


MAIN PRODUCT-PROPERTIES

- 1C-AY Topcoat for high-grade corrosion protection of hot-dip galvanised steel constructions, e. g. girder masts, transforming stations of power supply industry
- Excellent adhesion on hot-dip galvanised steel parts
- Together with suitable priming coats also as topcoat in multi-layered systems for steel constructions of low alloyed steel
- Brush application will be recommended with a DFT of 100 to 120 µm

PRODUCT DATA

WIEKORANT-A2B-DKX	MIO-colours
	A2B-E7833 Cement grey approx. RAL 7033 (other colours on request)
	Mixing ratio by weight not relevant
	Thinner V-76 (for brush application) Thinner V-27 (for spraying)

WIEKORANT-A2B-DKX	Guideline MIO-colours ¹⁾				
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1.35	70.0	30	49.0	365
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	100	211	8.3	0.275	3.6

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)	0.38 to 0.48	1.5 to 2.0	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	-	3 to 5	-
DFT * per working operation (µm)	100 to 120	100 to 120	100 to 120
Addition of thinner (%)	5 to 8 (V-27)	12 to 16 (V-27)	0 to 2 (V-76)

*) DFT = Dry film thickness

COMMENTS ON PROCESSING



Pot life
Not relevant

Drying/Curing times at 100 µm DFT		Ambient air temperature 20 °C
 dust-free:		after 60 to 75 minutes
 tack-free:		after 4 to 6 hours
 overcoating interval / dry to handle: dry to walk on:		after 8 to 10 hours after 3 to 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 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)
	Optional Priming coat	WIEKORANT-A2B-DKX-Grund	80
	Monolayer	WIEKORANT-A2B-DKX	120

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 1/2 or mechanical respectively manual derusting PMA/St2 if applicable with old coating

		Product(s) (other paint systems on request)	NDFT (μm)
	Priming coats	GEHOTEX-W5-Korrogrund GEHOLIT-K19B-Korrogrund in 1 to 2 working operations	40 to 60 each
	Top coat	WIEKORANT-A2B-DKX	120

SAFETY MEASURES



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