



# PICK

## PICKLING PASTE FOR STAINLESS STEELS

### For stripping stainless steels and acid-resistant steels

The stripping of welds on stainless steels and acid-resistant steels is necessary to restore the weldment's superior corrosion resistance and produce a brilliant and esthetic surface.

The welding operation causes a temperature rise that affects the stainless steels and the acid-resistant steels. An oxide layer forms on the heat-affected zones. This high temperature also weakens the weld zone through the formation of chromium carbides. This transformation of the heat-affected zone lowers the corrosion resistance of the steel, and a heat treatment is often required to recover these corrosion-resistance properties.

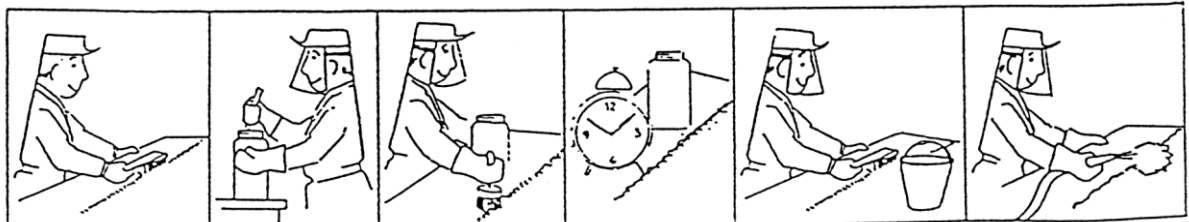
These properties may be recovered in stainless steel by using the Soudotec pickling paste. In less than one (1) hour, the Soudotec pickling paste strips the steel and completely removes the contaminated layer as well as the weakened chromium layer, leaving a clean metallic surface. Results vary according to the time/temperature ratio within a temperature range of + 5°C to + 50°C (41 - 122°F). The part must be maintained at room temperature when the Soudotec pickling paste is applied; the latter must never be applied at a temperature below + 5°C (41°F).

The Soudotec pickling paste contains hydrofluoric acid and nitric acid. These products are essential for the stripping and passivation action to take place. It also contains an homogenizing organic agent that guarantees the product's adherence in all positions. The Soudotec pickling paste contains neither hydrochloric acid nor chloride, thus eliminating the risk of corrosion when using this paste.

The Soudotec pickling paste is delivered in plastic containers specially designed for its transportation and storage. Two (2) kg of Soudotec pickling paste enables the treatment of 160 to 300 meters (530 - 985 feet) of welding beads.

The Soudotec Neutra.02 neutralizing paste is recommended as the most efficient neutralization product, since it converts the acid into lime nitrate and calcium fluoride, both of which are environmentally safe

#### Procedure



1 - Brush the weld

2 - Stir the paste

3 - Apply with a paint brush

4 - Wait 30-60 min.

5 - Brush the weld with a wet stainless steel brush

6 - Rinse with water

Rév. : 11\_10

*Specialized welding alloys and technology. For technical assistance or for ordering:*

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