

## TECHNICAL DATA SHEET

# S-WELD CLEAN

Code 1100

### *Stainless Steel Pickling Gel*

*Conforms to ASTM a380-06 Standard Practice for Cleaning, Descaling and Passivation of Stainless Steel Parts, Equipment, and Systems*

#### DESCRIPTION

S-Weld Clean utilises innovative Australian technology for the formulation of a high adhesion stainless steel pickling gel. It is used to remove the black oxide marks and heat tint left during welding of stainless steel. S-Weld Clean leaves a clean professional finished stainless-steel weld area. It is suitable for use on stainless steels, duplex steel and inconel alloys.

#### PHYSICAL PROPERTIES

Boiling Point	:	N/A
Specific Gravity	:	1.24 - 1.26
Water Solubility	:	Miscible
pH (as supplied)	:	<1.0
Appearance & Colour	:	Opaque, white acidic gel, pungent acidic odour

#### BENEFITS

- ✓ Quick acting
- ✓ One step treatment
- ✓ Comes complete with own acid resistant application brush
- ✓ Completely water rinse able
- ✓ Convenient size packs - no wastage
- ✓ Can be used on vertical and overhead surfaces

#### DIRECTIONS FOR USE

1. Clean the weld area carefully using a stainless-steel brush.
2. Roll or shake the drum of S-Weld Clean if possible for 30 seconds prior to opening the container to ensure a smooth consistency, especially if the product has not been used for a long time.
3. After welding, ensure the area to be pickled has sufficient time to cool below 40°C.
4. Apply the S-Weld Clean gel to the area to be pickled with the brush provided.  
**DO NOT PICKLE IN DIRECT SUNLIGHT.**
5. Application times may vary depending on ambient temperatures, the grade of stainless, surface finish or the method of welding. On a hot rolled surface the pickling time may increase by 50%. MIG welds may require longer pickling times than those obtained using covered electrodes. Allow the pickling gel or solution sufficient time to react with the surface. With high ambient temperatures or when longer pickling times are required, it may be necessary to repeat the process. Do not allow the pickling agent to dry on the surface. Should the product dry on the surface wash down, dry and repeat the process.



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**DO NOT OVER PICKLE – The best results are obtained by continuous visual inspection of the surface.**

Grade	Pickling Time	Temperature °C
200, 300, 400 Series	5 - 30 minutes	21 - 50
Duplex Grades	60 - 90 minutes	21 - 50
Super Duplex	80 - 120 minutes	21 - 50

S-Weld Clean can be used on Inconel 625. The Inconel has a very high resistance to corrosion so this means that the dwell time (time the product is left on the surface) will be longer than the dwell time when used on 300 Series stainless products. But the procedure is the same. The pickling times may vary from application to application the method is to conduct series of trials. Produce a small series of test plates using the methods and materials that will be used in normal fabrication. Apply the pickling gel, then conduct a range of visual inspection times starting at 40 minutes and continue and inspect by time period until the desired result has been achieved to set the benchmark for normal operations. Use a high-pressure water blaster to wash down, using clean potable water.

- To clean, rinse the surface with clean potable water. The best results are obtained by the use of high pressure water jet or similar. Ensure the pickle residues are not left on the surface. If the surface to be cleaned is in an environmentally sensitive area the bucket and rag method can be employed. Using a bucket of clean potable water wash and wipe surface down with wet clean rags. Repeat to ensure surface is clean and free of acids.

**Note:**

- Wear gloves and goggles; avoid spillage or splashes. Do not allow to come in contact with the body. If skin contact occurs, apply Calcium Gluconate gel.
- Avoid contact with eyes or breathing any vapour.
- Replace the lid on the container tightly and store upright in a cool dry area away from direct sunlight. Do not store or use below 5°C.
- S-Weld Clean has a recommended shelf life, in good storage conditions, of 2 years.

**PACKAGE SIZES**

S-Weld Clean comes in two convenient sizes 1kg and 2.5kg. Each pack comes with an acid resistant application brush.

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### SAFETY PRECAUTIONS

**Caution:** This product contains Hydrofluoric Acid and Nitric Acid and is corrosive and poisonous.

Wear appropriate clothing, i.e. rubber gloves, PVC apron/overalls, rubber boots, long sleeve shirt and full-face shield or clear goggles.

Do not use S-Weld Clean near open flames or cutting torches, since a hazardous flammable gas can be generated. Keep lid tightly closed when not in use. Store in a cool, dry spot away from direct sunlight.

Keep out of reach of children.

Refer to the Callington Haven S-Weld Clean Material Safety data sheet for further safety information. A copy of this sheet can be obtained on request from our office.

### OTHER CALLINGTON METAL TREATMENT PRODUCTS

S-Weld Passivator	-	Passivating gel
Steel Bright	-	Pickling solution
Albright	-	Aluminium brightener & cleaner
Alu-Weld	-	Aluminium weld scale cleaner
S-Weld Spatter Guard	-	Anti-spatter spray
Prosol	-	Non-toxic, biodegradable solvent degreaser, finger print cleaner
Metaprep No.1	-	Deoxidising solution and metal surface cleaner
S-Weld Neutraliser	-	Neutralising solution for acidic pickling paste
Cal-Guard	-	Non-toxic water based anti-spatter spray
Cal-Guard Nozzle Dip Gel	-	MIG nozzle cleaner and anti spatter agent
S-Weld Brite Wash	-	Stainless steel cleaner & corrosion remover

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