

# Avesta Pickling Spray 204

100% Stainless

## A powerful pickling spray for heavy-duty applications

Avesta Pickling Spray 204, is intended for heavy-duty applications and offers an aggressive spray pickling result for larger stainless steel surfaces.

## Standard applications

Avesta Pickling Spray 204 is intended for tougher applications such as heavy hot rolled plates, high-alloyed steels such as 904, duplex and SMO, thicker weld oxides and pickling at lower temperatures.

For non-heavy-duty applications we suggest the use of our low-fuming Avesta RedOne™ Pickling Spray 240 in order to improve safety when pickling.

## Features

- Restores stainless steel surfaces that have been damaged during fabrication operations such as welding, forming, cutting and blasting. It removes weld oxides, the underlying chromium-depleted layer and other defects that may cause local corrosion.
- Has a thixotropic consistency, which makes it stick well to the surface and hence facilitates the application even in difficult positions.
- The process is sensitive to strong sunlight/high temperatures and the spray may dry into the surface and be difficult to remove.

## Passivation

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

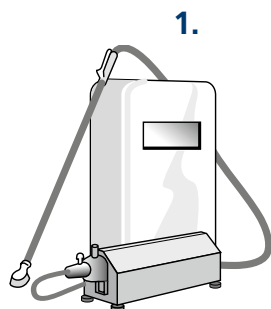


Avesta Pickling Spray 204 is a heavy-duty pickling spray.



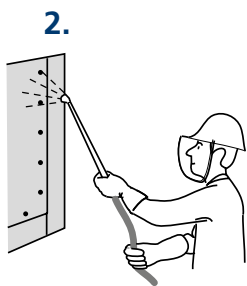
Avesta Pickling Spray 204 is intended for aggressive spray pickling.

## Instructions for use



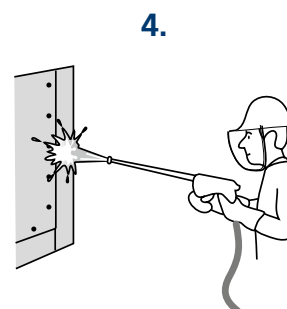
1. Pre-clean, remove oil and grease using Avesta Cleaner 401, and then rinse off with water. Apply the Cleaner with an acid-resistant pump, e.g. Avesta Membrane Pump SP-25.

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. Typical pickling time for steel grade 304 and 316 is 40 min at 20 °C and 30 min at 30 °C. The pickling time may vary for



the same steel grade, depending on the surface finish and the welding method.

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 Pickling Spray 204 is supplied in 30 kg and 220 kg polyethylene containers or 1200 kg IBC polyethylene containers.

All packing material follows the UN regulations for Hazardous goods.

## Storage

Avesta Pickling Spray 204 should be stored indoors at room temperature. Containers must be kept properly closed, in an upright position and inaccessible to unauthorised 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** 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 spray.

**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 the 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](http://www.avestafinishing.com) where you can find Safety Data Sheets and other useful information.

### Böhler Welding Group Nordic AB

Avesta Finishing Chemicals  
Lodgatan 14  
SE-211 24 Malmö, Sweden  
Tel: +46 (0)40 28 83 00  
Fax: +46 (0)40 93 94 24  
[www.avestafinishing.com](http://www.avestafinishing.com)



**Avesta**  
Finishing Chemicals