

TECHNICAL DATA SHEET

S-Weld PassGel-N

Conforms to ASTM A380 and ASTM A967 Passivation Treatments

Code 1132



DESCRIPTION

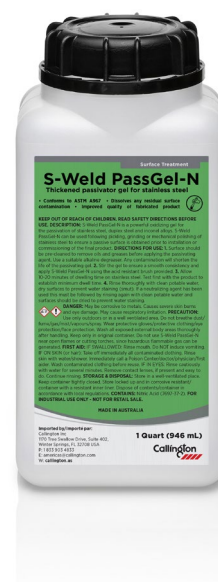
Callington S-Weld PassGel-N is a powerful oxidising gel for the passivation of stainless steel, duplex steel and Inconel alloys. S-Weld PassGel-N can be used following pickling, grinding or mechanical polishing of stainless steel to ensure a passive surface is obtained prior to installation or commissioning of the final product. Suitable for use within industrial, aerospace & food industries.

FEATURES & 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.
- Conforms to
 - ASTM A380 and ASTM A967 Passivation Treatments
 - Boeing Process Specification HP4-8

DIRECTIONS FOR USE

1. Surface should be pre-cleaned to remove oils and greases before applying the passivating agent. Use a suitable alkaline degreaser (contact your Callington Representative for suitable product). Any contamination will shorten the life of the passivating gel.
2. Stir the gel to ensure a smooth consistency and apply S-Weld PassGel-N using the acid resistant brush provided.
3. Test first with the product to establish minimum dwell time.



Grade of Stainless Steel	Temperature 20 – 38°C	Temperature 40 – 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

4. Rinse thoroughly with clean potable water, dry surfaces to prevent water staining (smut). If a neutralizing agent has been used this must be followed by rinsing again with clean potable water and surfaces should be dried to prevent water staining.

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Note:

1. Wear PVC gloves, goggles, overalls and safety boots. Wear a respirator if working in a confined or poorly ventilated area.
2. Avoid spillages and do not allow gel to come in contact with the body or eyes. Avoid breathing in the vapours.
3. If skin contact occurs, immediately flush body and/or clothes with water. Remove all contaminated clothing.
4. Replace the lid on the container tightly after use, and store upright in a cool dry area away from direct sunlight. Do not store or use below 5°C.
5. S-Weld PassGel-N has a recommended shelf life of twelve (12) months if stored as per above conditions (item 4).

ORDERING INFORMATION

Product Code	Packaging	Units/Carton
1132/32	1 quart	4 units

NB: S-Weld PassGel-N is presented as a 1 quart (946mL) security cap plastic container, and each bottle comes with an acid resistant application brush.

PHYSICAL PROPERTIES

Specific Gravity: 1.20
Water Solubility: Miscible
pH (as supplied): < 1.0
Appearance & Colour: Thick white translucent gel

SAFETY PRECAUTIONS

Caution: This product contains Nitric Acid and is corrosive and poisonous. Wear appropriate chemical protective clothing, eye protection and breathing apparatus as necessary.

Do not use S-Weld PassGel-N near open flames or cutting torches, since hazardous flammable gas can be generated. Keep lid tightly closed when not in use, and out of reach of children or unauthorised users.

If using in a poorly ventilated area, use a respirator. If you require to neutralise the acidic waste residue; this can be done using S-Weld Neutraliser neutralising solution. Add using S-Weld Neutraliser until the colour changes to a pale pink colour.

DANGER

May be corrosive to metals. Causes severe skin burns and eye damage. May cause respiratory irritation.

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PRECAUTION

Use only outdoors or in a well-ventilated area. Do not breathe dust/fume/gas/mist/vapours/spray. Wear protective gloves/protective clothing/eye protection/face protection. Wash all exposed external body areas thoroughly after handling. Keep only in original container. Do not use S-Weld PassGel-N near open flames or cutting torches, since hazardous flammable gas can be generated.

FIRST AID

FIRST AID: IF SWALLOWED: Rinse mouth. Do NOT induce vomiting. IF ON SKIN (or hair): Take off immediately all contaminated clothing. Rinse skin with water/shower. Immediately call a Poison Center/doctor/physician/first aider. Wash contaminated clothing before reuse. IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing.

STORAGE & DISPOSAL

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

CONTAINS: Nitric Acid (7697-37-2). FOR
INDUSTRIAL USE ONLY - NOT FOR RETAIL SALE.

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