



WELD-THRU PRIMER

K00020101 Red Oxide
K00020102 Gray
K00020103 Black

Weld-Thru Primer is a high solids, rust inhibitive primer used for shop priming structural steel where severe or extended exposure puts unusual demands on the shop applied primer. May be welded through with no effect on the weld's integrity.

- ✓ An excellent choice when harsh environments put heavy performance demands on a shop-applied primer
- ✓ May be welded through with no effect on the weld's integrity
- ✓ VOC Compliant everywhere except SCAQMD

INDUSTRIAL USE ONLY!

AS OF 01/01/2017 COMPLIES WITH:

- | | |
|---|---|
| <input checked="" type="checkbox"/> OTC | <input checked="" type="checkbox"/> CARB |
| <input checked="" type="checkbox"/> EC | <input checked="" type="checkbox"/> LADCO |
| <input type="checkbox"/> SCAQMD | <input checked="" type="checkbox"/> UTAH |

krylonindustrial.com

1-800-247-3266

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RECOMMENDED USES

This product is acceptable for interior/exterior use and generally recommended or specified for structural steel. Should be placed in the most mild to moderate environments, and where corrosion inhibiting properties are demanded.

RECOMMENDED SYSTEM

Steel or Iron:

- 1 ct. Weld-Thru Primer @ 2.0 mils dft
- 1-2 cts. Tough Coat® Alkyd Enamel @ 2.0 - 3.0 mils dft/ct.
- OR
- 1 coat Weld-Thru Primer @ 2.0 mils dft
- 1-2 coats Tough Coat @ 2.0 - 4.0 mils dft/ct.
- OR
- 1 coat Weld-Thru Primer @ 2.0 mils dft
- 1-2 coats. Rust Tough® Alkyd Enamel @ 2.0 mils dft/ct.
- OR
- 1 coat Weld-Thru Primer @ 2.0 mils dft
- 1-2 coats Iron Guard® Water- Based Acrylic Enamel 2.5 - 4.0 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.

CLEAN UP

Clean spills and spatters with Mineral Spirits. Follow manufacturer's safety recommendations when using solvents.

TECHNICAL DATA

Type	Modified Soya Oil Alkyd
Finish	Flat
Color	Red Oxide, Gray, Black
Volume Solids	68%
VOC	<250 g/L; 2.1 lb/gal
Flash Point	89°F
Rec. 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
Volume Solids	57.5%
Drying Time	@ 77°F (25°C) @ 2.0 mils dft:
To Touch:	45 minutes
To Handle:	3 hours
To Top Coat:	4 hours
	Note: Dry times will be extended at film thicknesses greater than 2.0 mils.

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 testing 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.

APPLICATION

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

Mixing Stir thoroughly prior to application

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

CAUTIONS

Thoroughly review product label and SDS for safety and cautions prior to using this product. Please direct any questions or comments to your local Krylon Industrial Representative.

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 1-800-247-3266.



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The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of Krylon Industrial. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Krylon Industrial dealer or representative to obtain the most recent Product Data Sheet.