Protective & Marine Coatings

STEEL-SEAM FT910
EPOXY PATCHING AND SURFACING COMPOUND

PART A	B58W910	RESIN (WHITE)
PART B	B58V910	HARDENER (BLACK)

Revised: January 15, 2024

PRODUCT INFORMATION

TRM.67

PRODUCT DESCRIPTION

STEEL-SEAM FT910 EPOXY PATCHING AND SURFACING COMPOUND is a 100% solids epoxy surfacing compound for steel or patching compound for concrete. It is formulated for ease of application with squeegee, trowel, or airless spray on horizontal, vertical or overhead applications. Cures down to 35°F/1.7°C.

- 100% solids
- Tolerates moisture during cure
- Outstanding workability
- Easy to use
- May be applied from 5 mils to 1/2" wft/dft vertically
- May be applied up to 1" thick with aggregate addition
- Cured down to 35°F/1.7°C
- Reduced or low gaps HAPS

PRODUCT CHARACTERISTICS

Color:	Gray
Volume Solids:	100%, mixed
VOC (calculated):	<100 g/l; 1.67 lb/gal, mixed
Mix Ratio:	3:1 by volume

Recommended Spreading Rate:

Coverage:	1" cove ~ 38 lf/gal 3" cove ~ 10 lf/gal 1 mil wft/dft ~ 1604 sf/gal

Drying Schedule @ 40.0 mils wet (1000 microns):

	@ 35°F/1.7°C	@ 73°F/23°C 50% RH
To touch:	6 hours	4 hours
To recoat:		
minimum:	12 hours	6 hours
maximum:	4 days	2 days
To cure:	7 days	7 days

If maximum recoat time is exceeded, abrade surface before recoating. Maximum recoat time is shorter when using polyurea topcoat, refer to topcoat data page.

Hardening time is temperature, humidity, and film thickness dependent.

Pot Life*:	50 minutes	30 minutes

*@ 90°F/32°C, Pot Life is 20 minutes

Sweat-in-Time: None

Shelf Life:	36 months, unopened Store indoors at 40°F (4.5°C) to 100°F (38°C)
Reduction:	Not recommended
Clean Up:	Reducer R7K54

RECOMMENDED USES

May be used as a versatile filler/surfacer for uneven surfaces found in formed, open or corroded concrete and masonry surfaces. May also be used as a fairing compound for weld seams, riveted connections, lap seams and chine angles in steel tanks prior to epoxy coating and lining applications.

Concrete Uses:
- To smooth rough concrete
- To fill bugholes, tie rod holes, cavities, honeycombs and other surface defects on horizontal, vertical, or overhead surfaces
- To form transition coves at vertical and horizontal coves

Steel Uses:
- To smooth riveted, lapped or welded seams
- To fill corrosion pits on steel surfaces
- To form chine coves and fill sharp angles

Acceptable for use in Canadian Food Processing facilities (Confirm acceptance of specific part numbers/rexes with your SW Sales Representative).

PERFORMANCE CHARACTERISTICS

Test Name	Test Method	Results
Abrasion Resistance	ASTM D4060	69 mg lost
Adhesion	Concrete, ASTM D4541; Steel, ASTM D1002	350 psi, 100% concrete failure (ASTM D4541); 1,400 psi (ASTM D1002)
Elongation	ASTM D412	17.9%
Flammability	ASTM D635	Self-extinguishing
Hardness, Shore D	ASTM D2240	55-60
Tensile Strength	ASTM D412	2,672 psi
Thermal Cycling	ASTM C884, 5 cycles	No cracking

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RECOMMENDED SYSTEMS

May be applied directly to prepared concrete or steel.

May be applied over 100% solids primers to include:
- Cor-Cote HCR
- Corobond 100
- Dura-Plate UHS Primer
- Macropoxy 920 PrePrime
- EnviroLastic LT

May be topcoated with a variety of coatings to include:
- Acrolon 218 HS
- Cor-Cote HCR, HCR FF
- Cor-Cote E.N. 7000
- Cor-Cote HP, HP FF
- Dura-Plate 235
- Dura-Plate UHS Laminate
- Dura-Plate UHS Epoxy
- EnviroLastic Polyurea
- Macropoxy 646 Epoxy
- Phenicon HS Epoxy
- SherFlex

The systems listed above are representative of the product's use, other systems may be appropriate.

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.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:

Iron & Steel:	SSPC SP-10/NACE2, 3 mils (75 microns) profile
Concrete & Masonry:	SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 4-6

Surface Preparation Standards

	Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal		Sa 3	Sa 3	SP 5	1
Near White Metal		Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast		Sa 2	Sa 2	SP 6	3
Brush-Off Blast		Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Rusted	C St 2	C St 2	SP 2	-
	Pitted & Rusted	D St 2	D St 2	SP 2	-
Power Tool Cleaning	Rusted	C St 3	C St 3	SP 3	-
	Pitted & Rusted	D St 3	D St 3	SP 3	-

TINTING

Do not tint.

APPLICATION CONDITIONS

Temperature:

Air and Surface:	35°F (1.7°C) minimum, 120°F (49°C) maximum
Material:	50°F (10°C) minimum, 95°F (35°C) maximum At least 5°F (2.8°C) above dew point
Relative humidity:	85% maximum

Refer to product Application Bulletin for detailed application information.

ORDERING INFORMATION

Packaging:

Part A:	11.2 lb / 1.3 Kg/L (~1.5 gal / 5.6L) in a 3 gallon (11.3L) pail
Part B:	4.4 lb / 0.53 Kg/L (~.5 gal / 1.9L) in a 1 gallon (3.78L) pail
Weight per mixed unit:	15.6 lbs. ; 1.9 Kg/L (462 cu. in.)

SAFETY PRECAUTIONS

Refer to the SDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

DISCLAIMER

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APPLICATION BULLETIN

TRM.67

SURFACE PREPARATIONS

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, Immersion Service:
Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (3 mils / 75 microns). Remove all weld spatter and round all sharp edges by grinding. Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

Iron & Steel, Atmospheric Service:
Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns).Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

Concrete & Masonry, Atmospheric & Immersion Service:
For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 4-6. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910.

Follow the standard methods listed below when applicable:
ASTM D4258 Standard Practice for Cleaning Concrete.
ASTM D4259 Standard Practice for Abrading Concrete.
ASTM D4260 Standard Practice for Etching Concrete.
ASTM F1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete.
SSPC-SP 13/Nace 6 Surface Preparation of Concrete.
ICRI No. 310.2R Concrete Surface Preparation.

Surface Preparation Standards

	Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal		Sa 3	Sa 3	SP 5	1
Near White Metal		Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast		Sa 2	Sa 2	SP 6	3
Brush-Off Blast		Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Rusted	C St 2	C St 2	SP 2	-
	Pitted & Rusted	D St 2	D St 2	SP 2	-
Power Tool Cleaning	Rusted	C St 3	C St 3	SP 3	-
	Pitted & Rusted	D St 3	D St 3	SP 3	-

APPLICATION CONDITIONS

Temperature:
Air and Surface: 35°F (1.7°C) minimum, 120°F (49°C) maximum
Material: 50°F (10°C) minimum, 95°F (35°C) maximum
At least 5°F (2.8°C) above dew point

Relative humidity: 85% maximum

APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Reduction .....Not recommended

Cleanup .....Reducer R7K54

Squeegee:
Squeegee.....Flat

Trowel:
Trowel .....Flat blade
For applications over severely damaged or eroded concrete, use a rubber faced grout float trowel.

Putty Knife .....Acceptable

Airless Spray
Pump .....45:1 (minimum) with gravity feed hopper connected to a high volume lower unit (minimum 220 cc/cycle)
Pressure .....2400-3000 psi
Hose .....3/8" ID, with ¼" whip hose acceptable
Tip.....019 - .031
Gun.....Graco Silver Plus, XTR, or Pistol Grip Mastic
Filter(s) .....remove
Reduction .....not recommended

Have material agitated with lids open to ensure rapid mixing. Multiple passes will allow film thickness up to 250 mils. An orange peel appearance is normal. If a smoother finished is desired, 1-2 hours after application use a 1/8" nap roller dampened with R7K54 to smooth the surface. Use a large spatula to continually wipe the material down into the hopper.

If specific application equipment is not listed above, equivalent equipment may be substituted.

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APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mixing Instructions: Stir each component with low speed power agitation prior to mixing. Mix 3 parts Part A (white) to 1 part Part B (black) by volume. Mix with low speed drill and Jiffy Mixer for approximately three minutes until uniform gray with no white or black streaks.

Temperature:
Do not apply product when ambient or surface temperatures are below 35°F (1.7°C). Surface temperature must be at least 5°F (2.8°C) above dew point.

Apply paint at the recommended film thickness and spreading rate as indicated below:

Recommended Spreading Rate:

Coverage:	1" cove ~ 38 lf/gal
	3" cove ~ 10 lf/gal
	1 mil wft/dft ~ 1604 sf/gal

Drying Schedule @ 40.0 mils wet (1000 microns):

	@ 35°F/1.7°C	@ 73°F/23°C *50% RH*
To touch:	6 hours	4 hours
To recoat:		
minimum:	12 hours	6 hours
maximum:	4 days	2 days
To cure:	7 days	7 days

If maximum recoat time is exceeded, abrade surface before recoating.
Maximum recoat time is shorter when using polyurea topcoat, refer to topcoat data page.
Hardening time is temperature, humidity, and film thickness dependent.

Pot Life*:	50 minutes	30 minutes

*@ 90°F/32°C, Pot Life is 20 minutes

Sweat-in-Time: None

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Reducer R7K54. Clean tools immediately after use with Reducer R7K54. Follow manufacturer's safety recommendations when using any solvent.

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PERFORMANCE TIPS

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

No reduction of material is recommended as it can affect film build, appearance, and adhesion.

Do not mix previously catalyzed material with new.

Do not apply the material beyond recommended pot life.

Check surfaces of primer, FT910, and subsequent coats for amine blush (oily film). If detected, remove before applying the next layer or coat.

For filling larger defects in concrete, one to four quarts of 30 to 100 mesh aggregate may be added per gallon of mixed FT910, depending on the size of hole and slump required.

Ambient air cured FT910 is acceptable for use on interior of potable water storage tanks and reservoirs when overcoated with an ANSI / NSF Std. 61 certified Sherwin-Williams coating.

Refer to Product Information sheet for additional performance characteristics and properties.

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