

TECHNICAL DATA SHEET

S-WELD PASSIVATOR GEL

Code 1130

Passivating Gel for Stainless Steel

Conforms to ASTM A967 Chemical Passivation Treatments for Stainless Steel Parts.

DESCRIPTION

S-Weld Passivator is a powerful oxidising gel for the passivation of stainless steel, duplex steel and inconel alloys. S-Weld Passivator can be used following pickling, grinding or mechanical polishing of stainless steel to ensure a passive surface is obtained prior to installation or commissioning of the final product.

PHYSICAL PROPERTIES

Boiling Point : N/A
 Specific Gravity : 1.20
 Water Solubility : miscible
 pH (as supplied) : < 1.0
 Appearance & Colour : Thick white translucent gel, mixes with water

BENEFITS

Gel consistency for ease of application
 Enhancement of chrome oxide corrosion resistant (passive) layer
 Dissolves any residual surface contamination
 Improved quality of fabricated product

DIRECTIONS FOR USE

1. Surface should be pre-cleaned to remove oils and greases before applying passivating agent. Use Callington S-Weld Brite Wash. Any contamination will shorten the life of the passivating gel.
2. Stir the gel to ensure a smooth consistency and apply S-Weld Passivator using the acid resistant brush provided.
3. Application Time

Grade of Stainless	Temperature 20 - 38° C	Temperature 50 - 70° C
200,300,400 Series	30 – 45 minutes	10 – 30 minutes
Duplex	30 – 45 minutes	10 – 30 minutes
Super Duplex	30 – 45 minutes	10 – 30 minutes
Inconel 625, 825	30 – 45 minutes	10 – 30 minutes



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DIRECTIONS FOR USE CONTINUED

4. Rinse thoroughly with clean potable water, dry surfaces to prevent water staining (smut). If a neutralizing agent has been used this must be followed by rinsing again with clean potable water and surfaces should be dried to prevent water staining.

Note:

1. Wear PVC gloves, goggles, overalls and safety boots. Wear a respirator if working in a confined or poorly ventilated area.
2. Avoid spillages and do not allow gel to come in contact with the body or eyes. Avoid breathing vapour.
3. If skin contact occurs, immediately flush body and/or clothes with water. Remove all contaminated clothing.
4. Replace the lid on the container tightly after use, and store upright in a cool dry area away from direct sunlight. Do not store or use below 5°C.
5. S-Weld Passivator has a recommended shelf life of twelve (12) months if stored as per above conditions (item 4).

PACKAGING

S-Weld Passivator is presented in a 2.5kg security cap plastic container, and each pack includes an acid resistant application brush.

SAFETY PRECAUTIONS

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

Wear appropriate chemical protective clothing, eye protection and breathing apparatus as necessary.

Do not use S-Weld Passivator near open flames or cutting torches, since hazardous flammable gas can be generated. Keep lid tightly closed when not in use, and out of reach of children or unauthorised users.

If using in a poorly ventilated area, use a respirator.

If you require to neutralise the acidic waste residue; this can be done using S-Weld Neutraliser neutralising solution. Add using S-Weld Neutraliser until the colour changes to a pale pink colour.

Refer to the Callington Haven S-Weld Passivator Material Safety Data Sheet for further safety information. A copy of the Material Safety Data Sheet can be obtained on request from our office.

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OTHER CALLINGTON METAL TREATMENT PRODUCTS

S-Weld Clean	- Pickling gel
Steelbright	- Pickling solution for spray & dip applications
S-Weld Neutraliser	- Neutralising solution for acidic waste
S-Weld Spatter Guard	- Non-toxic anti-spatter spray for stainless steel
Prosol	- Non-toxic, biodegradable, solvent degreaser
Cal-Guard	- All purpose anti-spatter spray
Metaprep No.1	- Deoxidising degreaser solution for stainless steel & aluminium
Alu-Weld	- Pre or post weld aluminium deoxidising gel cleaner
Albright	- Acidic aluminium detergent cleaner & brightener
S-Weld Brite Wash	- Stainless steel cleaner & corrosion remover

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