



HIGH INTEGRITY METAL PICKLING
& CHEMICAL CLEANING SPECIALISTS

METAPIC LIMITED

BRIMINGTON ROAD NORTH, WHITTINGTON MOOR, CHESTERFIELD S41 9BG

OFFICE & WORKS: TELEPHONE (01246) 451710

Fax: (01246) 455999

E-mail: sales@metapic.co.uk

WEB: www.metapic.co.uk

MET 012 Issue 5
October 2015

PROCEDURE FOR PICKLING AND PASSIVATING OF AUSTENITIC STAINLESS FABRICATIONS AND PIPEWORK

Item No.	Operation	Bath	Concentration	Time	Temperature	Inspection
1	All material must be accompanied by an official order and advice note and marked with an identifying label					
2.1	Degrease as necessary Chemodex Mainclean	Spray or Dip	10%		Ambient	
2.2	Water Wash	Towns Water			Ambient	MI
2.3	Chemical Clean	HNO ₃ HF Towns Water	10 / 12% 2 / 3% Balance	4 Hours *	Ambient	MI
2.4	Water Wash	Towns Water			Ambient	MI
3.0	Passivation	HNO ₃ Towns Water	10 / 15% Balance	1-2 hours	Ambient	MI
3.1	Water Wash	Towns Water			Ambient	MI
4.0	Demineralised water wash if specified					
5.0	Dry with air blowers					
6.0	Packing / wrapping, plastic caps, shrink wrap, cling film					
7.0	Despatch – suitable documentation to satisfy customer requirements					
Notes:						
A	Both acids are at commercial strength (60%)					
B	MI = METAPIC INSPECTION . Customer can inspect during any part of the process.					
*	Repeat as necessary					
Note	Generally in accordance with ASTM A380 / A380M - 13					

