WELD-THRU PRIMER

K00020101, Red
K00020102, Gray
K00020103, Black

Product Data Sheet

KRYLON INDUSTRIAL COATINGS™

DESCRIPTION

Weld-Thru Primer is a high solids, low VOC, rust inhibitive primer used for shop priming structural steel where severe or extended exposure puts unusual demands on the shop applied primer.

RECOMMENDED USES
Weld-Thru Primer is generally recommended or specified for structural steel, which is to be placed in most mild to moderate environments, and where corrosion inhibiting properties are demanded. Weld-Thru Primer may be welded through with no affect on the weld's intergrity.

SPECIFICATIONS

Steel or Iron:
1 ct. Weld-Thru Primer @ 2.0 mils dft
1-2 cts. High Gloss Enamel (K0083 Series) @ 2.0 - 3.0 mils dft/ct.
or
1 ct. Weld-Thru Primer @ 2.0 mils dft
1-2 cts. Industrial Alkyd Enamel (K0053 Series) @ 2.0 - 4.0 mils dft/ct.
or
1 ct. Weld-Thru Primer @ 2.0 mils dft
1-2 cts. Rust Tough® Alkyd Enamel @ 2.0 mils dft/ct.
or
1 ct. Weld-Thru Primer @ 2.0 mils dft
1-2 cts. DTM Satin Alkyd Enamel (K0010) @ 2.0 - 4.0 mils dft/ct.
or
1 ct. Weld-Thru Primer @ 2.0 mils dft
1-2 cts. Iron Guard™ DTM Acrylic @ 2.5 - 4.0 mils dft/ct.
or
1 ct. Weld-Thru Primer @ 2.0 mils dft
1-2 cts. Water-Reducible Alkyd (K0096 Series) @ 1.0 - 1.25 mils dft/ct.

SURFACE PREPARATION

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Iron & Steel:
Minimum surface preparation is Hand Tool Clean per SSPC-SP2. Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. For better performance, use Commercial Blast Cleaning per SSPC-SP6, blast clean all surfaces using a sharp, angular abrasive for optimal surface profile (2 mils). Prime any bare steel within 8 hours or before flash rusting occurs.

APPLICATION

Methods: Use conventional or airless spray; brush for touch-up only.

Mixing: Stir thoroughly prior to application.

Thinning: Normally not required. Do not thin if VOC must remain at or below 2.1 lb/gal. If thinning is desired, use Acetone.

Airless Spray:

Pressure	1800 - 3000 psi
Hose	1/4" ID
Tip	.015 - .019
Filter	60 mesh
Reduction	Not recommended

APPLICATION cont.

Conventional Spray:

Gun	Binks 95
Fluid Nozzle	63C
Air Nozzle	63PB
Atomization Pressure	50 psi
Fluid Pressure	15-20 psi
Reduction	As needed up to 5% by volume

Brush (for small areas only):

Brush	Natural Bristle
Reduction	Not Recommended

Roller: Not Recommended

CLEAN-UP: Mineral Spirits (K01661600)

CHARACTERISTICS

TYPE: Modified Soya Oil Alkyd (Lead & Chromate-Free)

FINISH: Flat

SOLIDS BY VOLUME: 57.5%

VOC: <250 g/L; 2.1 lb/gal

FLASH POINT: 89°F

RECOMMENDED FILM THICKNESS: 2.0 mils dry

SPREADING RATE: Apply at 457 square feet per gallon (3.5 mils wet), to achieve recommended dry film thickness.

POT LIFE: N/A

DRYING SCHEDULE @ 77°F (25°C) @ 2.0 mils dft:
To touch: 45 minutes
To handle: 3 hours
To topcoat: 4 hours
Note: Dry times will be extended at film thicknesses greater than 2.0 mils.

PERFORMANCE TEST DATA
Salt Spray: Panels coated with 2 mils dry film thickness withstood 350 hours exposure to 5% salt spray tested in accordance with ANSI/ASTM B 117-73. The panels showed no rusting as tested in accordance with ASTM D-610 with a blistering rating of 6D in accordance with ASTM D-714.
Weld Through: Weld-Thru Primer may be welded through during erection to yield sound welds.

CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Krylon Industrial Coatings™ Distributor. Please direct any questions or comments to your local Krylon Industrial Coatings™ Distributor.

Note: The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, Krylon Products Group cannot make any warranties as to the end result. Please direct any questions or comments to 1-800-777-2966.

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