

## SURFOX™ 305 Weld Cleaning System

*The SURFOX 305 electrochemical weld cleaning system is a highly effective method of removing heat tint in the heat affected zone of welded stainless steel (TIG, Spot and MIG), without altering the surface of the parent material. It also promotes the formation of a uniform and durable chromium oxide passive layer to protect stainless steel against further corrosion. SURFOX is a safer, faster and more cost effective alternative to very hazardous pickling pastes and abrasive weld cleaning processes like wire brushing and grinding.*



### The most powerful unit for a wide variety of jobs

The SURFOX™ 305 is our patented electrochemical weld cleaning system for stainless steel and aluminum. It quickly and easily removes heat tint from the heat-affected zone of MIG, TIG and spot welds, cleaning the surface and allowing passivation on stainless steel to begin without altering the surface finish. The integrated tank and flow-through system ensures the electrolyte solution is delivered directly to the workpiece, minimizing the potential for spillage or cross-contamination. The dynamic current control also ensures that the electrical current will not cause micropitting on the surface.

#### Process

- Set the machine to manual pumping or automatic feed level 1 (TIG) or level 2 (MIG)
- Put the wand setting to the tungsten insert, brush or large graphite insert setting (under the large wand group of settings) depending on the cleaning accessory you will use.
- Put the power to AC LEVEL 2. If needed go to AC LEVEL 3 which has the most power use fume elimination system. AC LEVEL 1 can be used on thin gauge metal when overheating could be an issue.
- Ground the workpiece
- Fill up the machine with the Surfox electrolyte solution.
- Turn on the machine
- Press the ON button (top button on the large wand)
- If it is the first time, purge the machine for at least 3 minutes to get rid of the testing solution (green color).
- Once the weld or the surface is cleaned, push the off button (lower button on the large wand) then use a rag to remove the excess of electrolyte solution. You could also rinse with water that contains less than 200 ppm.
- Apply Surfox-N or FT-100 everywhere the electrolyte solution has been.
- Use a different rag to remove the Surfox-N or FT-100. You could also rinse with water that contains less than 200 ppm.
- **Wait 48 hours to make sure the passive film is formed prior applying a protector or wrapping for shipping.**

**Be careful when mounting/removing the wand, always clean and neutralize the connector with Surfox-N or FT100.**

**Please read the user manual of the surfox before using the device.**

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SDS available upon request or on our website at [www.walter.com](http://www.walter.com)

Walter Surface Technologies Inc.  
5977 Trans-Canada Highway, Pointe-Claire, Quebec H9R 1C1  
Tel: 1-800-592-5837 or (514)630-2800 / Fax: (514)630-2825 / web: [www.walter.com](http://www.walter.com)