



WETOXWELD (NON TOXIC)

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WINKEL WETOXWELD is a gel product properly formulated for the pickling of austenitic stainless steels with a low sulfur content.

In particular, it is suitable for the removal of welding, annealing oxides and rust.

In order to achieve a uniform treatment it is advisable to degrease and decontaminate the surface before pickling

(Certification ASTM380, ASTM B117, ASTM967)

HOW TO USE

WINKEL WETOXWELD should be used as it is. Mix the product to bring it back to its homogeneity, using a plastic or a stainless steel rod, never of iron. Apply on surface by an acid-resistant brush free from metallic parts and wait until the product reacts (it turns to pale green colour). Do not apply the product on hot surface ($> 35\text{ }^{\circ}\text{C}$). The time for a good pickling varies from 10 minutes to more than 2 hours depending on the type of welding, the material to be treated and on the temperature.

Type of welding	Reaction time (min)
TIG	10-45
MIG	>60
ELECTRODE	>120

Once the reaction time has elapsed, wash thoroughly with cold and clean water if possible under pressure. The washing water must be tap and must not contain iron and chloride ions in concentration higher than 70 mg / l (conductivity $\chi < 450\text{ }\mu\text{S}$).

AFTER Pickling you should proceed with the passivation of the surface in order to increase the corrosion resistance.

IMPORTANT NOTICE: This information is presented to assist the user in determining whether our products are suitable for his intended application and user assumes all risks and liability whatsoever in connection therewith. No warranty or representation express or implied, shall apply to these products. Seller's only obligation shall be to replace quantity of this product which has proven to not substantially comply with the data presented Manufacturer's latest bulletin. Seller shall not be liable for any property loss or damage, direct or consequential, arising out of the use of or the inability to use the product. No protection from any law or patent is to be inferred and all patent rights are reserved. See Material Safety Data Sheet.

Which steels can be treated (the table below is indicative. It is advisable to test the product on a small portion of surface before applying it to the whole surface):

Martensitic and precipitation hardening	630 17-4PH, 63117-7PH
Austenitic 300 series	All, with the exception of AISI 303 and all alloys with sulfur content $S > 0.020$ to which particular attention must be paid.
Austenitic 200 series	201, 202, 204 Cu, 205
Austenitic special grade	Not suitable
Ferritic	Not suitable
Ferritic special grades	444, 446, 460, 470, Cronifer 2803

Avvertenze particolari:

Before using the product, read carefully the safety data sheet (Rif. n°747). The operator should wear the required PPE as reported in Sec. 8 of the MSDS.

Do not use the product at direct sunlight and on hot surfaces ($> 35\text{ }^{\circ}\text{C}$). Do not leave the product at direct sunlight and near heat sources.

WINKEL WETOXWELD is a pickling product and it may dull the glossy or matt finish.

Any emissions, the rinsing water and the product must be treated according to current legislation.

Date of expiry (in sealed properly stored vessel): 2 years