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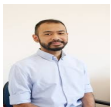
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Standard Specification for Chemical Passivation Treatments for Stainless Steel Parts¹

This standard is a limited guide for field application. ASTM International, the publisher of this standard, does not assume any liability for any injury or damage resulting from the use of the information contained herein. This standard is not intended to be used as a basis for contract documents. This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.

- 1. Scope²**
 - 1.1 This specification covers several different types of chemical passivation treatments for stainless steel parts. It includes recommendations and procedures for descaling, cleaning, and passivation of stainless steel parts. It includes several alternative tests, with acceptance criteria for confirmation of effectiveness of such treatments for stainless steel parts.
 - 1.2 Practices for the mechanical and chemical treatments of stainless steel surfaces are discussed more thoroughly in Practice A967.
 - 1.3 Several alternative chemical treatments are defined for passivation of stainless steel parts. Appendix X1 gives some supplementary information and provides some general guidance regarding the selection of passivation treatment appropriate to particular grades of stainless steel. It makes no recommendations regarding the suitability of any grade, treatment, or acceptance criteria for any particular application or class of application.
 - 1.4 The tests in this specification are intended to confirm the effectiveness of passivation, particularly with regard to the inclusion of free iron and other impurities. These tests include the following practices:
 - 1.4.1 Practice A—Water Immersion Test,
 - 1.4.2 Practice B—Blue Humidity Test,
 - 1.4.3 Practice C—Salt Spray Test,
 - 1.4.4 Practice D—Copper Sulfate Test,
 - 1.4.5 Practice E—Potassium Permanganate-Nitric Acid Test, and
 - 1.4.6 Practice F—Damp Cloth Test.
- Note 1—Free iron denotes iron present on the surface of the parts, including that formed in some circumstances, including work, handling, or in the process of manufacturing. The amount of free iron is to be controlled in accordance with the appropriate requirements in this specification.
- 1.5 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in

each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

- 1.6 The following precautionary covering pertains only to the test method practices. Section 14 of this specification *does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

- 2.1 ASTM Standards:
 - 2.1.1 B360 Practice for Cleaning, Descaling and Passivation of Stainless Steel Parts, Equipment, and Systems
 - 2.1.2 B377 Practice for Operating Salt Spray (Fog) Apparatus
 - 2.1.3 B729 Practice for Preparation of and Electroplating on Stainless Steel
- 2.2 Federal Specification:
 - 2.2.1 QQF-100 Passivation Treatments for Corrosion-Resistant Steels

3. Terminology

- 3.1 Definition of Term Specific to This Standard—It is necessary to define which of the several commonly used definitions of the term passivation will be used in this specification. (See Discussion.)
- 3.1.1 Electrolytic—Solutions which are appropriate in the sense that the protective passive film is formed spontaneously on exposure to air or moisture. The presence of oxygen, surface contamination, including dirt, grease, free iron from contact with steel handling, and oil film, may interfere with the formation of the passive film. The cleaning of these contaminants from the stainless steel surface will facilitate the spontaneous passivation by allowing the oxygen access to occur

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