

MAIN PRODUCT- PROPERTIES

- Overweldable 1-pack AY Hydro Prefabrication Primer for temporarily corrosion protection of steel parts
- Adjustment for an application in the shop in automatic painting lines according to EN 10238 by airless-spraying with nominal dry film thicknesses of 15 to 25 µm
- Report No. 9234071 "Testing of pore inclination" and "Gas detection test while overwelding" of SLV Duisburg as well as certificate WF 0790001 HH of Germanischen Lloyd are available
- Short-time temperature resistance up to 180 °C
- High compatibility with many suitable commercially available 1-pack and 2-pack coating materials

PRODUCT DATA

GEHOTEX-W80-FB-Hydro



W80-809 Redbrown (other colours on request)



Mixing ratio by weight

not relevant



Demineralised water

GEHOTEX-W80-FB-Hydro / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1.3	55.0	< 4	42.0	320
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	20	48	1.2	0.062	16.2

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



Airmix



High
pressure




	Airless	Airmix	High pressure
Processing viscosity (s) (4 mm DIN-cup)	20 to 25	20 to 25	20 to 25
Nozzle diameter (mm)	0.33 to 0.58	0.38 to 0.45	1.2 to 1.5
Material pressure (bar)	150 to 250	75 to 100	-
Atomiser pressure (bar)	-	3 to 4	3 to 4
DFT * per working operation (µm)	15 to 25	15 to 25	15 to 25
Addition of thinner (%)	3 to 5	3 to 5	3 to 5

*) DFT = Dry film thickness

COMMENTS ON PROCESSING



Pot life
Not relevant

Drying/Curing times at 20 µm DFT		Ambient air temperature 20 °C
	dust-free:	after 15 to 30 minutes
	tack-free:	after 30 to 45 minutes
	dry to handle: overcoating interval with 1C-paint: overcoating interval with 2C-paint:	after 3 to 4 hours after 6 hours after 5 days

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

Steel surfaces

- Sweep blast-cleaning according to EN ISO 12944-4 alternatively in industrial application areas
- Remove adhesion-reducing substances, e. g. cleaning, washing, phosphating



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: steel, blast-cleaning in surface preparation grade Sa 2 ½ in accordance with EN ISO 12944-4

		Product(s) (other paint systems on request)	NDFT (µm)
	Prefabrication Primer	GEHOTEX-W80-FB-Hydro	15 to 25
	Suitable Priming coats	GEHOLIT-K65-Metallgrund GEHOPON-E87-Metallgrund GEHOPON-E90R-Metallgrund GEHOTEX-W90-Metallgrund	80 to 100
	Suitable Monolayer	GEHOLIT-K65 GEHOTEX-W9 WIEREGEN-M15RN	80 to 100

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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