

## MAIN PRODUCT PROPERTIES

- Zinc- and butyl glycol-free 1C-AY Hydro topcoat for high-quality corrosion protection of hot-dip galvanised steel structures, e.g. girder masts, transforming stations of electric power supply companies
- Free of labelling, water hazard class WGK 1
- Formulation without toxic heavy metal compounds, SVHC substances, and PFAS
- With suitable base coats also as a top coat in multi-layered systems for steel constructions made of low-alloy steel

## PRODUCT DATA

### GEHOTEX-W18-Pure



W18P-E...

Micaceous iron ore colour shades  
(according to G+W colour chart)



#### Mixing ratio by weight

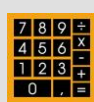
not relevant



Demineralised water or water of low hardness

### GEHOTEX-W18-Pure

### Guide values MIO-colours <sup>1)</sup>

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	<b>1.45</b>	<b>64.0</b>	<b>&lt; 4</b>	<b>48.0</b>	<b>330</b>
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup>	Spreading rate (m <sup>2</sup> /kg)
	<b>100</b>	<b>210</b>	<b>1.2</b>	<b>0.305</b>	<b>3.3</b>

1) Guide value averaged data, slight deviations are possible depending on the colour

2) Based on consumption in g/m<sup>2</sup> at DFT 10 µm

3) Theoretical consumption based on a smooth surface. Depending on the surface roughness and processing losses, different consumption data will be achieved in practice

## COMMENTS ON PROCESSING

Recommendation at  
temperatures  
of approx. 20 °C



Airless



High  
pressure



Roller/Brush  
application <sup>4)</sup>

<b>Nozzle diameter (mm)</b>	<b>0.38 to 0.53</b>	-	-
<b>Material pressure (bar)</b>	<b>200 to 300</b>	-	-
<b>Atomiser pressure (bar)</b>	-	-	-
<b>DFT * per working operation (µm)</b>	<b>120</b>	-	<b>50 to 70</b>
<b>Addition of thinner (%)</b>	<b>0 to 3</b>	-	-




\*) DFT = Dry film thickness

4) Recommended only for smaller areas,  
formation of a product-specific surface structure is possible

## PROCESSING INSTRUCTIONS



**Pot life**  
Not relevant

Drying/Curing times at 120 µm DFT		Ambient air temperature 20 °C
	dust-free:	after 45 to 60 minutes
	tack-free:	after 1.5 to 2 hours
	overcoating interval / dry to handle:	after 16 to 24 hours

### Notes referring to Directive 2004/42/EC "Decopaint-Directive"

Subcategory as referred to in Annex IIA	VOC limit values (Phase II from 2010)	Max. VOC content of the product in its ready-for-use condition (including the max. amount of diluents as given in "Application methods")
i ("One-pack performance coatings") Type WB	140 g/l	< 140 g/l

## INSTRUCTIONS FOR APPLICATION

### Surface preparation

#### Hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances, especially zinc salts, e. g. cleaning, washing, alkaline wetting agent washing, alternatively
- Sweep blast-cleaning according to EN ISO 12944-4  
The surface must have a uniformly dull appearance after surface preparation.

#### Optional priming coats (see below)

- Remove adhesion-reducing substances
- Before overcoating of other priming coats, compatibility tests are recommended



**Air and surface temperatures**  
10 to 40 °C




relative humidity ≤ 80 %  
dew point distance ≥ 3 °C  
Ensure sufficient air movement during drying


**PAINT SYSTEMS**

**EXAMPLES**

**Substrate: hot-dip galvanised steel in accordance with EN ISO 1461**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT (µm)</b>
	<b>Optional priming coat</b>	GEHOTEX-W180-Shopprimer	20
	<b>Monolayer</b>	GEHOTEX-W18-Pure	100

**Substrate: steel, blast-cleaning in surface preparation grade Sa 2 1/2, or mechanical respectively manual derusting PMA/St2, if applicable with old coating**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT (µm)</b>
	<b>Priming coats</b>	GEHOTEX-W5-Korrogrund	80
	<b>Top coat</b>	GEHOTEX-W18-Pure	50 to 70

**SAFETY MEASURES**



The relevant data can be found in the current material safety data sheets, available at [www.geholit-wiemer.de](http://www.geholit-wiemer.de).

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