



SWHTR® – EnviroPaste

STAINLESS WELD HEAT TINT REMOVER

2-in-1 Pickling & Passivation – Free of Hydrofluoric Acid (HF)

PRODUCT DESCRIPTION

SWHTR® EnviroPaste (Stainless Weld Heat Tint Remover – PASTE formula) is a high-performance, patented, 2-in-1 product that pickles and promotes passivation for all grades of stainless steel. In 1 step, it quickly and effectively removes heat tint discoloration and free-iron contamination from stainless steel surfaces. Unlike traditional, toxic products, **SWHTR® EnviroPaste** is biodegradable and uses “*Smart Chemical Technology*” that is **FREE of hydrofluoric acid (HF)** and encourages homogenous passivation when applied.

SWHTR® EnviroPaste is fume-free and easily applied by either a caulking tube, by brush or by specialty sprayer depending on the surface area to be treated. It is safe to be used on surfaces for extended / long-term dwell times without pitting, discoloring, corroding or damaging the healthy metal. As a non-dangerous goods product, it is easy to ship and store.

This advanced, water-based paste is the only non-toxic chemical pickling product commercially available. **SWHTR® EnviroPaste** replaces dangerous hydrofluoric acid and nitric acid-based products, many of which are banned or becoming highly regulated. It also eliminates the need for mechanical methods which can release dangerous hexavalent chrome particles into the air. **SWHTR® EnviroPaste** complies with the highest levels of regulation and improves health and safety conditions onsite. It is the only known pickling product available in a caulking tube and the only one that can safely be sprayed on large areas.

SWHTR® EnviroPaste is the best choice to ensure safe and effective pickling and proper passivation every time to improve weld zone corrosion resistance and avoid in-service weld zone failures. **It comes ready to use and complies with ASTM A380 “Standard Practice for Cleaning, Descaling and Passivating of Stainless Steel Parts, Equipment, and Systems”**

FEATURES & BENEFITS

- ✓ High-performance, 2-in-1 pickling and passivation – on all grades of stainless steel.
- ✓ Removes heat tint discoloration & free-iron contamination
- ✓ Free of Hydrofluoric acid (HF)!
- ✓ Only known pickling product that can be sprayed & is available in a caulking tube.
- ✓ Water-based & fully-biodegradable
- ✓ Non-toxic, non-poisonous, non-hazardous
- ✓ No VOC's, no HAPS, no TAPS
- ✓ As fast and effective as traditional, dangerous methods
- ✓ Easy to spread for application on surfaces.

- ✓ Extended dwell times will not damage healthy metal.
- ✓ Best choice for health and safety - reduces liability.
- ✓ Non-dangerous goods product – easy to ship and store.

SWHTR® (Stainless Steel Heat Tint Remover) is available in two formulas (paste & liquid).

SWHTR® EnviroPaste (Paste) in 305mL (10 oz) Caulking Tube or 1 and 5 gallon pails. It is applied using the caulking tube, or by brush or spray application – depending on quantity and project area. It is used for in-situ application on vertical, horizontal, overhead and large surface area applications.

SWHTR® (Liquid) is only used in large dip tanks for immersion applications and for system flushing applications. **SWHTR® (Liquid)** is **RECHARGABLE** and can be used multiple times. It is an ideal replacement for traditional acid baths and acid washes. Please refer to separate TDS for use and application instructions.

FOR USE ON

SWHTR® EnviroPaste is safe and effective on all grades of stainless steel.

- Austenitic Stainless Steel
- Inconel™ Alloys
- Monel™ Alloys
- Hastelloy™ Alloys
- Duplex Stainless Steel
- Super-Duplex Stainless Steel

It can be brushed or sprayed on indoor/outdoor, vertical/horizontal/overhead and large surfaces areas. It can also be a controlled application using a caulking tube.

COVERAGE

SWHTR® EnviroPaste comes ready to use. DO NOT DILUTE. PROTECT FROM TEMPERATURE EXTREMES. Do not allow it to freeze. Do not allow it to sit in direct sun or heat.

SWHTR® EnviroPaste 35-45 Lineal feet / 305mL (10oz) tube
(305mL / 10oz Caulking Tube)

SWHTR® EnviroPaste Brush-on Application: 60-80 lineal feet / liter (.25 gallon)
(In Pails) Brush-on Application: 80 square feet / 1 US gallon

Product will require mixing prior to use. Use a plastic or clean, rust-free drill mixer (wash after use).

Apply at least a 1-2 inch band of product that liberally covers the entire underlying weld seam and any discoloration.

SWHTR® EnviroPaste Spray-on Application: 80-100 square feet / 1 US gallon
(Required sprayer specs below)

SPRAYER SPECIFICATIONS

2 Quart Stainless Steel Pressure Pot Sprayer with regulator of up to 50psi.
Recommended 68SS x 68PB Nozzle Setup

PERSONAL PROTECTIVE EQUIPMENT (PPE)

In well vented areas, brushing or spraying, properly fitted splash goggles and nitrile (chemical resistant) gloves are recommended and should be used at all times when using this product.

A face shield can also be used as added protection. If you are working in a poorly ventilated area, a respirator is required using either a half mask with acid vapor cartridges and splash proof goggles and/or a face shield or a full face respirator. Wear proper clothing to avoid any direct contact to skin such as long sleeves or coveralls.

Refer to Health & Safety Section (below) and SDS for additional instructions.

SITE CONDITIONS

Use and store product at temperatures between 50-77°F (10-25°C); never in direct sun. Protect areas that are not to be treated from overspray and dripping. Protect treated areas from contact or contamination by traffic and/or environmental factors (i.e. rain). Good ventilation should be provided in confined areas.

SURFACE PREPARATION & CLEANING

First, preclean cool surfaces to remove all oils, grease, dirt and other contaminants, using Protocol's **DEEP CLEAN XTREME** or other alkaline cleaner according to ASTM A380 Standard for Descaling, Pickling and Passivation of Stainless Steel. This is imperative when using an oil-based anti-spatter product in welding operations.

Surfaces should be smooth and free of weld spatter, loose debris and any liquid or moisture.

APPLICATION

SWHTR® EnviroPaste arrives ready to use and **MUST NOT BE DILUTED WITH WATER** or MIXED WITH OTHER PRODUCTS. Testing in a small area is suggested to determine exact dwell time.

The caulking tube should be shaken prior to use to avoid product settling. After shaking, apply directly from the caulking tube to the area to be treated.

When using from a pail, **the product will require stirring prior to use. Use a plastic or rust-free, clean drill mixer (wash after use).** Do not dilute. Let hot, newly welded surfaces cool completely before application.

When applying by synthetic brush, apply a liberal amount of **SWHTR® EnviroPaste** directly on the treatment area. Ensure complete coverage of .078" - .120" (2mm-3mm) thickness with at least a 1-2 inch (25mm – 50mm) band of product that covers the underlying weld seam and any adjacent discoloration. Once applied, **DO NOT** agitate or interfere with the working product.

When applying by pressure pot sprayer, ensure complete coverage similar to recommendations for brush-on application. Cover the weld seams, adjacent discoloration and surfaces requiring rust (bloom or imbedded) removal. Protect areas not to be treated from overspray. Once applied, DO NOT agitate or interfere with. It is important to apply the proper thickness of **SWHTR® EnviroPaste** to ensure effective surface results. However, too thick an application may result in the product slipping or moving on vertical or sloped surfaces resulting in an incomplete treatment of affected areas.

SWHTR® Liquid is designed for dip / immersion tanks ONLY. It is not designed for spray application as it will not cling to the surface. Refer to the separate **SWHTR® Liquid** TDS for use.

DWELL TIME

Always perform a test patch to determine adequate dwell time.

Normal working dwell time (in temperatures above freezing) is between 45 and 90 minutes. Dwell time will vary slightly based on the amount of heat tint discoloration on the surface. Warmer temperatures will increase working speed and decrease dwell time.

SWHTR® EnviroPaste can be left on stainless steel as long as is needed – overnight or until removal is convenient – without fear of pitting, corrosion or thinning of the weld or base metal that could result in premature failure in the field.

REMOVAL

SWHTR® EnviroPaste is removed by wiping with wet cloth, washing, or pressure washing. NEVER USE METAL or WIRE BRUSH FOR REMOVAL as cross contamination to pickled area can occur.

Product and wash water is fully biodegradable. Wash away according to local water regulations.

HANDLING & DISPOSAL

SWHTR® EnviroPaste does not require any special handling. The product itself is biodegradable, however once applied, the product will naturally be contaminated with metal ions so disposal should always be approached with a knowledge of local regulations to ensure compliance with any and all rules for your area.

STORAGE

SWHTR® EnviroPaste requires no specialty storage or handling. Store in well-sealed containers to prevent spillage and contamination. Store and transport between 50-77°F (10-25°C); never in direct sun. Do not allow it to freeze. DO NOT DILUTE.

HEALTH & SAFETY

Avoid eye contact – it is mandatory to always wear appropriate chemical resistant eye protection. Splash proof goggles are recommended.

Avoid skin contact – wear appropriate clothing to avoid direct contact with skin. Nitrile (chemical resistant) gloves for hands, coveralls or comparable clothing for body and site appropriate footwear. If the product comes in contact with skin, wash the area thoroughly with water.

Use in areas with adequate ventilation. If the area has poor ventilation, proper air flow must be added. If the area is a confined space, follow all confined space rules and regulations as well as use the mandatory proper PPE.

Do not swallow, inhale, or ingest. If ingestion occurs, seek medical advice if you feel unwell. Do not eat, drink or smoke when using this product. Refer to SDS for additional information.

PHYSICAL PROPERTIES

SWHTR® EnviroPaste		
Color:	Off White	
pH:	Acidic	
Odor:	Slight	
VOC's:	None	
Flammability:	Not Flammable	
Solubility in Water:	Miscible	
Viscosity:	140 000 CPS	
Application Temperature	10°C-32°C (50°F-90°F)	

DISCLAIMER:

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