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2,940,867

IMMERSION TIN PLATING AND COMPOSITION THEREFORE

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This invention relates to the immersion deposition of tin and is more particularly directed to processes and compositions useful for applying tin coatings to selected areas of steel sheets so that such areas can be soldered.

I have found that tin can be deposited on steel articles by immersion in an aqueous solution of stannous sulfate, sodium bisulfate, and a polyalkylene oxide. Sheet steel such as that used for making "tin cans" can be prepared for soldering by mechanically roughening selected areas which it will later be desired to solder and then immersing such sheet into the solutions of the invention to obtain a tin coating on the roughened areas.

According to the invention, a steel sheet is first roughened mechanically. This mechanical treatment is required in order to obtain deposition of tin and only those areas which have been roughened will receive tin using the baths which will hereafter be described.

The mechanical roughening can be effected in any convenient way as by sanding, scraping, or grinding with abrasive materials. Much preferred is grinding with an abrasive which will leave the surface roughened without excessive removal of metal. Preferably the surface can be roughened as with an 80-grit sanding belt or its equivalent. Obviously considerable variation is permissible in the grit depending upon the surface to be treated and the speed of travel of a sanding belt or grinding wheel.

The surfaces to be coated with tin according to the invention should be clean in accordance with customary practices. They can be cleaned prior to roughening or after roughening. The surfaces can be cleaned using any conventional degreasing cleaning system followed by a conventional alkali cleaning. It is to be noted that if the surface is cleaned prior to mechanical roughening, then after such roughening any dust or grit remaining on the sheet should be removed by brushing or blowing.

If the immersion deposition of tin is to be effected at a rapid rate, which is a very desirable practice in the coating of sheet to be used in making "tin" cans, then the sheet ought to be preheated. This can be done by passing it through a hot water bath, by ending the cleaning cycle with a hot rinse, or of course the sheet can simply be passed through an area appropriately heated by dry heat.

The aqueous solutions employed according to the invention contain sodium bisulfate and stannous sulfate.

While the proportions of the sodium bisulfate and stannous sulfate can be considerably varied it has been found for best results the solution can contain:

	G./l
Sodium bisulfate	100-250
Stannous sulfate	10-40
Water, 1 liter.	

The amount of water can be considerably varied but the proportions shown will be found very satisfactory.

If the proportion of sodium bisulfate is lowered or raised much below the figure shown, the rate of deposi-

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tion will fall off so that the process becomes undesirably slow. About the same consequences result from raising or lowering the stannous sulfate content.

In addition to the components shown the composition must contain an "organic addition agent." The addition agent should be of the type shown in the Hoffman U.S. Patent 2,457,152. Any of the substituted or unsubstituted polyalkylene oxide addition agents there described can be employed, the amount in the above composition being 30-100 g./l. If more or less than the amount shown is used the effect on deposition rate will not be as great as may be desired.

In addition to the polyalkylene oxide addition agents described in the Hoffman patent and in the references therein cited there can be used any of a number of more recently developed substituted or unsubstituted polyalkylene oxides of the same type. These will include an unsubstituted polyethylene oxide (now often called a polyethylene glycol) having a molecular weight ranging up from about 350 and will also include unsubstituted polyethylene oxides having molecular weights as high as 20,000.

Broadly there may be used any of the agents of the types described in the said Hoffman patent, but it is more specifically preferred to use an unsubstituted polyethylene oxide having a molecular weight between 350 and 20,000. It is still more preferred to use an unsubstituted polyethylene oxide having a molecular weight between 6000 and 7500. It is most preferred to use an unsubstituted polyethylene oxide having a molecular weight of about 6000.

A detailed description of the substituted and unsubstituted polyalkylene oxides of the Hoffman patent will be found therein and need not be repeated in detail. The disclosure of the said patent is incorporated here by reference.

Preferred compositions of the invention are dry, or pasty, products containing an appropriate mixture of sodium bisulfate with stannous sulfate and a polyalkylene oxide addition agent.

A preferred dry composition to be sold and to be used after dissolving in water is as follows:

	Parts by weight
Stannous sulfate	1-4
Sodium bisulfate	10-25
Unsubstituted polyethylene oxide having a molecular weight of about 6000	3-10

In use a customer can dissolve the dry, or pasty, products prepared as just above described in an appropriate amount of water. Alternatively a user can simply make the bath up at the point of use by dissolving the required ingredients in water. It is preferred to make a bath as above generally described and preferably of about the following composition:

	G./l.
Water, sufficient to make 1 liter total.	
Sodium bisulfate	100-250
Stannous sulfate	10-40
Unsubstituted polyethylene oxide having a molecular weight of about 6000	30-100

In processes of the invention a strip of steel will ordinarily be roughened on the surfaces to be plated and a solution as described will be applied. This can be done by immersing the surface or the whole sheet in the solution to effect deposition without the application of an external electric current. Whichever is done, the tin will deposit only on the roughened areas so that the remainder of the sheet will not be coated. The solution can be applied in any other similar fashion as by flowing the solution on the strip, by spraying, and so forth,

The treating solutions of the invention should be used at elevated temperatures and temperatures that are near to the boiling point will be used in practice. As has been noted earlier, the strip should also be treated so that there will be no undue cooling of the solution in use.

After a tin coating has been applied, the strip can be handled in conventional manner, rinsing off excess solution, drying, forming the strip and then soldering joints in conventional manner to form a "tin" can. The can will thereafter be enameled or otherwise treated in accordance with standard practices.

It will be seen that by coating only the edges or other selected areas of the strip it is possible to form cans which have tin only at the soldered joints. There need be no waste of tin and there need be no tin present where it would not be wanted.

In order that the invention may be better understood reference should be had to the following illustrative examples.

Example 1

Steel strip to be made into cans was first cleaned in the following sequence. It was first roughened on the areas to be plated by grinding with an abrasive belt. In this particular case, the roughening was on opposite sides at the two edges, these sides being those which would be in contact in soldering of the side-seams of the can. The abrasive belt carried an 80-grit abrasive. After roughening the edges, the sheet was degreased in an organic solvent in conventional manner and dried in warm air.

The strip was then pre-heated in boiling water.

The strip was then immersed in a solution with the following components in the proportions shown:

	G./l.
Water, sufficient to make 1 liter total.	
Stannous sulfate	10
Sodium bisulfate	100
Polyethylene oxide 520-600 molecular weight	27

The solution was at the boiling point. The strip was in contact with the bath for 5 minutes and received a satisfactory coat of tin on the roughened surfaces, the deposit amounting to 76.7 mg. tin per sq. dm. There was no tin deposition on other areas.

The strip was then rinsed in weak sodium hydroxide solution (0.01 N). The strip was thereafter rinsed in warm water and dried.

The strip thereafter can be soldered readily to form a "tin" can.

Example 2

A procedure was followed as in Example 1 except that instead of polyethylene oxide above described there was used a polyethylene oxide of molecular weight 6000 in the same amount by weight.

Following all of the conditions as shown above there was obtained a strip satisfactorily treated with tin only on its roughened surfaces and suitable for soldering to form a can.

Depending upon the amount of tin wanted on the strip the immersion time can be increased or lowered. Thus at the following immersion times the results obtained are as shown.

Immersion time—	Mg. Sn/sq. dm.
5 sec.	10.5
15 sec.	20.4
30 sec.	34.8
1 min.	46.7
2 min.	89.7
5 min.	182.0

In the above examples other stannous compounds such as the hydroxy acetate, oxalate and sulfamate can be used instead of the sulfate in an amount to provide an equivalent quantity of tin, all other conditions remaining as

shown, but with much lesser amounts of deposition with each solution.

Example 3

A procedure was followed as in Example 1 except that instead of the liquid polyethylene oxide there described there was used the same amount by weight of solid polyethylene oxide of 15,000-20,000 molecular weight. The results were the same as those in Example 1, except that the deposition rate was increased so that 121-128 mg./sq. dm. deposited in 5 minutes.

I claim:

1. A composition to be dissolved in water for immersion tin coating consisting essentially of:

	Parts by weight
Stannous sulfate	1-4
Sodium bisulfate	10-25
Unsubstituted polyethylene oxide having a molecular weight of about 6000	3-10

2. An aqueous bath for immersion tin coating consisting essentially of the following in the proportions tabulated:

	G./l.
Sodium bisulfate	100-250
Stannous sulfate	10-40
Unsubstituted polyethylene oxide having a molecular weight of about 6000	30-100
Water, sufficient to make 1 liter total.	

3. A composition to be dissolved in water for immersion tin coating consisting essentially of:

	Parts by weight
Stannous sulfate	1-4
Sodium bisulfate	10-25
Polyalkylene oxide of molecular weight from 350 to 20,000	3-10

4. An aqueous bath for immersion tin coating consisting essentially of the following in the proportions tabulated:

	G./l.
Sodium bisulfate	100-250
Stannous sulfate	10-40
Polyalkylene oxide of molecular weight from 350 to 20,000	30-100
Water, sufficient to make 1 liter total.	

5. A composition to be dissolved in water for immersion tin coating consisting essentially of:

	Parts by weight
Stannous sulfate	1-4
Sodium bisulfate	10-25
Unsubstituted polyethylene oxide with a molecular weight between 350 and 9000	3-10

6. An aqueous bath for immersion tin coating consisting essentially of the following in the proportions tabulated:

	G./l.
Sodium bisulfate	100-250
Stannous sulfate	10-40
Unsubstituted polyethylene oxide with a molecular weight between 350 and 9000	30-100
Water, sufficient to make 1 liter total.	

7. In a process for depositing tin on a selected area of a steel sheet the steps comprising mechanically roughening such area and applying thereto an aqueous bath consisting essentially of the following proportions of:

	G./l.
Stannous sulfate	10-40
Sodium bisulfate	100-250
Unsubstituted polyethylene oxide having a molecular weight of about 6000	30-100
Water, sufficient to make 1 liter total.	

8. In a process for depositing tin on a selected area of a steel sheet the steps comprising mechanically roughening such area and applying thereto an aqueous bath consisting essentially of the following proportions of:

Stannous sulfate	G./l.	
Sodium bisulfate	10-40	
Polyalkylene oxide of molecular weight from	100-250	
350 to 20,000	30-100	10
Water, sufficient to make 1 liter total.		

9. In a process for depositing tin on a selected area of a steel sheet the steps comprising mechanically roughening such area and applying thereto an aqueous bath consisting essentially of the following proportions of:

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Stannous sulfate	G./l.	
Sodium bisulfate	10-40	
Unsubstituted polyethylene oxide with a molecular weight between 350 and 9000	100-250	
Water, sufficient to make 1 liter total.	30-100	5

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