GEHOTEX-W92-Metallgrund

1C-AY Hydro Priming coat

MAIN PRODUCT-PROPERTIES

- **In accordance with TL/TP-KOR-Stahlbauten, Blatt 92 and is subject to regular external control**
- **1-pack AY Hydro Priming coat for high-grade corrosion protection of steel and hot-dip galvanised steel constructions, e. g. tank areas, steel halls, crane systems etc.**
- **Excellent adhesion on hot-dip galvanised steel parts and excellent corrosion protection on grit-blasted steel surfaces**
- **Application preferable by airless-spraying with dry film thicknesses of 80 to 100 µm**
- **Processing by roller coating and brush application with dry film thicknesses of 60 to 80 µm also possible**

PRODUCT DATA

GEHOTEX-W92-Metallgrund

W92-102 Sand yellow approx. RAL 1002 code-number 692.02
W92-812 Redbrown approx. RAL 8012 code-number 692.06
(other colours on request)

Mixing ratio by weight

not relevant

Demineralised water or water of low hardness

GEHOTEX-W92-Metallgrund / Guideline

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
1.35	**61.0**	**< 3**	**48**	**355**

DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m²) 1)	Consumption (kg/m²) 2)	Spreading rate (m²/kg)
80	**167**	**0.9**	**0.225**	**4.4**

1) Based on consumption in g/m² at DFT 10 µm
2) 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**	**Roller/Brush application 3)**
Nozzle diameter (mm)	**0.35 to 0.53**	**0.38 to 0.53**	**-**
Material pressure (bar)	**150 to 250**	**100 to 150**	**-**
Atomiser pressure (bar)	**-**	**3 to 4**	**-**
DFT * per working operation (µm)	**80 to 100**	**80 to 100**	**60 to 80**
Addition of thinner (%)	**0 to 3**	**3 to 5**	**-**

*) DFT = Dry film thickness

3) recommended only for smaller areas, formation of a product-specific surface structure is possible

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COMMENTS ON PROCESSING

Pot life

Not relevant

Drying/Curing times at 80 µm DFT		Ambient air temperature 20 °C
	dust-free:	after 45 to 60 minutes
	tack-free:	after 2 to 3 hours
	overcoating interval / dry to handle:	after 6 to 8 hours

Notes referring to Directive 2004/42/EC „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 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

- Blast-cleaning Sa 2 ½ 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.
  The surface must have a uniform dull appearance after surface preparation.

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-W92-Metallgrund	80
	Top coat	GEHOTEX-W92	80

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½, mechanical or manual derusting PMa/St2 if applicable with old coating

		Product(s) (other paint systems on request)	NDFT (µm)
	**Priming coat**	GEHOTEX-W92-Metallgrund	80
	Intermediate coat	GEHOTEX-W92 (MIO)	80
	Top coat	GEHOTEX-W92	80

SAFETY MEASURES

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