

5 - Liquids and sprays



- Cooling liquid for torches..... 5-1
- Leakage control..... 5-1
- Anti-spatters..... 5-2
- Anti-corrosion..... 5-3
- Sharpening of tungsten electrodes..... 5-3
- Cracks detection..... 5-4 to 5-5
- Stainless steel treatment..... 5-6



Cooling liquid for torches



WELDLINE

FREEZCOOL (red)

FREEZCOOL is a highly elaborated heat carrier. It is formulated with multi metal corrosion inhibitors for a safe use into all types of circuits. Its thermal stability and dielectric properties make a cooling liquid especially suitable for "high tech" systems.

General use:

- Cooling of welding torches
- Cooling of induction furnaces
- Cooling of tack welding systems, plasma flares
- Air conditioning
- Electric generators
- Motorcar industry: engines cooling systems, engines and gearboxes testing benches.
- Cooling of radar systems.

Product benefits:

- Ensures an anti-freezing protection down to -27 °C
- High electrical resistivity
- Non volatile (no product losses)
- Chemically stable, does not polymerize
- Anti-corrosion: contains multi metallic corrosion inhibitors.
- Anti-algae growth
- Non toxic
- Non flammable

Cat N°: W 000 010 167 (10 kg)

Cat N°: W 000 010 168 (20 kg)

Controls:

- Freezing point with a refract meter
- pH control
- Iron and copper contents

Physical properties:

- Physical form: red liquid
- Base: monopropylene glycol and water
- Specific gravity: 1.04 at 20 °C
- pH: 7+/-2
- Freezing point: -27 °C
- Resistivity: 10⁵ ohm.cm-1



2004-216

Packaging:

FREEZCOOL is delivered in 10 or 20 kilos net weight, polyethylene drums. For any other type of packaging, please contact us.

Caution:

Before use, carefully read and understand the safety datasheet.

Leakage control



BUBBLE

A high-return product for leak detection suitable for all gases except high pressure oxygen > 150 bars.



- Volume: 500 ml (net)
650 ml (nominal)
- Propellant gas: denaturate hydrocarbure
- Base: mixture of foam compounds
- Temperature of application: -10 °C/+130 °C

Cat N°: W 000 010 963



2007-794

1000 BULLES

A leakage controller suitable for all gases.

- Volume: 400 ml (net)
650 ml (nominal)
- Propellant gas: nitrogen protoxyde
- Base: lauryether natrium sulfate

Cat N°: W 000 011 090



2000-228

CAUTION: before use, carefully read and understand the safety datasheet www.safety-welding.com

SPRAYMIG H₂O

Anti-spatter spray and liquid

- Water based and odourless
- No influence on porosity and cold cracks
- No influence of the content of diffusible hydrogen in the weld metal
- Solvent and silicone free
- Biodegradable
- Allows parts to be lacquered
- Easily washed off parts

Spray (400 ml)

Cat N°: W 000 010 001

Drum (20 liters)

Cat N°: W 000 011 074

Description:

- SPRAYMIG H₂O silicone-free water-based anti-spatter based on highly efficient water soluble substances.
- It prevents spatter from sticking to nozzles, tips, and work pieces robots and extends nozzle life considerably.
- It permits rapid changing and cleaning of the nozzles.
- Painting, galvanizing, lacquering of parts is possible.
- A preliminary test is recommended.
- Very low consumption for a high effectiveness.

Physical and chemical properties

- Aspect: liquid uncoloured clear.
- Density at 20 °C: 1.00.
- Pure pH: 7.
- Volume: - spray: 400 ml (net) - 520 ml (nominal), - drum: 20 liters.
- Propellant gas: dimethylether.
- Base: water based emulsion of synthetic oil.



2007-394

SPRAYMIG SIB

Anti-spatter spray

- Silicone based
- Not for use on any parts that are to be painted
- Use on cold parts
- Use on nozzles only and outside contact tip

Technical data:

- SPRAYMIG SIB is a preventive maintenance product for MIG/MAG torches.
- To be used on cold parts only, do not use on threads or inside contact tips (as the product is electrically insulating).
- Volume: 400 ml (net) - 520 ml (nominal).
- Propellant gas: aliphatic hydrocarbons.
- Base: silicone and isoparaffinic solvent.



Cat N°: W 000 011 093



2007-394



SPRAYMIG SVB

Anti-spatter spray

- Silicone free
- Compatible with paint
- Use on cold parts
- Use on nozzles only and outside contact tip

Cat N°: W 000 011 092

Technical data:

- SPRAYMIG SVB is an anti-spatter silicone free spray for welding applications.
- Volume: 400 ml (net) - 520 ml (nominal).
- Propellant gas: aliphatic hydrocarbons.
- Base: biodegradable synthetic polymers.



Cat N°: W 000 271 574



2009-250

SPRAYMIG SVD

Anti-spatter spray

- Silicone free
- Compatible with paint
- Use on cold parts
- Use on nozzles only and outside contact tip
- Dichloromethane solvent.

Technical data:

- SPRAYMIG SVD is an anti-spatter silicone free spray for welding applications
- Volume: 300 ml (net) - 520 ml (nominal)
- Propellant gas: aliphatic hydrocarbons
- Base: Synthetic oil not siliconic.
- Dichloromethane solvent.

Anti-spatters



NETMIG

Anti-spatter dip

- Protects nozzles and contact tips from spatter by immersion.
- Silicone and solvent free.
- Odourless.

Technical data:

- Prevents spatter adhering to:
 - To torch nozzles and contact tips,
 - To positioners and jaws of welding lathes.
- Does not clog threads or apertures.
- Does not cause porosity. Silicone and solvent free. Odourless.
- Base: waxes and oil.
- Volume: 300 gr.

Cat N°: W 000 011 071



2009-283

Anti-corrosion

GALVASPRAY

- Protection of welded joints
- Permits welded parts to be lacquered

Technical data:

- GALVASPRAY sprays a zinc protective finish.
- High resistance to oxidation and corrosion (more than 80 hours in salty fog)
- Quick drying (about 5 minutes) and no dripping.
- Volume: 400 ml (net) - 520 ml (nominal).
- Propellant gas: propane/butane.
- Base: zinc powder in a vegetal resin.

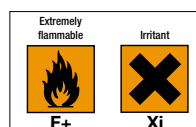
Instructions for use

- Clean and degrease the area to be treated.
- Shake the can before use at least for 1 minute.
- Spray at 25 cm distance from the piece by short and regular passes.

Cat N°: W 000 011 094



2007-395



Sharpening of tungsten electrodes

TIG POINT

Chemical sharpening of tungsten electrodes

Instruction for use:

- Make the electrode to be out from the torch of 15 mm.
- Use the welding current to warm the electrode to white.
- Dip the electrode in the product while rotating the electrode.
- Make sure that the result is satisfactory.
- Carefully close the pot.



2006-528

Cat N°: W 000 011 101

Heat protection

THERMISHIELD

Heat shield gel

Description:

- It is designed to stop heat from travelling through most metals during welding, brazing or soldering.
- It prevents from distortion of metals and even plastics caused by the heat of a welding torch.
- Volume: 500 ml

Cat N°: W 000 274 839

Instructions for use:

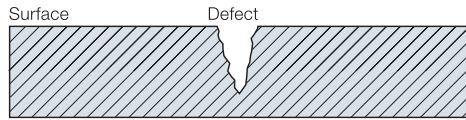
- Shake well before use and spray the product over the surface to be protected.
- Use in well ventilated areas only.



2009-249

SKINCRIC

This non destructive technique allows the detection of cracks opening on the surface of the plate helping a visual control, due to the cracks becoming visible (30 to 50 µm).



A wide range of materials:

Steel, Ceramic, Plastic, Glass...

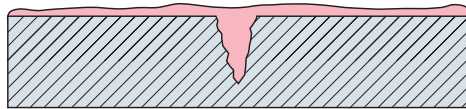
Many industries:

- Boilers maker • Founders • Petrochemical
- Railway • Nuclear • Shipyard • Automotive...



1 - Cleaning

Product: SKINCRIC C.10 S1 CLEANER



+ Product:

- Perfect cleaning without dry rest.
- Quick drying (evaporation).
- Spray: - Spraying in all positions.
- 400 ml which is better than 500 to economise product.

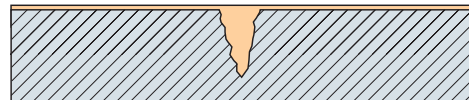
Spray based on Butane Propane (extremely flammable).

Solvent: Heptane.

Necessity for protection (petroleum based) solvent.

2 - Red penetrant spray

Product: SKINCRIC P.138 SA PENETRANT



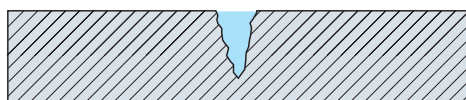
+ Product:

- Temperature of use: 5 °C to 220 °C. Easy to use even on hot plates.
- Good impregnation. A single spray lasts > than 30 min without drying.
- Powerful penetration. Due to its viscosity.
- Spray: works in all positions, 400 ml for economical use of the product.
- Very good identification of cracks under white light.
- Water washable penetrant. No "ground" noise.

Butane spraying (extremely flammable).

3 - Cleaning

Product: water



4 - Developer

Product: SKINCRIC R.764 S1 DEVELOPER

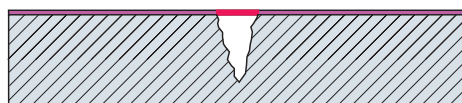


+ Product:

- Thin and uniform film and transparent film. After drying the white surface appears.
- Very good surface coverage due to the thin granulometry.
- Quick drying of the solvent included in the developer.
- Spray: works in all position, 400 ml for a better use of the product.
- Very good identification of the cracks under white light.

Butane spraying.

5 - Inspection of the defects



Cracks are visible at the surface of the plates, thanks to clear vivid red indications easily seen by the naked eye (no uv light required).

SKINCRIC C.10 S1 CLEANER

Piece degreasing & cleaning of excess penetrant.

Direction for use:

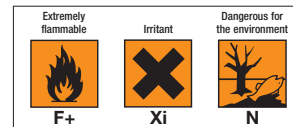
Spray SKINCRIC CLEANER until disappearance of red or purple PENETRANT traces. Drying time: 1-5 minutes.

Safety precautions:

Very toxic to aquatic organisms, may cause long-term adverse effects in the aquatic environment. Irritating to skin. Extremely flammable. Vapours may cause drowsiness and dizziness. Keep away from sources of ignition - no smoking. Do not breathe the steams. Avoid release to the environment. Refer to special instructions/Safety data sheets. Pressurised container: protect from sunlight and do not expose to temperatures

exceeding 50 °C. Do not pierce or burn, even after use. Do not spray on a naked flame or any incandescent material. If swallowed, seek medical advice immediately and show this container or label.

- Propellant: Butane / Propane.
- Base: Petroleum based solvent.
- Volume: 400 ml (net) - 520 ml (nominal).



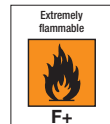
Cat N°: W 000 011 096

SKINCRIC P. 138 SA PENETRANT

Non destructive testing. Red water washable penetrant

Direction for use:

Be sure the area is clean. Spray at 20 cm SKINCRIC PENETRANT for a complete recover of the area. Let penetrate at least 10 minutes. Rinse with SKINCRIC CLEANER. Control with SKINCRIC DEVELOPER.



Safety precautions:

Suitable for high temperatures: 5 °C to 220 °C. Extremely flammable. Keep away from sources of ignition - no smoking. Pressurised container: protect from sunlight and do not expose to temperatures exceeding 50°C. Do not pierce or burn, even after use. Do not spray on a naked flame or any

incandescent material. If swallowed, seek medical advice immediately and show this container or label. Use only in well ventilated areas. Do not breathe the steams.

- Propellant: Butane / Propane.
- Base: Petroleum based solvent.
- Volume: 400 ml (net) - 520 ml (nominal).



Cat N°: W 000 011 095

SKINCRIC R.764 S1 DEVELOPER

Detection of cracks and surface defects.

Direction for use:

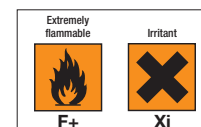
Be sure that the area is clean and without penetrant last trace. Shake the can until hearing clearly the ball bearing. Spray at 20 cm for an uniform layer without super thickness. Wait a few minutes until obtaining a dry powdery film before examining the surface.

Safety precautions:

Irritating to eyes. Extremely flammable. Vapours may cause drowsiness and dizziness. Keep away from sources of ignition - no smoking. Do not breathe the steams. Pressurised container: protect from sunlight and do not expose to temperatures exceeding 50°C. Do not pierce or burn, even after use. Do not spray on a naked flame or any incandescent material. If swallowed, seek medical advice

immediately and show this container or label. Use only in well ventilated areas.

- Propellant: Butane / Propane.
- Base: Isopropyl alcohol
- Volume: 400 ml (net) - 520 ml (nominal).



Cat N°: W 000 011 097

Also available: ARDROX

- ARDROX 9PR5 CLEANER **Cat N°: W 000 011 080**
- ARDROX 9VF2 PENETRANT **Cat N°: W 000 011 078**
- ARDROX 9D1 DEVELOPER **Cat N°: W 000 011 079**

Weldline proposes a complete range of product for stainless steel treatment.

There are three essential phases for a good surface treatment:

- 1 - Degreasing
- 2 - Pickling
- 3 - Passivation



The first two are « intermediate phases », in the sense that they can be repeated in different working stages.

The third, passivation, represents always the final treatment step.

1 CLEANOX (Degreasing- Liquid)



Degreasing is the essential process before any thermal treatment.

It avoids incidental remains of oil or dust which interact (contamination) with the metal during welding or thermal treatment of stainless steel.

It can be repeated in the following phases, in case further thermal processing is required, before the final passivation.



CLEANOX L (liquid) 6 kg	W 000 266 423
CLEANOX L (liquid) 30 kg	W 000 266 425

How to use CLEANOX DEGREASER

Dilute the degreaser with 30% to 50% water and allow it to vaporize on the surface to be treated. Leave for a few minutes to allow the product to act and then rinse with clean water. Do not expose the product or treated surface to sunlight or to any atmospheric agents.

Mandatory safety tools

Protection kit

Working with acid products, the user should use protective clothing carefully.

The protection kit includes:

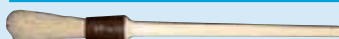
- 10 pairs of acid resistant gloves,
- a pair of closed goggles,
- a facial protection respirator against acid vapours,
- a full chemical protective suit.

Cat. N°: W 000 267 118

Paintbrush

Compatible with acid.

Cat. N°: W 000 267 116



2 PICKLINOX

(Pickling - Product in gel, paste or liquid)

Pickling is the operation that permits, the remove of all oxides after welding, removing the surface layer following a thermal treatment.

It is the most important step in the treatment process.

A welding bead and generally a heated surface, lose their stainless property (Cr < 12%).

For this reason, a pickling operation does not mean only cleaning the welding bead but it restores the stainless steel characteristics.



PICKLINOX G (gel) 2 kg	W 000 266 426
PICKLINOX G (gel) 10 kg	W 000 266 427
PICKLINOX P (paste) 2 kg	W 000 266 428
PICKLINOX P (paste) 10 kg	W 000 266 429
PICKLINOX L (liquid) 30 kg	W 000 266 422

How to use PICKLINOX GEL or PASTE

Degrease the surface to be treated with the specific CLEANOX product. Then apply a coat of PICKLINOX paste or gel. The exposure time will vary from a few minutes up to 30 minutes depending on the type of steel being welded. At the end of treatment remove the gel or the paste with clean water.

Do not expose the product or treated surface to sunlight or to any atmospheric agents.

3 RESTORINOX

(Passivation - Product in gel)

This is the final phase of the process, and is absolutely necessary for restoring the stainless property. With passivation is created a « desired oxidation ».

In fact this working phase restores the chromium layer damaged by heat shortening the spontaneous oxidation time.

In this way, the oxide layer which protects the surface from external agents is restored.



RESTORINOX G (gel) 2 kg	W 000 266 430
RESTORINOX G (gel) 10 kg	W 000 266 431
RESTORINOX L (liquid) 30 kg	W 000 266 424

How to use RESTORINOX

First degrease and pickle the part to be treated with CLEANOX and PICKLINOX. Then apply the product. The times required for exposure will vary from 20 minutes up to 60 minutes. At the end of the treatment remove the product with clean water.

Do not expose the product or treated surface to sunlight or to any atmospheric agents.

WELDLINE is an Air Liquide Welding trademark

PROFESSIONAL WELDING PRODUCTS BY



Cleaning, polishing and marking of stainless steel.

OPTICLEAN

New inverter-technology installation for cleaning, polishing and marking of stainless steel.

Characteristics:

- Includes a torch with a manual pump and liquid cleaning hose inserted onto the torch itself.
- Works with alternating current and not direct current (electronic current control) "Inverter" technology.

Benefits:

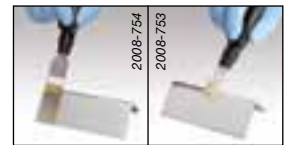
- Operators no longer have to dip the pump into the liquid to clean the piece and therefore it is not necessary to interrupt the operation several times (increased productivity).
- There is no longer any risk of ruining the metal if the torch accidentally touches the workpiece.



Additional advantages:

If, instead, you usually apply cleaning gel or paste.

- **AESTHETICAL ADVANTAGE:** does not leave stains on the steel. Cleaning gel or paste, leave stains as they are very aggressive.
- **ECOLOGICAL ADVANTAGE:** does not produce toxic water requiring treatment, as the workpiece is cleaned with piece of damp cloth. In the traditional solution, for every metre of weld at least 5 litres of water have to be used to eliminate the cleaning solutions on the piece. This water becomes toxic and must be treated in very expensive treatment plants. Failure to observe the law is a criminal offence.
- **LOGISTIC ADVANTAGE:** large outdoor areas are not required for cleaning as use of the machine does not generate toxic vapour emissions or the need for water treatment plant. Being toxic, gel or paste must not be used in closed areas in order to prevent the risk of inhaling harmful vapours.
- **ECONOMIC ADVANTAGE:** It is not necessary to passivate after cleaning with OPTICLEAN. Cleaning with gel or paste, requires a further passivation phase in order to reconstruct the chromium layer weakened through cleaning. If the passivation phase is not performed, the steel will no longer be stainless in the areas where welding and cleaning were performed.



Technical Data:

Model	OPTICLEAN
Supply Voltage	220 V
Frequency	50/60 Hz
Capacity	300W
Electrode Voltage	10/30V AC/DC
Isolation Class	IP23
Noise level	<10 dB (A)
Machine weight (empty)	4,5 kg
Machine dimensions	280 x 210 x 135 mm

To order:

Equipments and products for cleaning

Reference	Name	Complete installation OPTICLEAN W 000 271 933	Extra kit cleaning OPTICLEAN W 000 271 938
-	OPTICLEAN Inverter	•	-
-	OPTICLEAN Torch	•	•
W 000 272 355	Inox narrow insert 60°	•	•
W 000 272 354	Inox narrow insert 90°	•	•
W 000 272 357	Inox standard insert 60°	•	•
W 000 272 356	Inox standard insert 90°	•	•
W 000 272 351	Narrow soft bond pad 90°	•	•
W 000 272 348	Standard bond pad 90°	•	•
W 000 272 352	Narrow soft bond pad 60°	•	•
W 000 272 349	Standard bond pad 60°	•	•
W 000 272 038	Neutral OPTICLEAN solution 100 ml	•	•
W 000 272 346	Soft OPTICLEAN solution 100 ml	•	•

Equipments and products for polishing

Reference	Name	Polishing extra kit - W 000 271 935
W 000 272 028	Narrow graphite insert 11 mm	•
W 000 272 030	Standard graphite insert 22 mm	•
W 000 272 034	Narrow brill bond pad 11 mm	•
W 000 272 036	Tampon brill bond pad 22 mm	•
W 000 272 035	Narrow teflon ring 11 mm	•
W 000 272 037	Standard teflon ring 22 mm	•
W 000 272 347	Brill OPTICLEAN solution 100 ml	•

Equipments and products for marking

Reference	Name	Marking extra kit - W 000 271 936
W 000 272 039	Graphite marking insert 35 mm	•
W 000 272 040	Marking felts insert	•
W 000 272 041	Stainless steel marking electrolyte 100 ml	•

DECLARATION OF CONFORMITY



- Machinery Directive 98/37/EC and its subsequent modifications
- Low-voltage Directive 2006/95/EC
- Electromagnetic Compatibility Directive 2004/108/EC

And the following harmonised standards:
DIN EN ISO 12100-1, DIN EN ISO 12100-2, DIN EN 60204-1, EN 55011, DIN EN 61000-6-4, DIN EN 61000-6-2, EN 61000-4-2, EN 61000-4-4.



- Directive 2002/95/EC (RoHS Directive) – concerns the restriction of the use of six specific hazardous substances (cadmium, mercury, lead, hexavalent chromium, polybrominated biphenyls – Pbbs, and polybrominated diphenyl ether PBDE) in electrical and electronic appliances sold in the EU.

We recommend the users of OPTICLEAN to wear a disposable respirator in order to protect them from vapours and fumes while :

- using polishing solution in a intensive mode,
- working inside a tank or in confined areas.