

TECHNICAL INFORMATION

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GEHOTEX-W23B

1C-AY Hydro Monolayer

MAIN PRODUCT-PROPERTIES

- 1C-AY Hydro Monolayer in particular for reconstruction of interior steel constructions, e. g. steel halls for production, logistics, automotive industry etc.
- Excellent adhesion on steel and hot-dip galvanised steel
- High compatibility with plenty of intact, sustainable old coatings
- Especially adjusted for the processing by roller coating respectively brush application of 50 to 70 µm
- At large-area damage of old coating, spotting with the optional priming coat GEHOTEX-W5-Korrogrund is recommended

PRODUCT DATA

GEHOTEX-W23B

RAL-colours, flat



W23B-F... (RAL-colours, other colours on request)



Mixing ratio by weight

not relevant



Demineralised water or water of low hardness

GEHOTEX-W23B		B Guid	Guideline RAL-colours 17			
7 8 9 ÷ 4 5 6 ×	Density (g/mL) 1.35	Solid content (weight %) 63.0	VOC-content (weight %) < 4	Solid conte (%) 50.0	ent by volume (mL/kg) 370	
0 , =	DFT * (μm) 60	Calculated wet-film thickness (μm)	VOC-content (g/m²) 2) 1.1	Consumption (kg/m²) 3) 0.165	Spreading rate (m²/kg) 6.1	

- 1) Guideline averaged data, slight deviation are possible depending on the colour
- 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
Nozzle diameter (mm)	0.35 to 0.53	-	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (μm)	60 to 100	-	50 to 70
Addition of thinner (%)	0 to 3	-	-

^{*)} DFT = Dry film thickness

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COMMENTS ON PROCESSING



Drying/Curing times at 60 μm DFT		Ambient air temperature 20 °C	
\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\	dust-free:	after 60 to 90 minutes	
*	tack-free:	after approx. 3 to 4 hours	
4	overcoating interval / dry to handle:	after 16 to 24 hours	

Notes referring to Directive 2004/42/EC "Decopaint-Directive"			
Subcategory as referred	VOC limit values	Max. VOC content of the product	
to in Annex IIA	(Phase II from 2010)	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

Steel surfaces with existing old coating

- Remove adhesion-reducing substances, e. g. cleaning, washing
- At partial corrosion: mechanical or manual derusting in preparation grade PMa respectively PSt 2 according to EN ISO 12944-4
- Before overcoating of old coatings compatibility tests are recommended

Weathered, hot-dip galvanised steel surfaces

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



Air and surface temperature

10 to 40 °C



relative humidity ≤ 80 % dew point distance ≥ 3 °C

Ensure sufficient air movement during drying

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PAINT SYSTEMS EXAMPLES

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½, mechanical or manual derusting St 2 in accordance with EN ISO 12944-4 if applicable with old coating

		Product(s) (other paint systems on request)	NDFT (μm)
4	Optional Priming coat	GEHOTEX-W5-Korrogrund	40 to 60
	Monolayer	GEHOTEX-W23B	50 to 70

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461, if applicable with old coating

		Product(s) (other paint systems on request)	NDFT (μm)
	Optional Priming coat	GEHOTEX-W5-Korrogrund	40 to 60
	Monolayer	GEHOTEX-W23B	50 to 70

Several coating systems according to EN ISO 12944-5 are possible. Please ask for our advice for your special application.

SAFETY MEASURES



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

The statements made here are based on the present state of our knowledge. We do not assume liability for damages resulting from the use of the material or from any advice given by our employees. In this respect, any advice given by our employees has to be seen as not binding. The processor is responsible for the supervision or construction, the maintaining of process guidelines and the observation of the established rules of techniques, even if our employees are present at the time our material is being applied.

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This information is subject to modifications due to technical improvements. The latest edition of this information replaces all previous issues.