

Duplex Pickling Spray 250

A unique, stronger and safer-to-use pickling spray

Range: Duplex and other high-alloyed stainless steel

AVESTA Duplex Pickling Spray 250 is tailor-made for spray pickling of larger surfaces of duplex and other high-alloyed stainless steel.

The pickling spray restores stainless steel surfaces that have been damaged during fabrication operations such as welding, forming, cutting, grinding and blasting. It removes weld oxides, the underlying chromium depleted layer and other defects that may cause local corrosion.

Features

- Excellent results on high-alloyed stainless steel
- Low consumption of pickling product/m²
- Color indicates the covered area
- Excellent pickling results at low ambient temperatures

Typical pickling parameters

Pickling product	AVESTA Duplex Pickling Spray 250		
Material (EN)	LDX 2101 (1.4162)	2205 (1.4462)	2507 (1.4410)
Weld	FCAW	FCAW	GMAW
Temperature	16-18 °C	16-18 °C	16-18 °C
Pickling time	60 min	100 min	150 min
Consumption	7 m ² /kg		
Package	1 jerrican @ 30 kg/ 1 pallet 12 jerricans		

It is recommended not to use the product in direct sunlight or at high temperatures, as this may dry out the product and reduce the effect. Please observe the hazard and safety advice on the jerrican label.

Passivation

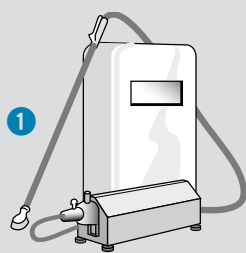
To further improve the result we recommend passivating after pickling using Avesta FinishOne Passivator 630, which is a safer acid-free passivation method.



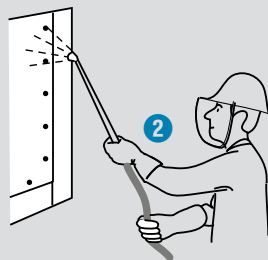
Avesta Duplex Pickling Spray 250 offers stronger and safer-to-use pickling.



Instructions for use



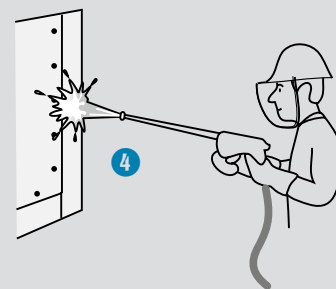
1. Pre-clean, remove oil and grease using Avesta Cleaner 401, and then rinse off with water.
2. Stir the solution before use. Apply the pickling spray with an acid-resistant pump, e.g. Avesta Membrane



Pump SP-25. Spray evenly over the whole surface.



3. Pickling time depends on steel grade, temperature, surface finish and the welding method used. See typical pickling parameters in table.



4. Remove pickling residues using a high-pressure water jet and then rinse with water. The waste water should be treated before discharge.

Packaging

Avesta Duplex Pickling Spray 250 is supplied in 30 kg polyethylene containers.

All packing material follows the UN regulations for hazardous goods.

Storage

Avesta Duplex Pickling Spray 250 should be stored indoors at room temperature. Containers must be kept properly closed, in an upright position and inaccessible to unauthorized persons.

The product is perishable and should not be kept in storage longer than necessary. The spray may decompose during storage and hence need to be stirred before usage. It has a maximum shelf life of two years when stored at room temperature. Exposure to higher temperatures (> 35 °C) may damage the product and reduce the shelf life.

Worker safety

Avesta First Aid Spray 910 (available only on some markets) or Hexafluorine® should be readily available to all who work with pickling to use as a first rinse to decontaminate small acid splashes of pickling spray, followed by Calcium Gluconate Gel or Solution to be used as a first aid to treat the HF acid burn.

Protective clothing. In general, users should wear acid-resistant overalls, gloves and rubber boots. Face visor should be used and, if necessary, suitable respiratory protective devices.

Special conditions may apply from one country to another. Consult our website where updated Safety Data Sheets can be found.

Waste treatment


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

Heavy metals from stainless steel are precipitated as a sludge, and should be sent for deposition according to local regulations.


Empty containers (HDPE) must be cleaned and can then be recycled according to local regulations.

Other information


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




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