

# TECHNICAL INFORMATION RODINE 85

## 1. INTRODUCTION

**Rodine 85** is a very strong, soluble, low foaming, liquid inhibitor, formulated for use in conventional acid pickling operations.

**Rodine 85** is an effective inhibitor for sulphuric, hydrochloric, hydrofluoric, phosphoric and acetic acids, as well as sulphamic, citric, oxalic and sodium bisulphate solutions in pickling and industrial cleaning operations.

The organic surfactants contained in **Rodine 85** are classified by the manufacturer as biodegradable.

## 2. MAKE UP

## For Mild and Low Carbon Steels

For each 1,000 litres of **concentrated acid** used, add to the diluted acid:

- (i) For pickling temperatures below 82°C **Rodine 85** 1.2-3.8 litres.
- (ii) For pickling temperatures above 82°C Rodine 85 2.5-5 litres.

## For Alloys and More Reactive Steels

Usual pickling temperatures below 82°C.

For each 1,000 litres of **concentrated acid** used, add to the diluted acid:

Rodine 85 3.8-5 litres.

**Note:** Because of its solubility, **Rodine 85** may be added to tap water or dilute acid at room temperature.

## 3. REPLENISHMENT

In batch pickling operations, **Rodine 85** should be added each time acid is added; in an appropriate quantity to maintain the **Rodine 85**/acid ratio to that of the fresh bath.

For continuous strip line, where water and acid are added continuously, **Rodine 85** should also be added continuously.

## 4. OPERATIONAL RECOMMENDATIONS

If increased foam is desired, Henkel **Foaming Agent 8A** (liquid) may be added to the pickling bath containing **Rodine 85**.

RODINE 85 Page 2

# 5. EQUIPMENT

Rodine 85 is non-corrosive to commonly used pickle tank linings.

#### 6. HANDLING PRECAUTIONS

Protective gloves, aprons and goggles should be worn when handling **Rodine 85** to avoid skin and eye contact.

If splashed on skin, wash off immediately with soap and water.

If splashed in eyes, flush immediately with large quantities of water and obtain medica attention.

#### **DISCLAIMER**

Any information given is, to the best of our knowledge, the best currently available, with respect to our products and their use, but it is subject to revision as additional knowledge and experience is gained. Such information is offered as a guideline for experimentation only and is not to be construed as a representation that the material is suitable for any particular purpose or use. Customers are encouraged to make their own enquiries as to the material's characteristics and, where appropriate, to conduct their own tests in the specific context of the material's intended use. This information is not a license to operate under nor is it intended to suggest infringement of any patent. We guarantee a uniform quality standard for this product. The only conditions and warranties accepted by Henkel in relation to this product or process are those implied by either Commonwealth or State statutes

Ref: RODINE 85/IRR/SJG Page 2 of 3 Issue: 27<sup>th</sup> May, 1996 RODINE 85 Page 3

This form supplied by HENKEL AUSTRALIA PTY LTD, Manufactures of inhibitors and metal working chemicals								
RODINE SAVES ACID AND IRON								
PICKLE LOG								
DEPARTMENT :					WEEK OF :			, 20
		SUNDAY A.M. PM	MONDAY A.M. P.M.	TUESDAY A.M. P.M.	WEDNESDAY A.M. P.M.	THURSDAY A.M. P.M.	FRIDAY A.M. P.M.	SATURDAY A.M. P.M.
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C E N T I I G R A D E	20 2	**************************************	1	ADDITIO	DNS AND TONNAGE			
A	TURN 1							
C I D	TURN 2							
	TURN 3							
	TOTAL							
R	TURN 1							
I N	TURN 2							
Е	TURN 3							
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O D	TURN 1							
H T	TURN 2							
E I R O N								
S	TOTAL							
тР	TURN 1							
0 C	TURN 2							
N I	TURN 3							
S D	TOTAL							
SUMMARY FOR WEEK								
	1 TOTAL ACID				5 TONNES PICKLED			Kg
	2 ACID DUMPED							Kg
3 ACID CONSUMED, 1 - 2 = Kg 7 Kg ACID CONSUMED PER TONNE, 3 ÷ 5 =   4 TOTAL RODINE ADDED Kg or Litre 8 RODINE PER TONNE TOTAL, 4 ÷ 5 =							Kg or Litre	
TRIGORIE ADDED   Kg OF Little   O RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF Little   N RODINE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF LITTLE PER TONNE TOTAL, 4 ÷ 5 =   Kg OF LIT								

Keep an accurate record of additions of acid, Rodine, salt, Foaming Compound, etc., if added, and the tonnage pickled so the consumption of the acid and Rodine

Plot on chart at regular intervals acid concentrations, iron content and temperature of pickle bath.

To prevent wasting acid use Rodine and exhaust acid in the spent bath as far as possible before dumping it.

per tonne can be accurately calculated for each work week.

Ref: RODINE 85/IRR/SJG Page 3 of 3 Issue : 27<sup>th</sup> May, 1996