

MAIN PRODUCT-PROPERTIES

- Non-labelled 1K-AK-HS Primer for high-grade corrosion protection of steel constructions
- Slightly hazardous for water (WGK 1)
- WIEKORANT-A80B-Korrogrund with a dry film thickness of up to 80 µm shows excellent adhesion on steel
- Brush application will be recommended

PRODUCT DATA

WIEKORANT-A80B-Korrogrund



A80B-309 oxide red approx. RAL 3009




Mixing ratio by weight

Not relevant



Thinner V-50

WIEKORANT-A80B-Korrogrund / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.55	81	19	(%)	(mL/kg)
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (g/m ²) ²⁾	Spreading rate (kg/m ²)	Spreading rate (m ² /L)
	80	126	0.200	5.0	7.9

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

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



High pressure



Roller/Brush application

Application viscosity (s) (Epprecht, MKC 25 °C)	350 to 400		
Nozzle diameter (mm)	-	-	-
Material pressure (bar)	-	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (µm)	-	-	80
Addition of thinner (%)	-	-	0 to 2 at low temperatures




COMMENTS ON PROCESSING



Pot life

Not relevant

* DFT = Dry Film Thickness

Drying/Curing times at 80 µm DFT		Ambient air temperature 20 °C
	touch dry:	after approx. 5 hours
	tack free:	after approx. 16 hours
	ready for overcoating/handling: walkable:	after 24 hours after 72 hours

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4 alternatively
- Mechanical or manual derusting at preparation grade St 2 according to EN ISO 12944-4

Hot-dip-galvanised steel surfaces

- Remove adhesion-reducing substances, particularly zinc salts alternatively
- Sweep blast-cleaning according to EN ISO 12944-4.
After sweep blast-cleaning the surface shall have a uniform dull appearance.

Existing old coatings

- Remove adhesion-reducing substances, e. g. cleaning, washing and if applicable
- Mechanical or manual derusting at preparation grade PMA respectively PST 2 according to EN ISO 12944-4.



Air and surface temperature

5 to 40 °C



Relative humidity ≤ 80 %
Dew point distance ≥ 3 K

PAINT SYSTEMS

EXAMPLES

		Product(s) (other paint systems on request)
	Priming coat	WIEKORANT-A80B-Korrogrund
	Topcoat	WIEKORANT-A80B-DKX

SAFETY MEASURES



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