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Standard Specification for Chemical Passivation Treatments for Stainless Steel Parts¹

This standard is intended solely for the information of the user and does not constitute an approval or endorsement by the American Society for Testing and Materials. It is the responsibility of the user 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 A380.
 - 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 Stain 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.
- Notes—1—Free iron denotes iron present on the surface of the parts, including that formed in some circumstances, including such conditions as work with unbuffered iron and iron tools.
- 2—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 caveat pertains only to the test method portions, Section 14 of this specification. 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.

2. Referenced Documents

- 2.1 ASTM Standards:³
 - A380 Practice for Cleaning, Descaling and Passivation of Stainless Steel Parts, Equipment, and Systems
 - B117 Practice for Operating Salt Spray (Fog) Apparatus
 - B224 Practice for Preparation of and Electroplating on Stainless Steel
- 2.2 Federal Specification:⁴
 - QQF-352 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 Discussion—Scientists usually are unconcerned 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 tooling, and so forth, 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

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²A Summary of Changes section appears at the end of this standard.

³The referenced ASTM standards, visit the ASTM website, www.astm.org, or ASTM International, 1000 Brook Hill Drive, West Conshohocken, PA 19380. This document is copyrighted by ASTM International, 1000 Brook Hill Drive, West Conshohocken, PA 19380. This document is intended solely for the individual user's reference and use; it is not to be distributed, reproduced, or stored in a retrieval system without the prior written permission of ASTM International. Copyright © 2013 ASTM International. All rights reserved. For more information, contact ASTM Customer Service at 610-855-7829.

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