

FinishOne Passivator 630

The need for an extra Passivation of Stainless Steel.

An air-passivation of Stainless steels take place naturally on a clean surface. However in the presence of surface contamination, like free iron from contact with carbon steel tooling, this may interfere with the formation of the passive film. These contaminants has to be removed by using Passivator 630 to allow the oxygen uniform access to the surface in order to create the protective passive film. Further the air-passivation may take too much time in some aggressive environments, like close to the sea side. The passive film build up may need assistance of the Passivator 630 to speed up the formation.

A safer-to-use acid free Passivator!

Many of the processes used for passivation of stainless steel lead to the development of hazardous nitric fumes. We have developed a ONE Technology, to avoid this with a unique non fuming passivator which reduces the toxic nitric fumes by 100%.

Standard applications

The Passivator 630 restores stainless steel surfaces, after pickling or mechanical cleaning, that have been damaged during fabrication operations such as welding, forming, cutting and blasting. It removes free iron and speeds up the formation of the protective passive layer to prevent local corrosion.

Avesta FinishOne Passivator 630 passivates without nitric or citric acid. This Passivator is acid free and safe to use. The resulting rinse water is acid free and hence no need for and extra neutralization and waste treatment step The Passivator 630 is intended for spray passivation only. For immersion or circulation passivation we recommend the Avesta 601 Passivator

Features

- » ONE Technology, 100% NO_x-reduction, this prevents the workers from breathing dangerous acid fumes.
- » Higher yield, superior performances compared to nitric and citric acid passivation.
- » Acid free, creates no toxic waste to handle, no risk for nitrates in the rinse water. Easy to handle and to ship, classified as non dangerous goods.
- » Diminish the risk of discolored surfaces caused by flash clouds of free Iron (SMUT) when applied we-on-wet.
- » For reduction of Nitric fumes during pickling by spraying a mist over the pickled surcafe "vet on wet".



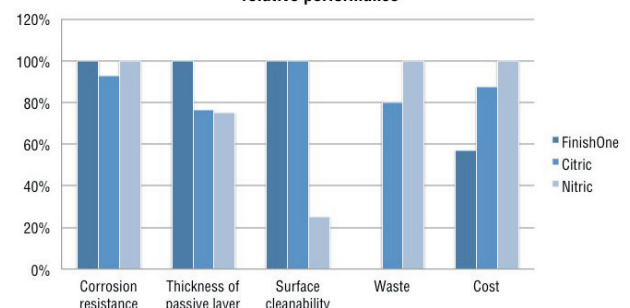
1000kg IBCs



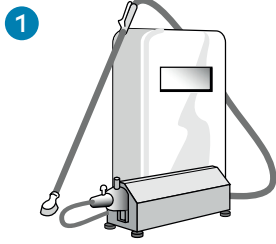
25 kg drums

Photos: Available in several packages
(Sizes may differ from markets)

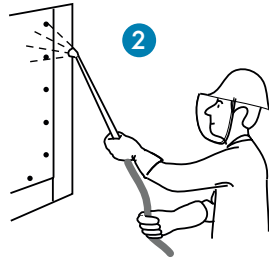
Comparing study between FinishOne, nitric acid and citric acid – relative performance



Instructions for use



1. Apply the Passivator 630 by spraying with a spray pump like Avesta SP 25 or with a brush.



2. The Passivator 630 can be used for different purposes:

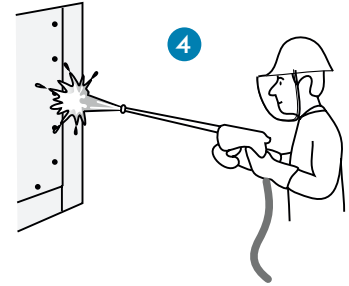
2.1. To passivate after pickling, and avoid SMUT formation after spray pickling, the 630 shall be applied while the surface is still wet, "wet on wet".

2.2. To passivate after mechanical treatment, first pre-clean the surface using Avesta Cleaner 401 give it 20 min. to react., rinse with water, then apply the Passivator 630. "wet on wet".

2.3. To reduce nitric fumes when pickling, spray on the pickling fluid as a "mist" "wet on wet".



3. Typical reaction time for each purposes and all stainless steel grades is 10-15 min. 20°C The pickling time may vary for the same



4. Rinse off the Passivator 630 residuals by using a high-pressure water jet. Use deionized water for the final rinsing of sensitive surfaces. The waste water do not need to be neutralized.

Packaging

Avesta FinishOne Passivator 630 is supplied in 25 kg and 1000 kg IBC polyethylene packages. Availability of different packages sizes may differ between markets.

Storage

Avesta FinishOne Passivator 630 should be stored indoors at room temperature. Containers must be kept properly closed, in an upright position and inaccessible to unauthorized persons. Keep the lid on at all times when not in use. Metals, alkaline, organic materials, heat and UV radiation will degrade the product. Store in a clean, cool and UV protected environment. Avoid contact with textiles.

Worker safety

Protective clothing. In general, users should wear acid-resistant overalls, gloves and rubber boots. Face visor should be used and, if necessary, suitable respiratory protective devices.

Special conditions may apply from one country to another. Consult our website where updated Safety Data Sheets can be found.

Maintenance Cleaning

For the cleaning of stainless steel objects in service which are suffering from surface rust / tea staining. The Avesta Cleaner 401 can be used together with Avesta FinishOne Passivator 630, they will remove the surface rust and then promote the regeneration of the protective layer in the stainless steel by speeding up the thickness of the passive layer.

Waste treatment

Empty containers (HDPE) must be cleaned and can then be recycled according to local regulations.

Other information

For more information, please visit our website:

www.voestalpine.com/welding, where you can find Safety Data Sheets and other useful information.



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