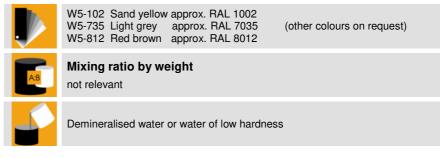


1-pack AY Hydro Priming coat for high-grade corrosion **MAIN PRODUCT**protection of steel and hot-dip galvanised steel constructions, PROPERTIES e. g. girder masts, transforming stations from electric power supply companies Adjustment for brush application (DFT 40 to 60 μm) Excellent adhesion on galvanised 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



GEHOTEX-W5-Korrogrund / Guideline¹⁾

7 8 9 + 4 5 6 × 1 2 3 + 0 , =	Density (g/mL) 1.35	Solid content (weight %) 59,5	VOC-content (weight %) < 5	Solid conte (%) 45.0	nt by volume (mL/kg) 335
	DFT * (µm) 60	Calculated wet-film thickness (μm) 133	VOC-content (g/m ²) ²⁾ 1.5	Consumption (kg/m ²) ³⁾ 0.180	Spreading rate (m²/kg) 5.6

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

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

Recommendation at

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

temperatures of approx. 20 °C			
	Airless		
Processing viscosity (mPas) Epprecht, MKC 25 °C			
Nozzle diameter (mm)	-		
Material pressure (bar)	-		

Hiah

pressure

Roller/Brush
nonci/Brush
application

		procedure	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

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Pot life not relevant

Drying/Curing times at 50 μm DFT		Ambient air temperature 20 °C
	dust-free:	after approx. 45 minutes
b	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	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 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, alcaline 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

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PAINT SYSTEMS

EXAMPLES

Substrate:	hot-dip galvanised steel in accordance with EN ISO 1461 if applicable with old coating
	in appricable inter ora 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.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.

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

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