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ANTOX 71E Plus – Pickling Paste TECHNICAL DATA SHEET

Antox 71E Plus is a clear thixotropic paste used to remove weld burn and annealing colours from Stainless Steels after welding. It can also be used on Titanium, Nickel and their alloys. This product settles on the shelf and must be mixed well before use to ensure that the liquid and paste combine. Application is with pickling brushes of acid-resistant materials for repeated use or Antox disposable brushes of synthetic materials. A white “halo” mark may be left on the area pickled.

Application and Procedure

Before commencing work, read the material safety data sheets, observe all safety precautions and use the correct protective equipment. **STIR WELL BEFORE USE!**

1. For best results the area to be pickled must be clear of all grease & contaminants. We would recommend a solution similar to our *Mainclean* used either with a pressure wash spray or applied by hand from a spray bottle.
2. Generously paint *Antox 71E Plus* onto the area to be pickled. The reaction times for various metals are given below. The reaction time is dependent on the degree of weld burn, the ambient air and material temperatures. The optimal pickling temperature is around 18° - 22° C. Work routines should be avoided in direct sunlight due to the hazard of premature drying.
3. After the application time has elapsed neutralisation needs to be undertaken with *Antox NP* (see *Technical Data sheet on Antox NP*). This is placed directly onto the pickling paste and will start to bubble as it reacts. This not only stops the reaction, by neutralizes the acids present but prevents them from being washed elsewhere on the job where it may cause corrosion. It also gives a solution approx. pH7 which can be washed into the waste water system. The surface is then rinsed with water, using a high-pressure water jet appliance. The rinsing effect can be improved and enhanced by employing plastic or stainless steel wire brushes.
4. It is recommended that passivation using *Antox 90E* be carried out to encourage the rapid formation of the protective layer on the surface of the Stainless Steel. Although this will form naturally in air it can take anything up to 14 days for complete protection to occur. (See *Technical Data sheet on Antox 90E*).

Reaction Times

Rusty and acid-resistant steels, stainless steels	15 - 60 minutes
Nickel and nickel alloys	5 - 20 minutes
Titanium & Alloys	by trial only

1 kg of *Antox 71E Plus* is sufficient for 50 - 80 running meters approximately of weld seam with heated tinted area.

General Remarks - *Antox 71E Plus* contains no hydrochloric acid and no chloride.

Notes on hazards and suggestions for safety precautions

Antox 71E Plus contains hydrofluoric acid and nitric (azotic) acid. This is extremely toxic when inhaled or swallowed. If contact with the skin occurs, immediate application of *Calcium Gluconate gel* will stop the reaction and neutralise the acid burn.

Work routines should be carried out in a well-ventilated area. Store also in a well ventilated enclosure (the cans should be tightly closed). Breathing apparatus should be used when ventilation facilities are insufficient. Appropriate protective goggles; gloves and clothing should always be worn whilst working.

Thorough rinsing with water should treat any contact with the eyes and thereafter a doctor should be consulted. Contaminated and soaked protective clothing should be immediately changed. A doctor should be consulted if nausea is experienced (the doctor should be shown the notes on safety precautions, the product notes or the product label).

These products should not be accessible by children. The products are only intended for commercial and industrial use.

Disposal of Waste

Neither *Antox 71E Plus* nor the rinsing water may be disposed of in the public sewers in an untreated state. The waste water is acidic and contains alloy residue solids from the treated metal. Appropriate treatment should be carried out in a suitable neutralisation plant or disposal undertaken via a licensed waste disposal enterprise. All local waste water public sewerage regulations are to be observed.

Disclaimer

This issue replaces all previous issues. The information is provided to the best of our knowledge and conscience and conforms to the laboratory and field experience at the time of going to press. However, it must only be regarded as non-binding guidelines which have to be adapted to requirements. Since the use of our products lies beyond our control, we can only accept liability for the perfect standard quality at the time of delivery. Consequential losses will only be recognised if this was expressly agreed before use in writing, stating the warranted characteristics.