

Iron phosphatisation

eska®phor W 622



Product characteristics and performance features

- Degreasing and iron phosphatising agent
- produces dense bluish iridescent layers on steel
- Excellent adhesion primer for paintwork and powder coatings
- Temporary corrosion protection
- sprayable



Application range

eska®phor W 622 is used in single or multi-chamber spraying systems as well as in vapour blasting processes for cleaning or phosphating light metal and ferrous materials.

After cleaning or phosphating, the workpiece surface is rinsed with clear, cold water to remove adhering product residues from the surface. Depending on the requirements of the workpiece surface, rinse with fresh water or demineralised water. The surface is then dried with hot air (100 - 120 °C). If no drying is available, a further hot rinsing bath must be installed downstream so that the workpieces dry by their own heat after removal. Drying can be additionally supported by blowing off with air.

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Advantages and benefits

- Advantage: Produces a high-quality phosphate layer
Benefit: Good primer and temporary corrosion protection for temporary storage
- Advantage: Use of pH-controlled dosing possible
Benefits: Less control effort and product consumption. Stable process
- Advantage: Degreasing and phosphating in one work step
Benefits: Economical, as no additional cleaning is required



Technical data

- Density (20°C): approx. 1.16 g/cm³
 pH value (1% solution): approx. 3.0



Preparation and operating data

- Concentration: 0.5 - 2.0 % by volume
 Bath temperature: 35 - 70 °C
 Treatment time: 1 - 3 min
 Spray pressure: 1 - 2 bar
 pH value: 4.0 - 5.2

Depending on the water hardness, the pH value is in the range of pH 2.4 - 3.5. To achieve the above-mentioned optimum working range, the pH toner eska® phor P 347 should be added to the bath solution in stages. The pH value should be monitored regularly using suitable equipment, e.g. an electric pH meter.

- Bath monitoring: 10 ml bath solution
 Phenolphthalein indicator solution (colourless-pink; pH 8.5)
 0.1 N sodium hydroxide solution Standard solution
 tap water factor 0.33
 Demineralised water factor 0.63

Concentration (vol. %) = consumption of standard solution (ml) x factor
 (see also titration instructions eska® phor products for bath monitoring)



Supplementary documents

Slight variations in colour and appearance between individual product batches have no influence on the quality and functionality of the product. The information is based on technical knowledge and experience.

For information on the safe handling of our product, please refer to the corresponding safety data sheet.

The above information corresponds to the current state of science and technology for the relevant products. Our advice does not release you from the need to check our products for suitability for use in your company and for the special requirements there.
Important note: Our products are intended exclusively for industrial use.

08.08.2023 hol/si