

PRODUCT DESCRIPTION

Single pack quickly-drying shop-primer for temporary protection of steel based on combination of binders and mix complex of zinc pigment (of spherical and platelet shape) for improving anticorrosive properties.

FEATURE

- Shop-primer allows welding without removing it.
- Ensures temporary protection of steel for a period of 3 years.
- Could be over-coated with most types of the paints.
- No limitation to the maximum interval for the next coat application.

(For compatibility of coatings, please contact Welesgard technical department.)

RECOMMENDED TO USE

Recommended to be used as shop-primer to protect steel plates after abrasive blast cleaning, including automatic shot-blasting line, during the transportation, storage, and assembly.

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: | 25±2 % |
| Density (at +20°C): | 1.13 ± 0.02 kg/ltr |
| VOC value: | 660 g/l |
| Dry heat resistance (ASTM D2485) | 120°C |

SURFACE PREPARATION

Preliminary surface preparation:

All solid contamination that could prevent adhesion should be removed from the surfaces. Remove salts and other water soluble contamination by wet cleaning with brush, high pressure-, steam- or alkali cleaning.

Remove grease and oils by alkali-, emulsion- or solvent cleaning (ISO 8504-3, ISO 12944-4). After cleaning with detergents, rinse thoroughly with water.

Steel Substrates

Blast cleaning to minimum Sa 2½ (ISO 8501-1, ISO 8504-2).

Surface profile:

The surface profile must conform to "fine" or "medium" according to ISO 8503-1 (30-75 microns Ry5).

AMBIENT CONDITIONS

| | |
|-----------------------------|--|
| Air temperature: | from +15 °C to +55°C |
| Surface temperature: | from +15 °C to +55°C |
| Paint Material temperature: | +15 °C |
| Relative humidity, below: | 85% |
| Dew Point: | at least 3°C higher than steel temperature |

THICKNESS & THEORETICAL SPREADING RATE

| | Min. | Med. | Max. |
|---------------------|------------------------|------------------------|------------------------|
| Dry Film Thickness: | 15 µm | 20 µm | 25 µm |
| Wet Film Thickness: | 60 µm | 80 µm | 100 µm |
| Spreading Rate: | 16.7 m ² /l | 12.5 m ² /l | 10.0 m ² /l |

Note: Practical coverage depends on wind conditions, type of structure to be painted, roughness of the surface and application method.

DRYING TIME

At a temperature of +23°C and DFT 20 µm :

| | |
|--------------------|-----------|
| Dry to touch | 3-5 min |
| Dried to transport | 10-15 min |

APPLICATION DATA

Stirring:

It's a single pack material, which shall be stirred thoroughly before application with mechanical mixer in order to achieve its fully homogeneous condition.

Thinning:

The painting material is diluted depending on the spray equipment with the solvent **WG-Welethinner SP** according to the table below:

Note: Prohibited to use other thinner than recommended ones.

Cleaning:

After work all equipment shall be cleaned with the thinner WG-Welethinner or WG-Welethinner CC. In case the above-mentioned thinner are not available the following solution can be used: xylene; MEK; xylene and MEK mixed 1:1.

Airless spray is the main method of application. As alternative the conventional spray method of applications are suitable as well.

Airless application recommendations:

| | |
|----------------|--|
| Pressure | 12-20 MPa |
| Nozzle orifice | 0,011-0,021" |
| Spray angle | Depended on structure type |
| Filter | To provide filter cleanliness. Filter Size - 60 mesh (250µm). |

Brush:

Recommended for minor repair or touch-up only.

Roller:

Prohibited to use roller for repair or touch-up.

PACKAGING

| WG-Ferrogalvanic SP | Volume (liters) | Size of containers (liters) |
|---------------------|-----------------|-----------------------------|
| | 10/12 | 10/12 |

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 ignition.

| | |
|----------------------|------------------|
| Storage temperature: | from 5°C to 30°C |
| Shelf Life | 18 months |

Note: Precipitation in primer does not change its properties or worsen its quality. After lasting storage primer shall be stirred thoroughly until its precipitation is spread over the suspension homogeneously. 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. Eyes rinse with water immediately and call a doctor.

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.