Weldphos MM

Weldphos MM is a uniquely balanced low foaming liquid iron phosphate, which produces an iridescent blue phosphate finish on multi-metals. Weldphos MM is formulated as an active corrosion inhibiting paint-bonding phosphate coating on multi-metals. Weldphos MM effectively cleans and produces corrosion resistant coating on steel, galvanized and aluminum substrates.

Features/Benefits

- Coating weights are up to 40 mg/sq.ft.
- Improves impact resistance and flexibility of applied paint films.
- Prevents the under-rusting of paints if the paint film is chipped or scarred.
- Best suited for 2 and 3 stage washers.
- Cleans and phosphates in one step and can be applied in the first stage.
- Superior surfactant system, which cleans faster, resulting in faster coating deposition.
- Operates as low as 43 ºC (110 ºF); but can be operated as high as 65 ºC (150 ºF).
- Can be controlled by pH or by acid analysis.
- Economical single step system.
- Liquid material for ease of use.

Equipment

Steel tanks and heating coils are satisfactory. Electric immersion heaters should be stainless steel (preferably 316 SS).

Spray Application

Concentration	3 to 5 % by volume Weldphos MM
Temperature	43 to 65 ºC (110 to 150 ºF)
Time	45 seconds to 2 minutes
Spray Pressure	15 to 30 psi

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Weldphos MM

Analysis of Weldphos MM – Burette Titration Method

Apparatus: 10 mL Volumetric Pipette, Type A
50 mL Burette, Class A
250 mL Erlenmeyer Flask

Reagents: 1 % (w/v) Phenolphthalein Indicator solution
0.1 N Sodium Hydroxide (NaOH)

Procedure:

1. Pipette a 10 mL sample of Weldphos MM solution into a 250 mL Erlenmeyer flask.
2. Add 3 – 5 drops of Phenolphthalein Indicator solution.
3. Titrate with 0.1 N NaOH to a pink endpoint.
4. Calculation:

   mL of 0.1 N NaOH titrated x 0.4 = % by volume Weldphos MM

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Analysis of Weldphos MM – Dropping Bottle Method

Apparatus: 10 mL Graduated Cylinder
250 mL Erlenmeyer Flask
125 mL Dropping Bottle

Reagents: 1 % (w/v) Phenolphthalein Indicator solution
1 N Sodium Hydroxide (NaOH)

Procedure:

1. Measure a 10 mL sample of Weldphos MM solution with a 10 mL graduated cylinder and add to a 250 mL Erlenmeyer flask.
2. Add 3 – 5 drops of Phenolphthalein Indicator solution.
3. Add dropwise 1 N NaOH from a dropping bottle while counting the drops and swirling the solution.
4. Stop adding the drops when the colour changes to pink.
5. Calculation:

   (drops of 1N NaOH x 0.1) + 0.56 = % by volume Weldphos MM

The data and statements contained in this bulletin are based on testing information and are believed to be accurate and reliable. This bulletin is not a Guarantee or Warranty, express or implied regarding the products use. The product is sold on the condition that the purchaser will do their own tests to determine the suitability of the product in a particular application.

READ THE MSDS BEFORE USING THIS PRODUCT

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