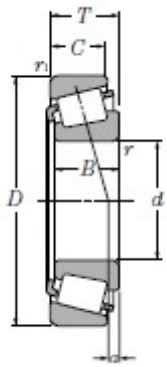
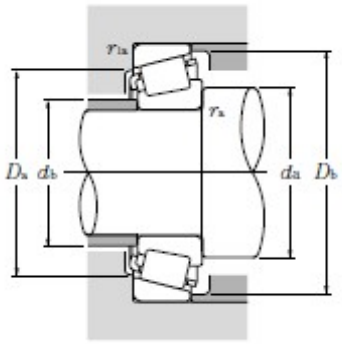
NTN 4T-685/672 size specifications





New Model	NTN 4T-685/672	da(min)	116
d(mm)	98.425	db(max)	1089
B(mm)	41.275	Db(min)	160
D(mm)	168.275	Da(min)	149
C0r/KN	340	a	3.0
Y2	1.28	e	0.47
Y0	0.70	cr/kN	222
r as max	3.5	cor/kgf	35000

The passivation solution, HNO3 should be controlled in 20% - 50%, according to the electrochemical test, the concentration of HNO3 is less than the passivation film quality of 20% treatment of unstable, easy to produce the pitting corrosion of [8], but the HNO3 concentration is greater than 50%, to prevent the passivation.
One step processing in addition to oleic acid washing passivation, although has the advantages of simple operation, time saving, but the pickling passivation (paste) will be the erosion of the HF, so the final protective film quality is better than multiple method.
Adjust the concentration, temperature and contact time of acid in a certain range allows the pickling process. As the acid wash time growth, must pay attention to the change of the concentration of acid and metal ion concentration, should pay attention to avoid pickling, titanium ion concentration should be less than 2%, otherwise it will cause serious corrosion. In general, improve the pickling temperature will accelerate and improve the cleaning effect, but also may increase the risk of surface contamination or damage.
Control of [2] 4 stainless steel pickling sensitized condition
Some stainless steel due to poor heat treatment or cause sensitization by HNO&HF welding, pickling may produce intergranular corrosion, caused by intergranular corrosion cracks at run time, or cleaning, or subsequent processing, can be concentrated halide, caused by stress corrosion. In addition to using HNO3+HF scale or acid pickling solution of these sensitized stainless steel in general should not be. This acid after welding as must be stabilized or using ultra low carbon stainless steel.



5 stainless steel and carbon steel assembly pickling

For stainless steel and carbon steel assembly (such as in the heat exchanger tube and tube plate of stainless steel and carbon steel shell), pickling and passivation if using HNO3 or HNO3+HF will be a serious corrosion of carbon steel, you should add the appropriate inhibitor such as Lan-826. When stainless steel and carbon steel assembly in sensitized state, using HNO3+HF pickling can not, can adopt the glycolic acid (2%) + (2%) + formic acid corrosion inhibitor, temperature 93 C, time 6h or EDTA ammonium neutral solution + inhibitor, temperature 121 C, time: 6h, then rinse with hot water and dip into the 10mg / L +100mg / L ammonium hydroxide, hydrazine in [3].