

**SERVICE BULLETIN****Oakite®****"Tomorrow's Solutions Today"****Proven Oakite procedure passivates stainless steel  
in two simple steps**

- No lung-irritating nitrous fumes to inhale
- No need to pre-clean or change solution strength

Before describing Oakite's foolproof, short-cut procedure for passivating stainless steel, some background facts seem appropriate.

1. All grades (series) of stainless steel have the unique property of forming a thin, transparent, corrosion-resisting film on exposure to air or other oxidizing conditions. Chromium is the alloy metal most responsible for this property. Nickel can be added as a second alloy to increase the corrosion resistance of the surfaces.
2. To achieve maximum corrosion resistance, stainless steel is usually *passivated* after it's been thoroughly cleaned and pickled to remove surface scale. The *passivation* procedure consists of immersing the cleaned and pickled stainless steel parts into an acidic solution that removes any residual contamination. This contamination — usually tiny iron particles — can cause discoloration or invite corrosion.

Removing the residues allows the complete formation of an invisible, protective oxide film that makes the surfaces highly passive and corrosion-resistant. The impervious coating is quickly formed on exposure of the surfaces to the oxygen in air or other sources.

Now here's Oakite's two-step passivation procedure. . .

1. Remove embedded iron particles by immersing stainless steel parts in a 15 to 25% by volume solution of Oakite 33 for 15 to 30 minutes. Or, remove lighter contamination by immersing parts in a similar strength solution of Oakite Liquacid for a similar length of time. Both solutions pickle as they clean to assure thorough passivation.
2. Rinse.

FOR 300 SERIES

**Oakite®**