

TECHNICAL DATA SHEET

S-WELD SPS SPRAY

Pickling Spray Solution

Code 1108



DESCRIPTION

Callington S-Weld SPS is a unique spray pickling solution that provides excellent working properties for the pickling of stainless steel. The unique red dye indicator allows the operator to know exactly where the product has been sprayed on the stainless surface, or if it has been washed down completely.



FEATURES & BENEFITS

- Conforms to ASTM a380-17
- Quick acting formulation
- One step treatment, no surface extra treatment
- Completely water rinsible
- Colour indicator – indicates if SPS has been sprayed onto surface or washed down
- Leaves no residual film after rinsing
- Very economical, excellent surface coverage compared to regular paste/gel pickling products

DIRECTIONS FOR USE

1. Ensure welded surface has had enough time to cool below 40°C.
2. Pre-clean surface to remove any possible contaminants of grease and oil. This can be achieved by using Callington S-Weld Brite Wash Acidic Detergent.
3. Stir or mix solution, then spray onto surface ensuring that coverage has an even coat all over.
FOR BEST RESULTS, DO NOT SPRAY IN DIRECT SUNLIGHT.
4. Application times may vary depending on ambient temperatures and the grade of stainless steel surface finishes or the type of welding method used. 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 enough time to react with the surface. With high ambient temperature requires for longer pickling times. 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.

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

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 products. Inconel has a very high resistance to corrosion so 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 method is to conduct series of 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 40 minutes and continue and inspect by period until the desired result has been achieved to set the benchmark for normal operations. Use a high-pressure water blaster to wash down, using clean potable water.

- To clean, rinse the surface with clean potable water. To obtain 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. Using a bucket of clean potable water wash and wipe the surface down with wet clean rag. Repeat to ensure surface is clean and free of acids.

Note:

- Wear gloves and goggles; avoid spillage or splashes. Do not allow in contact with the body. IF skin contact occurs, wash off immediately and apply Calcium Gluconate gel.
- Avoid contact with eyes or breathing any vapours.
- Replace the lid on container tightly and store upright in a cool dry area away from direct sunlight. Do not store or use below 5°C.
- S-Weld SPS has a recommended shelf life, in good storage conditions of 2 years.

PHYSICAL PROPERTIES

Boiling Point: N/A
 Specific Gravity: 1.30 +/- 0.01\
 Water Solubility: Miscible
 pH (as supplied): <1.0
 State: Liquid
 Appearance & Colour: Red Colour

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ORDERING INFORMATION

Product Code	Packaging	Units/Carton
1108/45	10 litres	Each

DANGER

Fatal if swallowed. Fatal in contact with skin. Fatal if inhaled. Causes severe skin burns and eye damage.

PRECAUTION

Do not breathe dust/fume/gas/mist/vapours/spray. Do not get in eyes, on skin, or on clothing. Do not eat, drink or smoke when using this product. Use only outdoors or in a well-ventilated area. Wear protective gloves/protective clothing/eye protection/face protection. Wear respiratory protection.

FIRST AID

IF SWALLOWED: Immediately call a POISON CENTER or doctor/physician. Rinse mouth. Do NOT induce vomiting. IF ON SKIN (or hair): Remove/Take off immediately all contaminated clothing. Rinse skin with water/shower. Wash with plenty of soap and water. Absorb spillage to prevent material damage. 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.

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.

Created 25 September 2019 Date Printed 20/05/2021 1:18 PM