

**TECHNICAL DATA SHEET**

# S-Weld PassGel-N

**Code 1132**
**Conforms to ASTM A380 and ASTM A967 Passivation Treatments**

## DESCRIPTION

Callington S-Weld PassGel-N is a powerful oxidizing gel for the passivation of stainless steel, duplex steel, and Inconel alloys. S-Weld PassGel-N can be used following pickling, grinding or mechanical polishing of stainless steel to ensure a passive surface is obtained prior to installation or commissioning of the final product. Suitable for use within industrial, aerospace & food industries.

## FEATURES & BENEFITS

- Ideal for the enhancement of chrome oxide corrosion resistant (passive) layer of numerous materials including stainless steel, duplex steel, and Inconel alloys.
- Get consistency for ease of application on vertical and horizontal surfaces, and spot passivation.
- Designed for in-field application reducing the need for equipment disassembly prior to the passivation process.
- Fluorine-free allowing use in applications where fluorine's are prohibited.
- Removes free iron and dissolves any residual surface contamination.
- Improved quality of fabricated product.
- Conforms to:
  - ASTM A380 and ASTM A967 Passivation Treatments
  - Boeing Process Specification HP4-8



## DIRECTIONS FOR USE

1. Surface should be pre-cleaned to remove oils and greases before applying passivating agent. Use a suitable alkaline degreaser (contact your Callington Representative for suitable product). Any contamination will shorten the life of the passivating gel.
2. Stir the gel to ensure a smooth consistency and apply S-Weld PassGel-N using the acid resistant brush provided.
3. Test first with the product to establish minimum dwell time.

Grade of Stainless Steel	Temperature 20 – 38°C (68 – 100.4°F)	Temperature 40 – 70°C (104 – 158°F)
200, 300, 400 Series	30 – 45 minutes	10 – 30 minutes
Duplex	30 – 45 minutes	10 – 30 minutes
Super Duplex	30 – 45 minutes	10 – 30 minutes
Inconel 625, 825	30 – 45 minutes	10 – 30 minutes

4. Rinse thoroughly with clean potable water, dry surfaces to prevent water staining (smut). If a neutralizing agent has been used this must be followed by rinsing again with clean potable water and surfaces should be dried to prevent water staining.

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### Note:

- Wear PVC gloves, goggles, overalls, and safety boots. Wear a respirator if working in a confined or poorly ventilated area.
- Avoid spillages and do not allow gel to come in contact with the body or eyes. Avoid breathing in the vapors.
- If skin contact occurs, immediately flush body and/or clothes with water. Remove all contaminated clothing.
- Replace the lid on the container tightly after use, and store upright in a cool dry area away from direct sunlight. Do not store or use below 5°C.

### ORDERING INFORMATION

Code	Product Description	Packaging	Units per Case
1132/32/AMS	S-Weld PassGel-N	1 Quart	4

S-WELD Passivator is presented as a 1 Quart (946 mL) security cap plastic container, and each bottle comes with an acid resistant application brush.

### PHYSICAL PROPERTIES

Specific Gravity: 1.20

Appearance: Thick white translucent gel

Solubility: Miscible

pH: < 1.0

Shelf-Life: 24 months if stored appropriately.

### DANGER

Causes severe skin burns and eye damage. May be corrosive to metals. May cause respiratory irritation.

### PRECAUTION

Use only outdoors or in a well-ventilated area. Do not breathe dust/fume/gas/mist/vapours/spray. Wear protective gloves/protective clothing/eye protection/face protection. Wash all exposed external body areas thoroughly after handling. Keep only in original container. Do not use S-Weld PassGel-N near open flames or cutting torches, since hazardous flammable gas can be generated.

### SAFETY PRECAUTIONS

**Caution:** This product contains Nitric Acid (7697-37-2) and is corrosive and poisonous. Wear appropriate chemical protective clothing, eye protection and breathing apparatus as necessary. Keep out of reach of children or unauthorized users. If using in a poorly ventilated area, use a respirator.

### FIRST AID

IF SWALLOWED: Rinse mouth. Do NOT induce vomiting. IF ON SKIN (or hair): Take off immediately all contaminated clothing. Rinse skin with water/shower. Immediately call a Poison Center/doctor/physician/first aider. Wash contaminated clothing before reuse. IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing.

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### STORAGE & DISPOSAL

Store in a well-ventilated place. Keep container tightly closed. Store locked up and in corrosive resistant container with a resistant inner liner. Dispose of contents / container to authorized hazardous waste collection point in accordance with any local regulation.

INDUSTRIAL USE ONLY – NOT FOR RETAIL SALE

**WARRANTY** – All statements, information and data presented herein are believed to be accurate and reliable but are not to be taken as a guarantee, expressed or implied, for which seller assumes legal responsibility and they are offered solely for your consideration, investigation, and verification. Statements or suggestions concerning possible use of this product are made without representation or warranty that any such use is free of patent infringement and are not recommendations to infringe on any patent. 4 June 2024 Date Printed 24/07/2024 12:25 PM

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