

MAIN PRODUCT-PROPERTIES

- **1C-AY Priming coat for high-grade corrosion protection of hot-dip galvanised steel constructions, e. g. girder masts, transforming stations of power supply industry**
- **Particularly as additional priming coat on weathered, hot-dip galvanised steel parts for subsequent coatings**
- **Brush application will be recommended with a DFT of 40 to 60 µm**
- **Excellent adhesion on hot-dip galvanised steel parts**

PRODUCT DATA

WIEKORANT-A2B-DKX-Grund



A2B-115 Light ivory approx. RAL 1015
A2B-812 Redbrown approx. RAL 8012
(other colours on request)



Mixing ratio by weight
not relevant



Thinner V-89

WIEKORANT-A2B-DKX-Grund / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.5	70.0	30	(%)	(mL/kg)
				49.0	325
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	50	102	9.3	0.155	6.5

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



High pressure



Roller/Brush application




Nozzle diameter (mm)	0.33 to 0.43	1.5 to 2.0	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	-	3 to 5	-
DFT * per working operation (µm)	60 to 80	60 to 80	40 to 60
Addition of thinner (%)	0 to 3	3 to 5	0 to 2

*) DFT = Dry film thickness

COMMENTS ON PROCESSING



Pot life
Not relevant

Drying/Curing times at 50 µm DFT		Ambient air temperature 20 °C
	dust-free:	after approx. 60 minutes
	tack-free:	after approx. 6 hours
	overcoating interval / dry to handle: dry to walk on:	after 16 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 performance coatings") Type SB	500 g/l	< 500 g/l

INSTRUCTIONS FOR APPLICATION

Surface preparation

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.
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
≥ 5 °C




relative humidity ≤ 80 %
dew point distance ≥ 3 °C

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	WIEKORANT-A2B-DKX-Grund	40 to 60
	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-wierner.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.