

PRODUCT DESCRIPTION

One-component, epoxy ester, fast drying, anticorrosive zinc-rich coating.

FEATURE

Provide:

- cathodic (galvanic), active electrochemical protection on the whole surface and the film thickness;
- provides maximum underlying corrosion protection;
- contain 88% of zinc by weight in dry film with particle size 3-5 microns.

RECOMMENDED TO USE

Steel surfaces:

- for structures in medium, high, very high and extreme atmospheric corrosivity categories (C3, C4, C5 and CX - ISO-12944-2 / 2018);
- for structures immersed in fresh, sea or brackish water compatible with cathodic protection as well (Im1; Im2 and Im4 - ISO-12944-2 / 2018).
- It used as cold galvanizing.

COMPATIBLE COATINGS

Depending on the operating conditions the material can be used with different types of coatings.

For details, please contact Welesgard Technical Sales Support.

TECHNICAL DATA

Appearance	
Color:	Grey
Appearance:	Matt
Material properties	
Volume solids:	50 ± 2 %
Density (at +20 °C):	2.45 ± 0.15 g/cm ³
VOC value:	440 g/l
Adhesion: (ASTM D4541)	>5 MPa

SURFACE PREPARATION

Surface	Minimum	Recommended
Surface Profile	Ry5 (30–75 мкм) (ISO 8503-1)	Ry5 (30–75 мкм) (ISO 8503-1)
Steel surfaces	St 2½ (ISO 8501-1)	Sa 2½ (ISO 8501-1)

AMBIENT CONDITIONS

Air temperature:	from +5 to +45°C
Surface temperature:	from +5 to +45°C
Relative humidity: (max)	85 %
Dew Point:	at least 3°C higher than steel temperature

Note: - Do not apply the material during rain or snow, or if precipitation is expected before the applied coating becomes dry to the touch.

- Temperature of the product is recommended within +15 to +25°C.

For details, please contact Welesgard Technical Sales Support.

THICKNESS & THEORETICAL SPREADING RATE

	Min.	Medium	Max.
Dry Film Thickness:	50 µm	70 µm	100 µm
Wet Film Thickness:	100 µm	140 µm	200 µm
Spreading Rate:	10 m ² /l	7 m ² /l	5 m ² /l

Note: The practical consumption depends on the application conditions, the complexity of the painted structure, the surface roughness and the application method.

DRYING TIME

For DFT of 100 µm	25 °C
Dry to touch	30 min
Recoat with itself or 1pack PUR, min	1 hour
Cure for service	10 days

Note: - There is no limit on the maximum recoating interval if the surface is clean.

- Drying and curing time determined at controlled temperature and relative humidity (RH) 60 - 80%.

- The relative humidity, temperature, ventilation conditions and film thickness will affect the curing and polymerization times.

For details, please contact Welesgard Technical Sales Support.

APPLICATION DATA**Stirring:**

It is a single pack ready to use material. Prior to use, it must be thoroughly stirred with a low speed mixer, avoiding air entrapment.

The material should be stirred every 20 minutes.

Before opening and stirring the temperature of material must be at least 3°C above the dew point.

Thinning:

The addition of thinner is usually not necessary. If necessary WG-Welethinner or WG-Welethinner CC can be added up to 10 % to the volume.

Note: If other than recommended thinners are used the manufacturer is not responsible for deterioration of coating quality.

Cleaning:

After work all equipment shall be cleaned with the thinner WG-Welethinner or WG-Welethinner CC.

For details, please contact Welesgard Technical Sales Support.

APPLICATION METHODS**Spraying:**

Airless spray application is recommended. For other spraying methods, viscosity adjustment may be necessary.

Brush:

Recommended for stripe coat application or minor repair touch-up only.

Roller:

Prohibited to use roller for application of priming coat. Roller could be used to build up the dry film thickness.

PACKAGING

Volume (liters)	Size of containers (liters)
10	10

STORAGE & SHELF LIFE

The product must be stored in original sealed containers. The storage conditions are to keep the containers in a dry, well ventilated space away from source of heat and/or ignition.

Storage temperature:	from 5 to 30 °C
Shelf Life	12 months

Note: After lasting storage primer shall be stirred thoroughly until its precipitation is spread over the suspension homogeneously. Precipitation in primer does not change its properties or worsen its quality.

After the expiration date has passed, it is necessary to check the quality of the paint material.

SAFETY

Use with adequate ventilation. Do not inhale aerosol. Avoid contact with skin. After contact with skin, wash immediately with detergent, soap and water. In case of contact with eyes, rinse immediately with water and seek medical advice immediately.

For detailed information on the health and safety protection for use of this product, see Safety Data Sheet (SDS).

IMPORTANT NOTE

The above-mentioned information is given according to our laboratory tests and practical application experience. The manufacturer takes into consideration the fact that the material can be used out of control; the manufacturer cannot give guarantees except of the material quality. The manufacturer has the right to improve the product and change the above-mentioned data without preliminary notification.

THE PRESENT TECHNICAL DATA SHEET REPLACES ALL PREVIOUS EDITIONS.