

## MAIN PRODUCT PROPERTIES

- 1C-AY Hydro priming coat for high-grade corrosion protection of steel constructions and hot-dip galvanised steel constructions, e.g. girder masts, transformer stations of energy supply companies
- Coating preferably by brush application (DFT 60 to 80 µm)
- Excellent adhesion on hot-dip galvanised steel constructions and excellent corrosion protection on steel surfaces
- Labelling-free, water hazard class WHC 1

## PRODUCT DATA

### GEHOTEX-W45B-Korrogrund



W45B-309	Oxide red, approx. RAL 3009
W45B-812	Red brown, approx. RAL 8012
W45B-115	Light ivory, approx. RAL 1015 (other colours on request)



#### Mixing ratio by weight

Not relevant



Demineralised water or water with low hardness

### GEHOTEX-W45B-Korrogrund / Guide values <sup>1)</sup>

Calculator icon	Density (g/mL)	Solid content (weight %)	VOC content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	<b>1.4</b>	<b>66.0</b>	<b>&lt; 5</b>	<b>52.5</b>	<b>375</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>60</b>	<b>115</b>	<b>1.4</b>	<b>0.160</b>	<b>6.3</b>

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

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

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

## PROCESSING INSTRUCTIONS

Recommendation at temperatures of approx. 20 °C



Airless



High pressure



Roller/Brush Application

Application viscosity (s) (Epprecht, MKC 25 °C)	180 to 240		
Nozzle diameter (mm)	-	-	-
Material pressure (bar)	-	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (µm)	-	-	60 to 80
Addition of thinner (%)	-	-	-

\* DFT = Dry Film Thickness



**Pot life**

Not relevant

**Drying/Curing times at 60 µm DFT**

**Ambient air temperature 20 °C**



touch dry:

after approx. 60 minutes



tack free:

after approx. 120 minutes



ready for overcoating / handling:  
walkable:

after 3 hours  
after 48 hours

**Notes referring to Directive 2004/42/EG "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 diluent 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 and grey cast iron**

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4, alternatively
- Mechanical or manual derusting at preparation grade St 2 according to EN ISO 12944-4

**Hot-dip galvanised steel surfaces**

- Remove adhesion-reducing substances, particularly zinc salts

**Existing coatings**

- Remove adhesion-reducing substances, e.g. cleaning, washing
- Before overcoating of old coatings, compatibility tests are recommended



**Air and surface temperatures**


10 to 35 °C



Relative humidity ≤ 80 %  
Dew point distance ≥ 3 °C

**PAINT SYSTEMS**

**EXAMPLES**

		<b>Product(s)</b> (other paint systems on request)
	<b>Priming coat</b> (optional on galvanised substrate)	GEHOTEX-W45B-Korrogrund
	<b>Top coat</b>	GEHOTEX-W45B-DKX-Hydro

**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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