

## TECHNICAL DATA SHEET

# S-WELD PASSIVATOR GEL

Code 1130

Conforms to ASTM A380 and ASTM A967 Passivation Treatments



### DESCRIPTION

Callington S-Weld Passivator gel 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. Suitable for use within industrial, aerospace & food industries.

### FEATURES & 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 Times



Grade of Stainless Steel	Temperature 20 - 38°C	Temperature 40 - 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

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.

## TECHNICAL DATA SHEET

*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 in the vapours.
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).

### ORDERING INFORMATION

Product Code	Packaging	Units/Carton
1130/78	2.5	6 units

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

### PHYSICAL PROPERTIES

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

### 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.

### DANGER

May be corrosive to metals. Causes severe skin burns and eye damage.

## TECHNICAL DATA SHEET

### PRECAUTION

Do not breathe dust/fume/gas/mist/vapours/spray. Wear protective gloves/protective clothing/eye protection/face protection. Keep only in original container.

### FIRST AID

IF SWALLOWED: Rinse mouth. Do NOT induce vomiting. IF ON SKIN (or hair): Remove/Take off immediately all contaminated clothing. Rinse skin with water/shower. IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. Immediately call a POISON CENTER or doctor/physician. Wash contaminated clothing before reuse. Absorb spillage to prevent material damage. IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing.

### STORAGE & DISPOSAL

Store locked up. Dispose of contents/container in accordance with local regulations.

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