

MAIN PRODUCT-PROPERTIES

- 1-pack AY Hydro Priming coat for high-grade corrosion protection of steel and hot-dip galvanised steel constructions, e. g. girder masts, transforming stations from electric power supply companies
- Adjustment for brush application (DFT 40 to 60 μm)
- Excellent adhesion on galvanised steel parts and on mechanical respectively manual derusted steel surfaces with preparation grade PMA/St2 and on many old coatings
- Brush application is possible on firmly anchored residual rust

PRODUCT DATA

GEHOTEX-W5-Korrogrund



W5-102 Sand yellow approx. RAL 1002
W5-735 Light grey approx. RAL 7035 (other colours on request)
W5-812 Red brown approx. RAL 8012




Mixing ratio by weight
not relevant



Demineralised water or water of low hardness

GEHOTEX-W5-Korrogrund / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1.35	59,5	< 5	45.0	335
	DFT * (μm)	Calculated wet-film thickness (μm)	VOC-content (g/m^2) ²⁾	Consumption (kg/m^2) ³⁾	Spreading rate (m^2/kg)
	60	133	1.5	0.180	5.6

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

2) Based on consumption in g/m^2 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

Processing viscosity (mPas) Epprecht, MKC 25 °C	240 to 320		
Nozzle diameter (mm)	-	-	-
Material pressure (bar)	-	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (μm)	-	-	40 to 60
Addition of thinner (%)	-	-	-

* DFT = Dry Film Thickness



Pot life

not relevant

Drying/Curing times at 50 µm DFT

Ambient air temperature 20 °C



dust-free:

after approx. 45 minutes



tack-free:

after 1.5 to 2 hours



overcoating interval /
dry to handle:
dry to walk on:

after 3 hours
from 48 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 reactive performance coatings") Type WB	140 g/l	< 140 g/l

**INSTRUCTIONS
FOR APPLICATION**

Surface preparation

Steel surfaces

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

Weathered, hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances, particularly zinc salts, e. g. cleaning, washing, alkaline wetting agent washing, alternatively
- Sweep blast-cleaning according to EN ISO 12944-4.
After sweep blast-cleaning the surface shall have a uniform dull appearance.

Existing coatings

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



Air and surface temperature

10 to 35 °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 if applicable with old coating

		Product(s) (other paint systems on request)	NDFT (μm)
	Priming coat	GEHOTEX-W5-Korrogrund	40 to 60
	Top coats	GEHOTEX-W19B-DKX-Hydro WIEKORANT-A2B-DKX	80 to 120 120

Substrate: steel, mechanical or manual derusting PMa/St2 if applicable with old coating

		Product(s) (other paint systems on request)	NDFT (μm)
	Priming coat	GEHOTEX-W5-Korrogrund In 1 to 2 working operations	40 to 60 each
	Top coats	GEHOTEX-W19B-DKX-Hydro WIEKORANT-A2B-DKX	80 to 120 120

SAFETY MEASURES



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

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