

TECHNICAL DATA SHEET

S-WELD CLEAN

Thickened Pickling Gel for Stainless Steel

Code 1100



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 scale burn marks and heat tint caused during welding on the stainless steel. S-Weld Clean leaves a clean professional finished look on the stainless-steel weld area. It is suitable for use on stainless steels, duplex steel and Inconel alloys.

FEATURES & BENEFITS

- Conforms to standard ASTM a380
- One step treatment for easy application
- Comes complete with an acid resistant application brush
- Completely water rinseable allowing no time loss for extra cleaning
- Can be used on vertical and overhead surfaces
- Controlled application which eliminates product wastage
- Removes black welding scale, discolouration and corrosion on stainless steel



DIRECTIONS FOR USE

1. Clean the weld area carefully using a stainless-steel brush.
2. Roll or shake the drum of S-Weld Clean, 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 steel, 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.

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

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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. 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. Although the procedure is the same. The pickling times may vary from application to application. The best method is to conduct a series of time 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 25 minutes and continue and inspect by time period until the desired result has been achieved to set the benchmark.

S-Weld Clean can be used on Monel materials but a trial pickling process should be conducted to access the best operating procedure and set the required dwell time. Surface dwell times vary between the different grades and composition of stainless materials. For Monel it is normally a shorter dwell time, but a trial should be conducted.

- To clean and rinse the surface use clean potable water. To get the best results, use a 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. **Bucket and rag method** – use a bucket of clean potable water. Wash and wipe the surface down with a wet clean rag, then with a dry clean rag. Repeat the process to ensure the surface is clean and free from acids.

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

ORDERING INFORMATION

Product Code	Packaging	Units/Carton
1100/30	1kg	12 units
1100/78	2.5kg	6 units
1100/51	23kg	Each

DANGER

May be corrosive to metals. Fatal if swallowed, or in contact with skin. Fatal if inhaled. Causes severe burns and eye damage.

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PRECAUTION

Highly Corrosive. Keep only in original container. Do not get in eyes, on skin, or on clothing. Do not eat, drink or smoke when using this product. Do not breathe dust, fume, gas, mist, vapours or spray. Wear protective gloves and clothing, eye and face protection. Use only outdoors or in a well-ventilated area. Obtain a supply of calcium gluconate gel.

FIRST AID: IF SWALLOWED: Immediately call a POISON CENTRE or doctor/physician. Rinse mouth and do NOT induce vomiting. IF ON SKIN (or hair): Remove/Take off immediately all contaminated clothing and gently wash skin with plenty of soap and water. Then apply Calcium Gluconate gel. IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing. IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses. if present and easy to do. Continue rinsing. Wash contaminated clothing before reuse and absorb spillage to prevent material damage.

STORAGE & DISPOSAL

Store in a well-ventilated place. Keep container tightly closed. Store locked up. Dispose of contents/container in accordance with local regulations.

WARRANTY – All statements, information and data presented herein are believed to be accurate and reliable but are not to be taken as a guarantee, expressed or implied, for which seller assumes legal responsibility and they are offered solely for your consideration, investigation and verification. Statements or suggestions concerning possible use of this product are made without representation or warranty that any such use is free of patent infringement and are not recommendations to infringe on any patent.

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