

OXYSCALE 7115

Mandrel bar lubricant for tube hot rolling

1. Introduction:

OXYSCALE 7115 is a powder product developed to assist in production process of mild steel seamless tubes. It is a white product with controlled particle size, containing borates and phosphates which melts at the temperature of tube rolling. The melted mixture has a scale dissolving effect and the removed scale is kept in melted phase. Melted phase is very viscous ensuring high level of lubrication. **OXYSCALE 7115** is especially suitable as deoxidizer and mandrel bar lubricant on tube rolling mill between piercing and rolling applied by injection.

OXYSCALE 7115 improves by:

1. Improving lubrication during tubes hot rolling
2. Ensures clean and smooth inner surface quality
3. Improving mandrel lifetime.
4. Offering corrosion resistance during the process.
5. Allowing faster rolling speed
6. Reducing the energy necessary for rolling.

2. Operating Summary:

Chemical:

OXYSCALE 7115

Operation and Control:

Concentration: 100 %

Dosing: Depends on tube diameter and length. Average dosing is 80-120 g/m².

3. Processing Sequence:

The complete process for applying **OXYSCALE 7115** normally consists of the following steps:

- Make the hole in the hot billet.
- Blow off non-adherent scale and air from shell by inert gas
- Blow the dosed amount of **OXYSCALE 7115** into the shell
- 2-3 s treatment time is required
- Rolling

4. Equipment:

All equipment to use **OXYSCALE 7115** should be constructed of stainless steel. Dosing equipment is recommended to be constructed from stainless steel.

5. Storage Requirements:

OXYSCALE 7115 is slightly sensitive to humidity but due to its special additives and packaging it is not necessary to store it in a special warehouse. Anti-tacking additives and packaging also help to avoid sticking particles to each other during storage or in dosing equipment. Shelf-life of **OXYSCALE 7115** is 1 year from production in closed original packaging.

6. Waste Disposal Information:

Applicable regulations covering disposal and discharge of chemicals should be consulted and followed. Disposal information for the chemical, in the form as supplied, is given on the Material Safety Data Sheet for the chemical.

7. Precautionary Information:

OXYSCALE 7115 can cause irritation of the eyes. Do not get in eyes. Use chemical goggles or face shield. In case of contact, follow the recommendations on the Material Safety Data Sheet for **OXYSCALE 7115**. The heated material can burn eyes or skin.