

MISCELLANEOUS PRODUCTS

Description	Page No
ChromeBright (Pickling Paste)	210

CHROMEBRIGHT (PICKLING PASTE)

- ▲ For Removal of Weld Scale on Stainless Steel.
- ▲ Easy to Use One Step Treatment, Brush on then Rinse with Water 15-90 minutes Later.
- ▲ Thickened Paste Allows For Vertical Use.
- ▲ PALE Purple Coloured Paste for Easy I.D.

QUALITY STANDARDS:

Made in Australia under an approved Quality Assurance Management System to ISO 9002.

TYPICAL CHEMICAL ANALYSIS:

HF: $\leq 50\text{g/L}$ HNO_3 : $\leq 300\text{g/L}$
 CH_3COOH : $\leq 30\text{g/L}$
 H_2O and Others (dye, thickener etc): Remainder

Identification:

ChromeBright is supplied in a white plastic bottle, with a blue coloured label and lid. The 2.5kg plastic bottle is packed inside a blue and white printed cardboard carton which contains a quality acid resistant application brush.

Packaging Data:

Pack Weight/Type	Part No
2.5kg White Plastic Bottle	321918

Description and Applications:

All stainless steel welding processes usually give rise to a brown or black oxide film adjacent to the weld. The discolouration must be removed to restore the attractive appearance of the steel and a convenient method of doing this is to use ChromeBright Pickling Paste.

ChromeBright is a thickened pickling paste, pale purple in colour for use with all grades of stainless steel. ChromeBright is used to remove the black oxide marks or weld scale created during the welding and brazing of stainless steel.

ChromeBright is also used to clean rust stains, various oxide films and the discolouration of weathered stainless steels to ensure the steel maintains its bright appearance. When used correctly ChromeBright applied to the weld or surrounding area will produce a uniform and pleasing matt surface appearance.

Safety Precautions:

The pickling operation must take place outdoors or in a well ventilated area because during the pickling operation, there is a risk of gas emission (mainly nitrous gas) which is dangerous to inhale.

When working with ChromeBright pickling paste, individuals should be equipped with chemical resistant rubber gloves, rubber boots, rubber apron and a full face covering chemical resistant faceshield.

In cases where a closed vessel has to be pickled on the inside, it is essential that good ventilation be provided, and that operators wear respirators equipped with an ABE-AUS filter of the "acid gases" type. Neoprene and Natural Rubber gloves and aprons offer the best protection.

Bottles containing ChromeBright must be stored in an upright position and must always be carefully closed. The paste should be kept beyond the reach of children.

ChromeBright is very aggressive and must be handled with great caution. If an accident does occur and paste splashes onto the skin or into the eyes, the affected area must be immediately and continuously rinsed with large volumes of running water. Use Calcium Gluconate gel and or tablets as required. Seek immediate medical attention. Inform the doctor or medical attendant that the paste contains nitric and hydrofluoric acids.

Recommendations for Neutralising ChromeBright Residues:

As the active pickling paste components are nitric acid and hydrofluoric acid, the best neutralising agents are limestone or hydrated lime. While hydrated lime is the more efficient agent, it has the disadvantage of tending to block drains and pipes. The active acids combine with limestone to form nitrate of lime and calcium fluoride. Neutralising 1 kilogram of pickling paste requires approximately 0.5 kilogram of limestone.

CHROMEBRIGHT (PICKLING PASTE) CONT.

Procedure for Pickling:

1) Using a stainless steel wire brush, thoroughly clean the work piece of loose weld scale, welding slag and other foreign material.



4) Using the brush provided, apply a thin layer of ChromeBright to the work piece and all other areas to be cleaned.



5) The paste should be applied for between 15 – 90* minutes before removal.

2) Before opening the plastic bottle, shake for approximately 20 seconds to form a consistent gel paste.



6) Wearing protective clothing, rinse the pickled surface carefully with water, whilst using a hard nylon bristle brush, stainless steel wool or Scotch-Brite pads to remove all traces of weld scale.



3) Do not apply ChromeBright to the work piece until the surface is cool.

WARNING:

Local liquid trade waste requirements may require the pickling paste residue to be neutralised before disposal. See CIGWELD's recommendation for neutralising Chrome Bright residues.

Application Times:

Application time will depend upon the welding process and thickness of plate being welded. e.g.: Gas Tungsten Arc (GTAW,-TIG) and Gas Metal Arc (GMAW,-MIG) will require less time than Manual Metal Arc (MMAW,-Stick) welding. Likewise 10mm plate will require more time than 1.6mm plate. A bottle (2.5kg) of ChromeBright will pickle approximately 100 metres of weld depending on the thickness of the layer applied. For pickling sheets of stainless steel, using a thinner layer, approximately 15 square metres can be treated with one bottle of ChromeBright.

