

# INTERNATIONAL STANDARD

# ISO 16048

First edition  
2003-02-01

---

---

## Passivation of corrosion-resistant stainless-steel fasteners

*Passivation des éléments de fixation en acier inoxydable résistant à la  
corrosion*

STANDARDSISO.COM : Click to view the full PDF of ISO 16048:2003



Reference number  
ISO 16048:2003(E)

© ISO 2003

**PDF disclaimer**

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

STANDARDSISO.COM : Click to view the full PDF of ISO 16048:2003

© ISO 2003

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office  
Case postale 56 • CH-1211 Geneva 20  
Tel. + 41 22 749 01 11  
Fax + 41 22 749 09 47  
E-mail [copyright@iso.org](mailto:copyright@iso.org)  
Web [www.iso.org](http://www.iso.org)

Published in Switzerland

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 16048 was prepared by Technical Committee ISO/TC 2, *Fasteners*, Subcommittee SC 1, *Mechanical properties of fasteners*.

## Introduction

In the preparation of this International Standard special attention has been given to the fundamental fact that a surface film of chromium oxide is immediately formed when producing stainless steel or products made of stainless steel. It is this very thin oxide film which can be thickened by passivation. The thickness of the layer is about 0,002  $\mu\text{m}$ .

STANDARDSISO.COM : Click to view the full PDF of ISO 16048:2003

# Passivation of corrosion-resistant stainless-steel fasteners

## 1 Scope

This International Standard specifies the methods most often used for passivation of corrosion-resistant stainless steel fasteners.

Typical anodic dissolution behaviour of an active-passive-transpassive metal is given in Annex A.

## 2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 3506-1:1997, *Mechanical properties of corrosion-resistant stainless-steel fasteners — Part 1: Bolts, screws and studs*

ISO 3506-2:1997, *Mechanical properties of corrosion-resistant stainless-steel fasteners — Part 2: Nuts*

ISO 3506-3:1997, *Mechanical properties of corrosion-resistant stainless-steel fasteners — Part 3: Set screws and similar fasteners not under tensile stress*

ISO 3506-4:—<sup>1)</sup>, *Mechanical properties of corrosion-resistant stainless-steel fasteners — Part 4: Tapping screws*

## 3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

### 3.1

#### **passivation**

chemical treatment that increases the thickness of the naturally occurring chromium rich oxide film present on all types of stainless-steel surfaces

### 3.2

#### **passivity**

chemically inactive surface condition of stainless steels

---

1) To be published.

**4 Passivation**

**4.1 Pickling prior to passivation**

Before passivation, a pickling treatment in a bath selected from those listed in Table 1 is recommended.

Before pickling, the fasteners shall be degreased and rinsed.

**Table 1 — Pickling baths**

Steel grade <sup>a</sup>	Chemicals	Concentration <sup>c</sup> volume %	Temperature <sup>c</sup> °C	Exposure time for fresh bath <sup>c</sup> min
A2 A3 A4 A5 C3 <sup>b</sup> F1	HNO <sub>3</sub>	20 to 30	20 to 60	10 to 30
	H <sub>2</sub> SO <sub>4</sub>	8 to 11	60 to 80	5 to 30
A1 C1 <sup>b</sup> C4 <sup>b</sup>	HNO <sub>3</sub>	10 to 15	20 to 60	10 to 30
	H <sub>2</sub> SO <sub>4</sub>	8 to 11	60 to 80	5 to 30

<sup>a</sup> Steel grades in accordance with ISO 3506-1, ISO 3506-2, ISO 3506-3 and ISO 3506-4.

<sup>b</sup> Prior to pickling, hot forged C1, C3 and C4 fasteners shall be soft annealed to the softest condition and shot-peened in order to reduce the risk of hydrogen embrittlement. For fasteners manufactured from soft annealed and ground C1, C3 and C4 raw material only a shot peening may be necessary.

<sup>c</sup> If necessary, values outside the specified ranges are permitted in adjusting the acid concentration, temperature and exposure time.

## 4.2 Passivation process

After pickling, the fastener shall be passivated in a bath selected from those listed in Table 2.

**Table 2 — Passivation baths**

Steel grade <sup>a</sup>	Chemicals	Concentration volume %	Temperature °C	Typical exposure time min
A2, A3, A4, A5 C1 F1	HNO <sub>3</sub>	20 to 50	20 to 40	10 to 30
A1 C4	HNO <sub>3</sub> <sup>b</sup>	25 to 35	15 to 40	
A1	HNO <sub>3</sub> + Na <sub>2</sub> Cr <sub>2</sub> O <sub>7</sub> ·2H <sub>2</sub> O <sup>c</sup>	15 to 25		
C4	HNO <sub>3</sub> + Na <sub>2</sub> Cr <sub>2</sub> O <sub>7</sub> ·2H <sub>2</sub> O <sup>c</sup>	2 to 6		
<sup>a</sup> Steel grades in accordance with ISO 3506-1, ISO 3506-2, ISO 3506-3 and ISO 3506-4. <sup>b</sup> Use preferably this bath. <sup>c</sup> The addition of Na <sub>2</sub> Cr <sub>2</sub> O <sub>7</sub> ·2H <sub>2</sub> O may be used to minimize the discoloration or etching of high carbon and free-cutting stainless steels.				

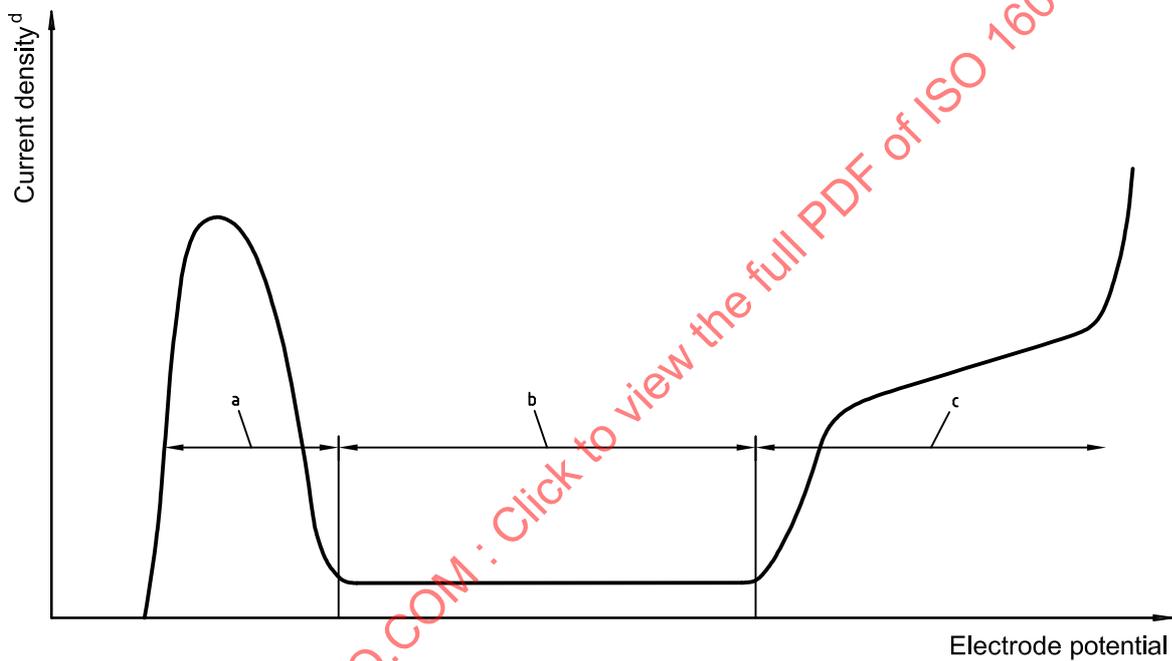
## 5 Verification of passivation

Passivation shall be verified by the manufacturer's quality assurance system. There is no known referee test method for passivation.

## Annex A (informative)

### Passivity

Figure A.1 schematically illustrates the typical behaviour of an active-passive-transpassive metal. The metal initially demonstrates behaviour similar to non-passivating metals, i.e., as the electrode potential is made more positive, the metal follows typical Tafel behaviour, and dissolution rate increases exponentially. This is the active region. At more noble potentials, dissolution rate decreases to a very small value and remains essentially independent of potential over a considerable potential region. This is termed the passive region. Finally, at very noble potentials, dissolution rate again increases with increasing potential in the transpassive region.



- a Active
- b Passive
- c Transpassive
- d Logarithmic scale

**Figure A.1 — Typical anodic dissolution behaviour of an active-passive-transpassive metal**