



Damstahl®

stainless steel solutions

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SUPER DAIRY®

– Reducing the Risk of Corrosion and Bacterial Growth

The Damstahl SUPER DAIRY Tubes are the ideal solution for critical applications. By using a specific welding method followed by a chemical post-treatment, the risk of subsequent corrosion and bacterial growth has been minimized.

Compared to common tubes, the heat tinting and discoloration have been reduced markedly. In addition, the reduced surface roughness of the main surface and the welds alike minimizes the risk of impurities sticking to the surface.

Advantages:

- Reduced risk of corrosion and bacterial growth
- Improved welding properties
- Reduced surface roughness (Ra)
- Both ends are sealed off to avoid pollution
- Improved life span – the right solution at the first attempt



SUPER DAIRY Tubes – Increasing the Performance

Reduced Risk of Crevice Formation

Traditionally, dairy tubes are made by laser welding, an excellent process which, in most cases, produces a fine result. However, laser welding requires an extremely fine cutting and subsequent correction of the coil. Otherwise, any lack of binding in between the weld and the base metal may cause the formation of crevices and, apart from inducing a greater risk of crevice corrosion, such defects may act as growth sites for bacteria.

When manufacturing the Damstahl SUPER DAIRY Tubes, only TIG welding is used. TIG is a slower process than laser. However, it is better for “absorbing” the defects from the possible non-ideal cutting and correction of the coil. Thereby, the risk of critical crevices is significantly reduced.

Pickling Increases the Corrosion Resistance

Heat tinting and impurities are both known to reduce the corrosion resistance and increase the risk of bacterial growth, and, ideally, the mechanical manufacturing should be followed by an appropriate chemical post-treatment. To cope with that, all Damstahl SUPER DAIRY Tubes have been subject to a final pickling. This pickle is carried out in a nitric acid / hydrofluoric acid solution capable of removing all heat tinting and impurities.

Along with the welding process, this ensures a maximum corrosion resistance and a minimum risk of bacterial growth. To maintain this and to avoid pollution by impurities during transportation or handling, all Damstahl SUPER DAIRY Tubes have been sealed off in both ends immediately after the final drying process.

Surface Finish and Supply

When dealing with food and pharmaceutical products, the surface roughness is of utmost importance. Therefore, the surface roughness of the Damstahl SUPER DAIRY Tubes is guaranteed not to exceed Ra 0.4 µm, measured on the “free surface” and 0.8 µm on the welds.

Long Life-Span

The quality of the steel, along with the manufacturing, ensures the Damstahl SUPER DAIRY Tubes the optimal corrosion resistance. You get the right solution at the first attempt and the equipment benefits from visually attractive tubes with the optimal corrosion resistance and the optimal life-span. The risk of break-downs and expensive repairs is reduced, and in the end your bottom line result is improved.

For further information regarding the Damstahl SUPER DAIRY Tubes, please see www.damstahl.dk or contact Brian Sejr, phone: +45 8794 4041, bs@damstahl.com

SUPER DAIRY	
Inside bead rolled, not annealed, double pickled, inside Ra max 0.4 µm, Welding bead Ra max 0.8 µm, tube ends with caps	
Tolerance: EN/ISO 1127 D4/T3, EN 10217-7, class 1	
L: 6.000 mm -0/+50 mm	
Certificate: EN 10204/3.1	

Dimension	Kg/m	EN 1.4404 Not polished	EN 1.4404 Polished Gr. 180/220
		Article no.	Article no.
25,0 x 1,20	0,72	33442	33449
38,0 x 1,20	1,11	33443	33450
51,0 x 1,20	1,50	33444	33451
63,5 x 1,50	2,33	33445	33452
76,1 x 1,60	2,99	33446	33453
76,1 x 2,00	3,71	33447	33454
101,6 x 2,00	4,99	33448	33455