

PRODUCT DESCRIPTION

One-component very fast drying, modified acrylic based anti-corrosion primer.

FEATURE

- Dries at temperatures below the freezing point, down to -10 °C.
- Can be over coated with alkyd-, acryl- and polyurethane paints.

RECOMMENDED TO USE

Recommended to use as a primer in protection systems on:

- steel-, cast iron-, aluminium- and galvanized steel surfaces;
- environment classes C2-C4 and C5-M on blast cleaned steel surfaces (ISO-12944-2).

It is recommended for use on structural steel, machinery, pipes and tank exteriors, bridges, ship hulls and -equipment. In field conditions it can be used as a fast drying primer / repair paint in alkyd-, acryl- and polyurethane systems.

COMPATIBLE COATINGS

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

Primer:

- WG-WELLPRIMER AK;

Topcoat:

- WG-WELLCOVER AK;
- WG-WELEFLEX AK;
- WG-SULACOVER AK;
- Polyurethane coatings WG-Sulacover 2K series.

For details, please contact Welesgard Technical Sales Support.

TECHNICAL DATA

Appearance	
Color:	Oxide red, grey*
Appearance:	Matt coating
Material properties	
Volume solids:	43 ± 2 %
Total mass of solids:	880 g/l
VOC value:	480 g/l

Note: *limited number of other colours.

SURFACE PREPARATION

Preliminary surface preparation:

All solid contamination that could prevent adhesion should be removed from the old 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). The surfaces should be rinsed carefully with fresh water after cleaning. Old, painted surfaces, in which maximum overcoating interval has expired, additional roughening with suitable method is recommended.

Steel and cast iron surfaces:

Blast cleaning to min Sa 2½ (ISO 8501-1, ISO 8504-2). Cold rolled surfaces should be cleaned to a grade St2.

Surface profile:

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

Shop-primed surfaces:

Damaged or corroded surfaces should be blast cleaned to a minimum of Sa 2½. Undamaged surfaces should be washed (SFS-ISO 8501-2, SFS-EN ISO 12944-4).

Aluminum surfaces:

Remove grease, anodizing residues and other contaminants. Clean surface must be rubbed down. Cast aluminum surfaces must be washed before painting. Sand-sweeping before painting improves adhesion.

Hot dip galvanized and Zinc surfaces:

Remove zinc salts and other contaminants by sand brushing. Grease and oils should be removed by alkali emulsion or solvent cleansing. Washing with an ammonia solution (5 %) followed by fresh water hosing.

**AMBIENT
CONDITIONS**

Air temperature:	from -10 to +50 °C
Surface temperature:	from -10 to +50 °C
Paint Material temperature:	+10 °C
Relative humidity:	85 %
Dew Point:	at least 3°C higher than steel temperature

Note:

In order to ensure the best possible performance of the product, it is recommended that the paint is at room temperature before the application.

**THICKNESS &
THEORETICAL
SPREADING RATE**

	Min.	Mid.	Max.
Dry Film Thickness:	40 µm	60 µm	80 µm
Wet Film Thickness:	90 µm	140 µm	185 µm
Spreading Rate:	10.7 m ² /l	7.1 m ² /l	5.4 m ² /l

Note:

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

DRYING TIME

For DFT of 60 µm	23 °C
Dry to touch	10 min
Dried to handle	1 h
Dry to recoat	2 h

Note:

Drying time will be affected by humidity, temperature, ventilation conditions and the coating film thickness.

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.

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

Thinning:

No need to add the thinner, but if necessary WT-041 could be added from 5 to 10% by volume.

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

Cleaning:

WT-041

APPLICATION METHODS

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

Airless application recommendations:

Pressure	17 - 20 MPa
Nozzle orifice	0.013-0.018"
Spray angle	Depended on painting structure
Filter	To provide filter cleanliness. Filter Size – 60 mesh (250 µm).

Brush:

For touch-up, stripe coating and small areas only. It is necessary to provide a nominal coating thickness.

Roller:

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

PACKAGING

WG-Ferrogalvanic	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/or ignition.

Storage temperature:	from 5 to 30 °C
Shelf Life	3 years

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.