

Bish's

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Fabrication

Metal Processing

Welding

Manufacturing

Acid Cleaning & Passivation Procedures

(Updated: 8/17/15)

Purpose:

1. To remove discoloration due to welding and additional surface contaminations due to the fabrication process.
2. Enhance corrosion resistance.

Safety Procedure:

1. Work in well ventilated area (preferably outside).
2. Wear appropriate safety equipment, such as:
 - a. Splash protective coveralls
 - b. Rubber gloves
 - c. Face shield / Safety glasses
 - d. Respirator Mask

Application Procedure:

1. Setup parts for cleaning in well ventilated area where there is access for turning parts with the appropriate lifting device for the parts being cleaned.
2. Obtain appropriate cleaning acid from storage cleaning cabinet.
 - a. Acid to be Hy-ko Brightener or passivation paste depending on customer's specification.
3. Apply acid to weld joints and surface areas of stainless steel.
4. Let acid sit for 10-20 minutes.
5. Scrub weld areas with scrub pad (do not use anything to scrub with that contains iron or has been contaminated by iron).
6. Rinse parts thoroughly with water until acid is removed.
7. Repeat cleaning if necessary.
8. Once parts are clean, move parts to a safe area to dry where they will not come in contact with contaminants.
9. Clean work area and return acid to storage cabinet.