

## OXYSCALE 2-14

Low Temperature Melting Point Deoxidant  
For Piercing Mill Tube Hot Rolling Process.

### 1. Description:

**OXYSCALE 2-14** is developed for production of seamless tubes from low carbon steel grades. It appears as a fixed particle size white colored powder with low temperature melting point. Contains borates, phosphates and soap which melts at hot rolling process. The melt dissolves scale and keeps it in liquid phase.

**OXYSCALE 2-14** blocks further scale formation.

**OXYSCALE 2-14** is applied by blowing on continuous tube rolling mill between piercing and rolling.

**OXYSCALE 2-14** improves the process due to:

1. Improving of lubrication at hot rolling.
2. Increasing of mandrel life time.
3. Ensuring corrosion protection during the process.
4. Increasing the rolling speed.
5. Decreasing the electric current loads during the process.

### 2. Physical Chemical Structure:

Appearance:	powder	Color:	white
(110 °C):		Humidity	< 2%
Particle size:	90% < 110 μm		

### 3. Application:

Chemical: **OXYSCALE 2-14**

Application and control:

Concentration: 100%.

Dosage: depending on the length and diameter. Norm. in range 80-180 g/sq.m.

### 4. Process Sequence:

**OXYSCALE 2-14** process contents on the following stages:

- Hole piercing in hot tube billet.
- Major scale volume blasting by the inert gas.
- Blowing off by the inert gas the dosed quantity of **OXYSCALE 2-14** to the shell.
- 2-4 s. reaction time
- Rolling

## 5. Equipment:

The dosing equipment has to be constructed from stainless steel.

## 6. Storage:

**OXYSCALE 2-14** is slightly sensitive to air humidity but due to special additives and package the special storage conditions are not applied as well as contents of the additives against caking during storage and usage. **OXYSCALE 2-14** shelf life in closed original package makes 1 year since the production date.

## 7. Waste Treatment Information:

The existing local utilization requirements has to be observed. The detailed information on product composition in the form as it is delivered refer the Product Technical Conditions.

## 8. Safety Information:

**OXYSCALE 2-14** may cause eye and mucous membrane irritation. Use safety glasses to avoid eye contact. Heated material may cause skin and mucous membrane burn. In case of contact follow the recommendations listed in the Product Technical Conditions.

This information is based on our current level of knowledge. It is given in good faith but it is not intended to guarantee any particular properties. The users must satisfy themselves that there are no circumstances requiring additional information or precautions or the verification of details given herein.