


MAIN PRODUCT PROPERTIES

- 1C-AY Hydro Topcoat for high-grade corrosion protection of hot-dip galvanised steel constructions, e. g. girder masts, transforming stations of electric power supply companies
- Application in the shop by airless-spraying with nominal dry film thicknesses of 120 µm
- As on site coating by brush application with nominal dry film thicknesses of 50 to 70 µm, e.g. for touch-up work
- Together with suitable priming coats also as topcoat in multi-layered systems for steel constructions of low alloyed steel

PRODUCT DATA

GEHOTEX-W18	MIO-colours
	W18-E7833 Cement grey approx. RAL 7033 (other colours on request)
	Mixing ratio by weight not relevant
	Demineralised water or water of low hardness

GEHOTEX-W18	Guideline MIO-colours ¹⁾				
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	(mL/kg)
	1.45	64.0	< 4	48.0	330
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	120	250	1.2	0.365	2.7

1) Guideline averaged data, slight deviation are possible depending on the colour

2) Based on consumption in g/m² at DFT 10 µm

3) Theoretical consumption related on a smooth surface. Dependent on 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 ⁴⁾

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




*) DFT = Dry film thickness

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

COMMENTS ON PROCESSING



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	Max. VOC content of the product in its ready for use condition (including the max. amount of diluents as given in "Application methods")
	(Phase II from 2010)	
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 uniform 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 temperature
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

		Product(s) (other paint systems on request)	NDFT (μm)
	Optional priming coat	GEHOTEX-W180-Shopprimer	20
	Monolayer	GEHOTEX-W18	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

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

SAFETY MEASURES



The relevant data can be found in the current material safety data sheets, available at www.geholit-wiemer.de.

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