

WELD DESCALING

- **ELECTROLYTIC PHOSPHORIC ACID-BASED PRODUCT - Requires rectifier**
 - CLEANER / DEOX 1
 - CLEANER / DEOX 2

- **WELD PASTES - Use with extreme care**
 - PROPRIETARY PRODUCTS
 - HOME RECIPES

WELD DESCALING

A significant problem in electropolishing involves removal of weld scale prior to electropolishing. If not removed, the scale prevents the flow of current totally or partially until the scale is dissolved, and "frosting" of the weld may result.

The problem of reducing or eliminating weld scale removal may also involve the choice of welding method. The inert gas methods are preferred, as oxidation of the heat affected area is minimized.

Two new products are available from MCP for preparing scaled parts for electropolishing. Cleaner/Deox 1 and Cleaner/Deox 2 are phosphoric acid based products, both of which require anodic DC current for best results.

Welding supply houses can furnish a weld paste containing an acid fluoride mixture which can be used to reduce scale prior to polishing. A home-made mixture is also available upon request. Acid products containing fluoride must be handled with great care, and adequate protection should be provide for operators.