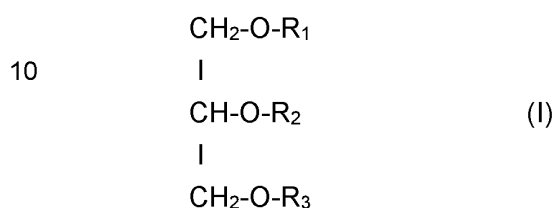


CLAIMS

5 1. A composition comprising

- water; and
- at least one water-soluble polyalkylene glycol of the formula (I)



15 wherein independently of each other

- R₁ is -(C₃H₆O)_{x1} -(C₂H₄O)_{y1} -(C₃H₆O)_{z1}-H;
 - R₂ is -(C₃H₆O)_{x2} -(C₂H₄O)_{y2} -(C₃H₆O)_{z2}-H; and
 - R₃ is -(C₃H₆O)_{x3} -(C₂H₄O)_{y3} -(C₃H₆O)_{z3}-H;
- and

- 20 - x₁, x₂ and x₃ are independently of each other a number of 0 to 6;
 - y₁, y₂ and y₃ are independently of each other a number of 0 to 40; and
 - z₁, z₂ and z₃ are independently of each other a number of 0 to 32;
- and
- x₁+x₂+x₃ has an average value of from 1 to 4;
 - 25 - y₁+y₂+y₃ has an average value of from 2 to 30; and
 - z₁+z₂+z₃ has an average value of from 1 to 25.

2. The composition according to claim 1, wherein independent of each other

- x₁+x₂+x₃ has an average value of 1.8 to 2.2;
- 30 - y₁+y₂+y₃ has an average value of 2 to 10, preferably 6.5 to 7.5; and/or
- z₁+z₂+z₃ has an average value of from 1 to 20, preferably, 2 to 12, and more preferably 3 to 10.

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3. The composition according to any of the preceding claims, wherein the water-soluble polyalkylene glycol of formula (I) has independent of each other one or more of the following properties:

- a pour point according to GB/T 3535 of below -30° C;
- 5 - a hydroxyl number according to GB/T 7383 of 100 to 300 mg KOH/g, preferably 150 to 270 mg KOH/g;
- a kinematic viscosity at 25° C according to GB/T 265 of below or equal to 1.500 cSt, preferably below 300 cSt;
- 10 - a kinematic viscosity at 40° C according to GB/T 265 of below or equal to 100 cSt;
- a kinematic viscosity at 100° C according to GB/T 265 of below or equal to 10 cSt;
- a water content equal to or below 0.5 wt.-%; and
- 15 - a molecular weight between 600 and 1.200 g/mol (number average).

4. The composition according to any of the preceding claims, comprising 30 to 85 wt.-% water.

5. The composition according to any of the preceding claims, comprising 5 to 30 wt.-% of the water-soluble polyalkylene glycol of formula (I).

6. The composition according to any of the preceding claims, further comprising at least one alkanolamine, preferably selected from the group consisting of monoethanolamine, triethanolamine and monoisopropanolamine, and more preferably 5 to 25 wt.-% of the at least one alkanolamine.

7. The composition according to any of the preceding claims, further comprising a carboxylic acid, preferably a C6 to C16 mono- or di- carboxylic acid and most preferably isononanoic acid, 2-butyloctanoic acid, neodecanoic acid and independent thereof 0.1 to 15 wt.%, preferably 0.5 to 10 wt.% of the carboxylic acid.

8. The composition according to any of claims 1 to 6, wherein the composition comprises no C6 to C16 mono- or di-carboxylic acid.

9. The composition according to any of the preceding claims, comprising 0.1 to 0.5 wt.-% of aminoacetic acid sodium salts, preferably tetra sodium EDTA (ethylenediaminetetraacetic acid), and/or 0.1 to 0.5 wt.-% of at least one biocide, in particular at least one fungicide.

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10. The composition according to any of the preceding claims, wherein the composition has a pH-value between 7 and 10, preferably between 8 and 10, at 25° C.

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11. The composition according to any of the preceding claims, wherein the composition has a surface tension of equal to or below 60 mN/m.

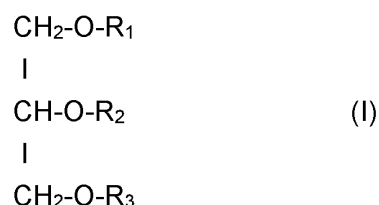
12. The composition according to any of the preceding claims, wherein the composition has a contact angle on a metal surface of equal to or below 90°.

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13. Use of the composition according to any of the preceding claims as a metalworking fluid.

14. Use of a water-soluble polyalkylene glycol of the formula (I)

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wherein independently of each other

- R₁ is -(C₃H₆O)_{x1} -(C₂H₄O)_{y1} -(C₃H₆O)_{z1}-H;

- R₂ is -(C₃H₆O)_{x2} -(C₂H₄O)_{y2} -(C₃H₆O)_{z2}-H; and

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- R₃ is -(C₃H₆O)_{x3} -(C₂H₄O)_{y3} -(C₃H₆O)_{z3}-H;

and

- x₁, x₂ and x₃ are independently of each other a number of 0 to 6;

- y₁, y₂ and y₃ are independently of each other a number of 0 to 40; and

- z₁, z₂ and z₃ are independently of each other a number of 0 to 32;

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and

- $x_1+x_2+x_3$ has an average value of from 1 to 4;
- $y_1+y_2+y_3$ has an average value of from 2 to 30; and
- $z_1+z_2+z_3$ has an average value of from 1 to 25;

as a base oil in a metalworking fluid.

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15. The use according to claim 14, wherein the base oil reduces the surface tension of the metalworking fluid to 60 mN/m and below and/or the contact angle on a metal surface to 90° and below.