

TECHNICAL DATA SHEET

S-WELD PASSIVATOR GEL

Code 1130

Passivating Gel for Stainless Steel

Conforms to ASTM A967 Chemical Passivation Treatments for Stainless Steel Parts.

DESCRIPTION

S-Weld Passivator 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.

PHYSICAL PROPERTIES

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

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 Time

Grade of Stainless	Temperature 20 - 38° C	Temperature 50 - 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

