

Avesta Classic Pickling Bath 302

For immersion and circulation pickling!

Avesta Classic Pickling Bath 302 is a concentrate that should be diluted with water depending on the stainless steel grade.

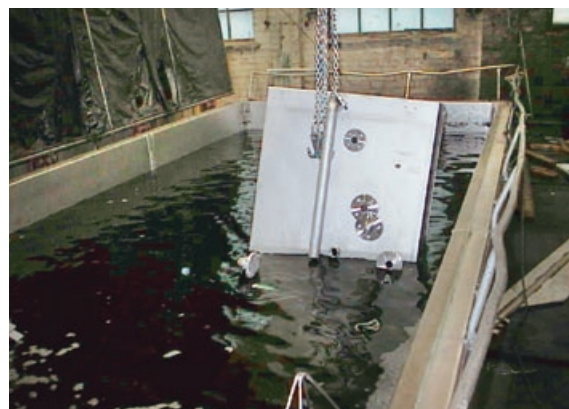
- Standard grades, such as 304 and 316: Mix 1 part 302 into 3 parts of water. A further dilution can be done if longer pickling times can be accepted.
- High alloyed grades, such as duplex grades (2205) and austenitic grades (904 L) for use in severe corrosive conditions: Mix 1 part of 302 into 2 parts of water.
- Very high alloyed grades, such as super-austenitic (254 SMO) and super-duplex (2507) grades: Mix 1 part of 302 into 1 part of water.

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- Restores stainless steel surfaces that have been damaged during fabrication operations such as welding, forming, cutting and blasting. It removes weld oxides, the underlying chromium-depleted layer and other defects that may cause local corrosion.
- The bath fluid is recommended for immersion pickling of small objects and for pickling surfaces that are time-consuming to brush or spray pickle. It can also be used for circulation cleaning of pipe systems.
- Working life; the bath fluid is consumed during usage and the effective working life of the bath fluid is determined by the amount of acids and free metals. The bath fluid should hence be analysed regularly and when needed new acid should be added in order to obtain an optimal pickling result. Avesta Finishing Chemicals may assist with this analysis service.

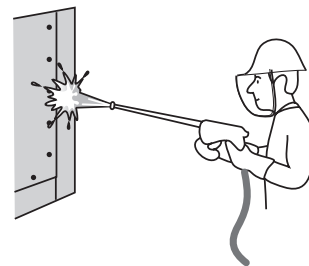
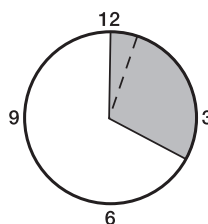
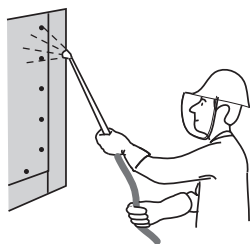
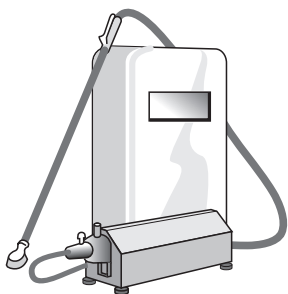


Avesta Classic Pickling Bath 302 – a concentrate ready to mix depending on which stainless steel grade you need to pickle.



Immersion of an object into a pickling bath yields the best pickling result.

Instructions for use



1. Mix the bath by adding the 302 to the water, not the other way round! The proportions depend on the steel to be pickled.
2. Pre-clean the objects from grease and oil before pickling by using Avesta Cleaner 401. Allow sufficient reaction; time 5 min. to 4 hours depending on temperature, steel grade, age of the bath etc.

3. Analyse the bath content of acids and free metals regularly to maintain optimal bath composition.
4. Rinse with high-pressure water jet after pickling.

Neutralisation and disposal

The waste water produced when pickling contains acids and should be treated with Avesta Neutralising Agent 502 or with slaked lime to a pH-value of 7–10 before discharge.

The neutralising agent also precipitates heavy metals, and the resultant sludge should be sent for deposition according to local regulations.

Passivation

To further improve the result and diminish the risk of discoloured surfaces caused by so-called flash clouds or smut, we recommend passivating after pickling using Avesta FinishOne™ Final Rinse 630 which offers the Best Available Technique when passivating.

Packaging

Avesta Classic Pickling Bath 302 is supplied in 30 kg, 220 kg and 1200 kg polyethylene drums/containers. These are UN-approved for hazardous goods.

Other information

For more information, please visit our website www.avestafinishing.com where you can find Material Safety Data Sheets and other useful information.

Storage

Avesta Classic Pickling Bath 302 should be stored indoors at room temperature. Containers must be kept properly closed, in an upright position and inaccessible to unauthorised persons.

The products are perishable and should not be kept in storage longer than necessary. They have a maximum shelf life of two years when stored at room temperature. Exposure to higher temperatures may reduce shelf life.

Worker safety

Hexafluorine® should be available when using the pickling bath. The 500 ml or 5 l content has been optimised to decontaminate larger acid-splashes of pickling bath.

Protective clothing. Users should wear acid-resistant overalls, gloves and rubber boots. Goggles or face visor should be used and, if necessary, suitable respiratory protective devices (chloride type filter).

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