

# TASETO Chemical Products

Auxiliary Agents

for Spatter Deposit Prevention

## TASETO SPANON (Spatter Deposit Preventive Agent)

### • Product types and properties

| Steel               |                                 | Mild & high tensile steels |              |        |              |      |              | Stainless steels |              |       |                    |
|---------------------|---------------------------------|----------------------------|--------------|--------|--------------|------|--------------|------------------|--------------|-------|--------------------|
| SPANON              |                                 | N                          | N-1          | L      | LA           | AW   | AW-1         | K-1              | H-1          | S     | S(For nuclear use) |
| Physical Properties | Liquid system                   | E                          | E            | WS     | WS           | WD   | E            | WS               | E            | WD    | WD                 |
|                     | Coated condition                | trans-parent               | trans-parent | Silver | trans-parent | gray | trans-parent | trans-parent     | trans-parent | white | white              |
|                     | Drying time(min.)               | 10                         | 10           | 5      | 5            | 10   | 10           | 10               | 10           | 10    | 10                 |
|                     | Recommended coated thickness(μ) | 3                          | 2            | 3      | 2            | 12   | 6            | 2                | 2            | 15    | 15                 |
|                     | Coated area(m <sup>2</sup> /kg) | 60                         | 60           | 50     | 60           | 35   | 50           | 60               | 60           | 25    | 25                 |
| Coating method      | Brushing                        |                            |              |        |              |      |              |                  |              |       |                    |
|                     | Spray gun                       |                            |              |        |              | ×    |              |                  |              | ×     | ×                  |
|                     | Simplified spraying             |                            |              |        |              | ×    | ×            |                  |              | ×     | ×                  |
| post-cleaning       | Water                           | ×                          | ×            | ×      | ×            | ×    | ×            |                  | ×            |       |                    |
|                     | Pickling                        | ×                          | ×            | ×      | ×            | ×    | ×            |                  | ×            |       |                    |
|                     | Solvent                         | ×                          | ×            | ×      | ×            | ×    | ×            |                  | ×            | ×     | ×                  |
|                     | Alkali                          | ×                          | ×            | ×      | ×            | ×    | ×            |                  |              |       |                    |
|                     | Chemical conversion             | ×                          | ×            | ×      | ×            | ×    | ×            |                  | ×            |       |                    |
|                     | Over coating with paint         |                            |              |        |              |      |              | ×                |              | ×     | ×                  |
| Rust Prevention     | Indoors (month)                 | 2                          | 1            | 3      | 1            | 3    | 3            | 2 weeks          | 1            | 1     | 1                  |
|                     | Outdoors (week)                 | 2                          | 1            | 4      | 1            | 2    | 2            | ×                | ×            | ×     | ×                  |

- Remarks
- E : Emulsion

S : Solvent (nonflammable solvent)

WD : Water dispersion

WS : Water soluble
  - : permitted

: permitted if a spray gun is cleaned after use

× : not permitted

# **TASETO Chemical Products**

Auxiliary Agents

for Spatter Deposit Prevention

---

The labor-saving and rationalization are urgent issues to the welding industry. Spatter generated during welding work not only adversely affects the finish appearance of a welded product but also the time required for removing the spatter cannot be neglected. The company developed a series of spatter deposit preventive agents "TASETO SPANON" to solve the problems. TASETO SPANON will help rationalize your welding work and, at the same time, improve the quality of your welded products.

## ● **How to use**

1. Clean off rust from the surface using an organic solvent or wire brush.
2. Apply uniform coats of TASETO SPANON until the recommended thickness is obtained with a brush or spray gun.
3. Start welding after the coated surface dried completely.
4. TASETO SPANON does not influence the weldability at all.
5. Some TASETO SPANONS are very adhesive to steels, thus making it difficult to remove such coatings. For easier removal, use TASETO SPANON S, SPANON K-1.

## **TASETO SPANON N TASETO SPANON N-1**

## ● **Applications**

Mild steels, high tensile steels

## ● **Features**

1. The coating color immediately after application is pale milky white, but it gets transparent when dried.
2. No solvent odor.
3. Steels coated with SPANON N are resistant against rust for two months when placed indoors and for one month in outdoors.
4. It is possible to overcoat oil, phthalic acid resin or phenolic resin coatings. If you want to use other types of coatings, please carry out the trial test or consult with us.
5. Use SPANON N-1 if you want to apply with a simplified spraying.

## ● **Packing units**

16-kg case (4kg×4 cans), 18-kg can, 12-can set (420 mL aerosol can×12)

# **TASETO Chemical Products**

Auxiliary Agents

for Spatter Deposit Prevention

---

## **TASETO SPANON L TASETO SPANON LA**

- **Applications**

Mild steels, high tensile steels

- **Features**

1. Water soluble type, relatively dry quickly.
2. Rust prevention.  
SPANON L 3 months indoors, 4 weeks outdoors  
SPANON LA 1 month indoors, 1 week outdoors
3. Do not freeze even -18 .
4. Appearance of coating film: SPANON L silver gray, SPANON LA transparent

- **Packing units**

16-kg case (4kg×4 cans), 18-kg can

## **TASETO SPANON AW TASETO SPANON AW-1**

- **Applications**

Mild steels, high tensile steels

- **Features**

1. Exert prominent effects when applied to the surface to be multi-layer welded
2. Good heat resistance.
3. Water based without solvent odor.
4. Good rust prevention.
5. SPANON AW produces gray coats. SPANON AW-1 transparent coats.

- **Packing units**

16-kg case (4 kg×4 cans), 18-kg can

# TASETO Chemical Products

Auxiliary Agents

for Spatter Deposit Prevention

---

## TASETO SPANON K-1 TASETO SPANON H-1

- **Applications**

Mild steels, high tensile steels, stainless steel sheets

- **Features**

1. SPANON K-1 and SPANON H-1 are water base liquids, with no solvent odor.
2. Easy to remove SPANON K-1 coats with water washing, pickling or alkali washing. SPANON H-1 coats are easily removed by pickling or alkali washing.
3. You cannot paint other coatings over SPANON K-1 after welding, however, you can do so after you remove the coat with water washing. You can paint other coatings directly over SPANON H-1 after welding.

- **Packing units** 16-kg case (4 kg×4 cans), 18-kg can

## TASETO SPANON S

- **Applications**

Stainless steel and nickel alloys

- **Features**

1. Inorganic heat resistant coatings are obtained, being effective for preventing spatter deposition.
2. Coatings are removed easily by water washing or pickling.

- **Packing units**

16-kg case (4 kg×4 cans), 18-kg can, 12-can set (420 mL aerosol can×12)

## TASETO SPANON POWDER

- **Applications**

Stainless steel and nickel alloys

- **Features**

It is possible to produce the spatter deposit preventive agent exactly same as TASETO SPANON S by adding water to TASETO SPANON POWDER in a ratio of 10 to 18 or 20 (wt%) and then shaking it well.

- **Packing unit**

4-kg box

## TASETO SPANON S (LOW halogens & low sulfur)

- **Applications**

Stainless steel and nickel alloys for nuclear welded structures.

- **Features**

Each content of impurities (Cl, F, S), which are critical issues in nuclear use welded structures, are limited to less than 200 ppm.

- **Packing units**

16-kg case (4-kg×4 cans), 18-kg can

## TASETO TIP CLEAN TASETO TIP CLEAN ZF (Spatter Deposit Preventive Agents for Torch)

- **Applications**

Carbon-dioxide welding torches, electrode holders and other tools.

- **Features**

1. Prevent spatter deposition.
2. Increase significantly the life of torch nozzles tips.

# **TASETO Chemical Products**

Auxiliary Agents

for Spatter Deposit Prevention

---

3. Improve the efficiency of welding work.
4. Easy to coat; immerse the nozzle tip in TASETO TIP CLEAN or spray TASETO TIP CLEAN ZF over the nozzle tip.

- **How to use**

- **TASETO TIP CLEAN** (Jelly solid, immersion type)

1. Immerse the nozzle tip in TASETO TIP CLEAN while it is hot. If the nozzle tip is cold, warm it up by sacrifice welding about 10 cm and then immerse it in the jelly.
2. While the effect of TASETO TIP CLEAN is remained, the nozzle shines. When the nozzle tip loses its gloss, immerse it again in TASETO TIP CLEAN.

- **TASETO TIP CLEAN ZF** (aerosol type)

1. Shake TASETO TIP CLEAN ZF can well before use.
2. Spray TASETO TIP CLEAN ZF about 5 to 10 cm away from the nozzle tip.
3. When the coating is thinned, re-spray after cleaning the surface.

Both TASETO TIP CLEANs are recommended to use from new nozzle tips.

- **Packing units**

- TASETO TIP CLEAN : 300-g can

- TASETO TIP CLEAN ZF : 420 mL aerosol cans×12