



**Protective  
&  
Marine  
Coatings**

**STEEL SPEC™  
WELD-THRU PRIMER 2.3**

**B50RS202  
B50AS200  
B50AS201**

**RED OXIDE  
GRAY  
DARK GRAY**

Revised: October 19, 2018

**PRODUCT INFORMATION**

2.46

**PRODUCT DESCRIPTION**

**STEEL SPEC WELD-THRU PRIMER 2.3** is a high solids, lead and chromate-free, rust inhibitive primer with no reportable organic HAPs. It is used for shop priming structural steel in industrial environments and is both weldable and compatible with a wide variety of topcoats.

**PRODUCT CHARACTERISTICS**

**Finish:** Flat  
**Color:** Red Oxide, Dark Gray, and Gray  
**Volume Solids:** 63% ± 2%, may vary by color  
**Weight Solids:** 83% ± 2%, may vary by color  
**VOC (EPA Method 24):** <250 g/L; 2.08 lb/gal

**Recommended Spreading Rate per coat:**

	Minimum	Maximum
<b>Wet mils:</b>	<b>4.0</b>	<b>6.0</b>
<b>Dry mils:</b>	<b>2.5</b>	<b>4.0</b>
<b>~Coverage sq ft/gal:</b>	<b>250</b>	<b>400</b>
Theoretical coverage sq ft/gal @ 1 mil dft	<b>1010</b>	

Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

**Drying Schedule @ 4.0 mils wet @ 50% RH:**

	@ 40°F	@ 77°F	@ 120°F
<b>To touch:</b>	20 minutes	15 minutes	10 minutes
<b>Tack-Free:</b>	30 minutes	25 minutes	15 minutes
<b>Dry-Hard:</b>	2 hours	1.5 hours	30 minutes
<b>To handle:</b>	6.5 hours	5 hours	45 minutes
<b>To recoat:</b>	9.5 hours	5 hours	45 minutes

*Drying time is temperature, humidity, and film thickness dependent.*

**Shelf Life:** 12 months, unopened  
Store indoors at 40°F to 100°F.  
**Flash Point:** 89°F, PMCC  
**Reducer/Clean Up:** Mineral Spirits

**RECOMMENDED USES**

STEEL SPEC Weld-Thru Primer 2.3 is generally specified for bridges, skyscrapers, marine-exposed job sites, etc., which demand a high performance primer.

Can be used as a primer under a variety of topcoats including some 2K epoxies and urethanes.\*

\*It is recommended to apply material to a test patch prior to beginning a job.

According to AISC, shop coat primers are intended for protection for only a short period of exposure in ordinary atmospheric conditions, and is considered a temporary and provisional coating.

Not recommended for immersion service or exposure to acids, alkalis, or strong solvents.

**PERFORMANCE CHARACTERISTICS**

**Weld Test:** Passed AWS D1.1

Meets the requirements of SSPC Paint 15



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## PRODUCT INFORMATION

### 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 2.3 lb/gal. If thinning is desired, use acetone or other appropriate exempt thinner.

**CLEAN-UP:** Mineral Spirits

### CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Sherwin-Williams store. Please direct any questions or comments to your local store.

**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, we cannot make any warranties as to the end result.

### APPLICATION METHODS

Airless Spray, Conventional, and Brush

**Airless Spray:**

Unit: 1500 - 2100 psi

Tip: .017 - .019

Filter: 60 Mesh

Hose: 3/8"

**Conventional:**

Air Pressure: 45-55 psi

Fluid Pressure: 10-15 psi

Cap/Tip: 704FF

Reducer: Acetone (not required)

Reduction Rate: Up to 10%

**Brush:**

Confine to small areas and touch-up.

### DISCLAIMER

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

### SURFACE PREPARATION

Surface should be free of dirt, oil, grease, moisture and other contaminants. All loose rust, loose mill scale and loose paint must be removed by hand or power tool cleaning in accordance with SSPC-SP2 or SSPC-SP3.

### APPLICATION CONDITIONS

Temperature: 40°F (4.5°C) minimum  
120°F (49°C) maximum  
(air, surface, and material)  
At least 5°F (2.8°C) above dew point

Relative humidity: 85% maximum

### SAFETY PRECAUTIONS

Refer to the MSDS 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.