

TECHNICAL DATA SHEET

ZINC SULFATE ELECTRO GALVANING PROCESS (EB-22)

Zincobrite EB-22 is a sulfate zinc plating process suitable for mild steel, metal sheets & wires continuous plating. This process used where highly ductile deposit required for wire draw and bending. Its deposition very fast that's why this process highly recommended for continuous electro galvanizing lines.

The deposit of sulfate zinc plating process less bright than conventional cyanide zinc or chloride zinc processes, but provide higher thickness good adhesion strength and ductile zinc deposition.

To improve corrosion resistance zincobrite EB-22 process can be easily passivated with conventional blue, yellow or olive green passivation

SOLUTION COMPOSITOIN:

CHEMICALS	RANGE	OPTIMUM
Zincobrite Salt EB-22	200-220 g/l	210 g/l
Zincobrite A	120-160 ml/l	140 ml/l
Zincobrite B	3-4 ml//	3.5 ml/l

OPERATING CONDITIONS:

Parameters	RANGE	Optimum
Cathode current density	0.5-4.0 A/dm ²	2.5 A/dm ²
Anode current density	1.0-2.5 A/dm ²	2.0 A/dm ²
Temperature	25-35°C	30°C
Density	16-20	18
Filtration	Continues	Continues
pH	4.8-5.2	5.0
Agitation	Mechanical Agitation	Mechanical Agitation
Voltage	4-8	6

BATH MAKE UP:

- Fill the tank with 2/3rd of warm water.(40-50°C)
- Add the required quantity of Zincobrite Salts EB-22.
- Maintain the temperature at 25-30°C.
- Filter the solution till the solution is clear.
- Add required quantities of Zincobrite A & Zincobrite B additives.

Zincobrite Salt EB-22:-

Zincobrite Salt EB-22 is a sulfate base plating grade zinc salt which increase zinc ions and throwing power in zinc solution. Add 12 gm/ltr to increase 1 density.

Zincobrite A:-

Zincobrite A is zinc grain refiner used to increase throwing power of solution and overall smooth zinc deposition.

Zincobrite B:-

Zincobrite B is a brightening agent used to increase the overall brightness.

EQUPMENTS:-

- A PVC, PP or similar materials is suitable to contain the solution.
- PP, PVC lined filters having capacity of 2-3 turnover per hour is recommended.

