



Surface Technologies

TECHNICAL BULLETIN

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

Ford 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**.