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Topic: Evaluating Stainless Steel Bare Floors

Please read carefully before performing work or unpacking any further

Required Materials

- None

Required Tools

- Calipers
- Clamp-on Ammeter

Most materials are sacrificial when used as an anode in an aqueous solution. Knowing this, it is important to estimate the eventual replacement period in order to prepare a maintenance budget. The purpose of this bulletin is to assist with the planning and implementation of a sampling program. For most ED systems there is some symmetry. Bare floor Stainless Steel Electrodes are arrayed down the bottom of the ED bath and the ware passes over them.

Please read all the instructions listed below to familiarize yourself with the project before attempting to perform any of the work.

There are two easy ways to determine when to change out Bare Floors.

1. One way to check your bare anode is to check the current. If the bare floor shows zero current (with load) and if there is no damage to the wire then it needs to be replaced.
2. The other way to check is to measure the OD (try to clean off any paint at the points where it is to be measured). If the electrode loses 60% of the outside diameter then its time to replace. Measure 4" away from both pvc ends and in the middle. Measure at 12, 3, 6 and 9 o'clock position to come up with average.
3. The attached chart (316L Stainless Steel OD Replacement Chart) shows what the OD will be when 60% of the original wall thickness is lost. You may want to use this as a threshold value that once an

Electrode is at this OD, it needs to be replaced within the next 3 – 6 months time frame.

Electrode Type	New	When to Replace
2" Schedule 80	2.375" OD	2.1" OD
1-1/2" Schedule 80	1.9" OD	1.66" OD

For more information see the original manual that came with the equipment or call UFS at the phone number shown on the first page.