

Manufacturers of high purity equipment

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## STANDARD PROCEDURE FOR PICKLING OF STAINLESS STEEL & HASTELLOY COMPONENTS

### SCOPE

This procedure details the method for pickling components prior to electropolishing and/or passivation.

### METHOD

1. On initial inspection examine all surfaces, checking for scratches or damage. If damage is evident, please contact the customer immediately.
2. Remove any adherent material, marker pen etc with suitable solvent ie. Acetone
3. If required, immerse in a solution of "Cleaner C" at ambient temperature for a suitable time period that will allow removal of grease, dirt etc.
4. Wash with cold high pressure (150 bar) water to remove loosened soiling.
5. If necessary, immerse in a pickling solution at a suitable temperature to remove weld staining/ferrite impurities for the required time.
6. Remove from pickling solution and inspect surfaces to ensure customer standards have been achieved. Repeat steps 5 and 6 if necessary.
7. Rinse free of pickling solution.
8. If no further steps are required, final rinse with de ionised water if necessary, dry thoroughly and inspect product to ensure customer standards have been achieved.
9. Package in accordance with customer specifications suitable for delivery. If possible, please return or recycle any packaging materials used.

### Notes:

The usage of PPE is mandatory (Rubber Boots, Rubber Gloves, Rubber Apron, Eye Protection) and work staff are to have a complete knowledge of acids being used and the actions to take in case of an emergency. Operators need to avoid contact of acids with skin or eyes and avoid breathing mists.

All operators working outside core hours should be left with clear instructions regarding the product they are processing and should also be supervised by a staff member who is competent with inspection duties.

Cleaner C is Phosphoric Acid/Detergent/Surfactant based.

Pickle solution is 1-10% Hydrofluoric Acid (60% Strength)/10-30% Nitric Acid (60-70% Strength)/Water.

This procedure is compliant with ASTM A380