

Features

Avesta pickling pastes and gels are used to remove welding oxides and the underlying chromium-depleted layer. The paste and the gel also remove micro-slag particles and other contaminants that may cause local corrosion. To assist pickling, this process may sometimes be combined with some form of simultaneous mechanical treatment, for example brushing.

After pickling, the workpiece should be thoroughly rinsed with tap water. The best results are achieved by using a high-pressure water jet. This operation instantly passivates the steel surface.

Avesta pickling paste and pickling gel follow the recommendations of ASTM A-380 A.1 and BS CP-312.

Products and applications

- **Avesta BlueOne Pickling Paste 130** is a new unique patented pickling paste that creates a better working environment. BlueOne makes it possible to pickle virtually without the toxic nitric fumes that are normally formed during pickling. BlueOne 130 is heat-stable and can be used in warmer climates. BlueOne 130 is a universal paste that can be used on all stainless steel grades.
- **Avesta Pickling Gel 122** is more free flowing than the paste to facilitate the application. The gel is also more heat-stable which makes it suitable for use in warmer climates.
- **Avesta Pickling Paste 101** is the original and only real paste on the market. It offers a perfect paste consistency that gives good adhesion to difficult surfaces and reduces the risk of splashing.

Characteristics

USAGE

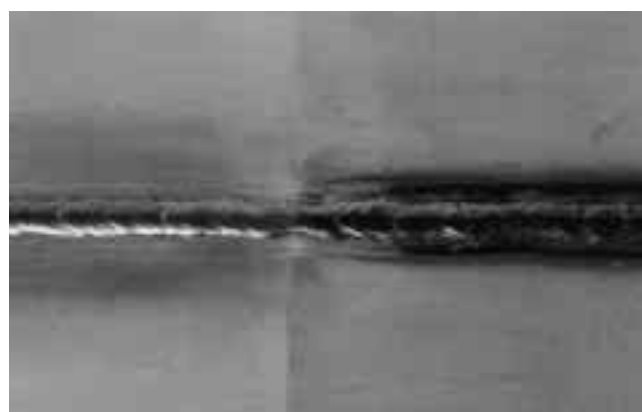
The paste/gel is recommended for the brush pickling of weld seams and smaller surfaces.

CONSISTENCY

The paste/gel has good adhesion even to vertical surfaces.

SHELF LIFE / HANDLING

The products have a shelf life of one year when stored properly. Exposure to high temperatures, such as in direct sunshine, should be avoided, as this may damage the product.



SAFETY

Avesta First Aid Spray 910 should be readily available when using the paste/gel to deal with acid splashes on the skin or in the eyes.

The formation of toxic nitric fumes can be reduced by 70 – 90% by using BlueOne Pickling Paste 130.



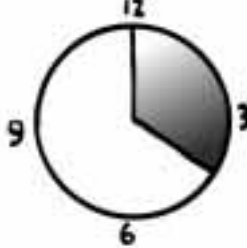

PICKLING TIME

The reaction time varies between 30 min and 4 hours depending on the stainless steel grade, temperature and contamination.

CHEMICAL PROPERTIES

Composition	Hydrofluoric acid (HF) Nitric acid (HNO ₃) Binder
Form	Paste/gel
Density	1.25 – 1.35 kg/l
pH	0
Flammable	No

Instructions for use

			
1. Stir or shake the paste/gel before use.	2. Apply the paste/gel with the brush supplied.	3. Leave the paste/gel to work 30 minutes to 4 hours (depending on temperature and steel grade). The temperature of the workpiece should always be higher than +10°C.	4. Remove pickling residues by using a high-pressure water jet or, with a stainless steel brush and then rinse with water. The waste water should be treated before discharge.

Neutralisation and disposal

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

The neutralising agent also precipitates heavy metals, and the resultant sludge should be sent for deposition according to local regulations.

Packaging

Avesta pickling paste and gel are supplied in 1.3 kg, 2.6 kg and 20 kg polyethylene containers. These are UN-approved for hazardous goods.

Other information

For further information, see also “Avesta Pickling Handbook”, “Avesta Guidelines for Planning and Designing a Pickling Workshop” as well as Material Safety Data Sheets (MSDS) for the products.

Storage

Avesta pickling paste and gel should be stored indoors at room temperature. Containers must be kept properly closed, in an upright position and inaccessible to unauthorised persons.

The products are perishable and should not be kept in storage longer than necessary. They have a maximum shelf life of one year when stored at room temperature. Exposure to higher temperatures may reduce shelf life.

Worker safety

Avesta First Aid Spray 910 should be readily accessible to all those who work with pickling. It comes in a handy 200 ml spray can and the content has been optimised to decontaminate small acid-splashes of pickling paste/gel.

Protective clothing. Users should wear acid resistant overall, gloves and rubber boots. Goggles or face visor should be used and, if necessary, suitable respiratory protective devices (chloride type filter).

Information given in this brochure may be subject to alteration without notice.

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