



## 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-based products. It also eliminates the need for mechanical methods which can release dangerous chrome particles into the air. **SWHTR® EnviroPaste** complies with the highest levels of regulation and improves health and safety conditions onsite.

Because **SWHTR® EnviroPaste** contains NO hydrofluoric acid in the formula and is regulated as non-toxic; it is the ONLY known product that can be applied safely by spray application. This provides the user with a significant advantage due to greatly improved efficiency on large projects. Additionally, the availability of the product in a caulking tube means easy portability and onsite use.

**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
- ✓ **NO** Hydrofluoric acid (HF) in the formula!
- ✓ Only known pickling product that can be sprayed
- ✓ Available in a caulking tube for easy portability and use
- ✓ Available in a COLD WEATHER formula for applications up to -40° Celsius / Fahrenheit

- ✓ 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.
- ✓ Safer product to work with. Reduces liability due to health & safety issues.
- ✓ Non-dangerous goods product – easy to ship and store.

**SWHTR**<sup>®</sup> (Stainless Steel Heat Tint Remover) is available in two formulas (paste & liquid).

**SWHTR**<sup>®</sup> **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**<sup>®</sup> **(Liquid)** is for dipping, immersion tanks and system flushing applications. **SWHTR**<sup>®</sup> **(Liquid)** is **RECHARGABLE** and can be used multiple times. It is an ideal replacement for traditional, toxic dipping solutions. Please refer to separate TDS for use and application instructions.

#### FOR USE ON

**SWHTR**<sup>®</sup> **EnviroPaste** is safe and effective on all grades of stainless steel.

- Austenitic Stainless Steel
- Inconel<sup>™</sup> Alloys
- Monel<sup>™</sup> Alloys
- Hastelloy<sup>™</sup> 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**<sup>®</sup> **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**<sup>®</sup> **EnviroPaste**                      35-45 Lineal feet / 305mL (10oz) tube  
(305mL / 10oz Caulking Tube)

**SWHTR**<sup>®</sup> **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 between 41-104°F (5-40°C), using caution when applying to hot metal surfaces. Store product at temperatures between 41-86°F (5-30°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 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 mixing 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 silicone 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 heavy metals 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 41-104°F (5-40°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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