

Stainless Steel Passivation Direction

不锈钢钝化操作指引

Items	Process Flow (工艺流程名称)	Liquor Name(溶液名称)	Temperature (温度)	Time(控制时间)
1	Ultrasonic deoiling (超声除油)	SW deoiling agent (SW除油剂): 50-60m l/L	60-70°C	5-8 min
2	Pure water washing (纯水洗)	Pure Water (纯水)	Normal	4-8 Sec
3	alkaline electropolishing (碱性电解抛光)	MaOH: 60-70g/L	60-70°C	25-35 Sec
4	Pure water washing (纯水洗)	Pure Water (纯水)	Normal	4-8 Sec
5	Acid activation (酸活化)	HCL(D=1.18) 150~180m l/L	Normal	35-45 Sec
6	Pure water washing (纯水洗)	Pure Water (纯水)	Normal	4-8 Sec
7	Pure water washing (纯水洗)	Pure Water (纯水)	Normal	4-8 Sec
8	Chromium Nitrate Passivation (硝酸铬盐钝化)	nitric acid(硝酸)350~400m l/L Chromate salt(铬盐) 150~200g/L	Normal	60-70 min
9	Pure water washing (纯水洗)	Pure Water (纯水)	Normal	4-8 Sec
10	Alkaline neutralization 碱性中和	NaOH(10g/L)	Normal	2-3 Min
11	Pure water washing (纯水洗)	Pure Water (纯水)	Normal	4-8 Sec
12	Ultrasonic water cleaning (纯水超声波清洗)	Pure Water (纯水)	Normal	4-8 Sec
13	Blow Dry(吹干)	Compressed air pressure (压缩空气压力)	Normal	Make sure all dry(吹干为止)
14	Drying (烘干)		<65°C	Make sure all dry (烘干为止)
15	QA(检验)	Check appearance according to customer requirements (根据客户要求检查外观)		
16	Package(包装)	PE bags (PE塑料袋包装)		
17	Delivery(出货)			