

MAIN PRODUCT PROPERTIES

- 1C-AY Hydro top coat for high-grade corrosion protection of hot-dip galvanised steel constructions, e. g. girder masts, transformer stations of electric power supply companies
- Application in the shop by airless spraying with NDFT of 120 µm resp. as shop primer with NFDFT of 60 µm
- Coating systems with GEHOTEX-W912 exhibit excellent adhesion to hot-dip galvanised steel, as well as elasticity.

PRODUCT DATA

GEHOTEX-W912		RWE Code No.
	W912-E7833 Cement grey approx. RAL 7033 W912-E6901 Green DB601 W912-E8801 Ochre brown approx. RAL 8001	DB-12-H-7033 DB-12-H-DB601 DB-12-H-8001 as shop primer
	Mixing ratio by weight not relevant	
	Demineralised water or water of low hardness	

GEHOTEX-W912		Guide values ¹⁾			
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1.45	65	4	48	330
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²) ²⁾	Spreading rate (m ² /kg)	Spreading rate (m ² /L)
60	125	0.185	5.4	7.85	
120	250	0.370	2.7	3.9	

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	Airless DB-12-H-8001	Roller/Brush application ⁴⁾
Nozzle diameter (mm)	0.38 to 0.53	0.33 to 0.43	-
Material pressure (bar)	200 to 300	150 to 250	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (µm)	120	60	50 to 70
Addition of thinner (%)	0 to 3	0 to 3	-

*) DFT = Dry film thickness

⁴⁾ Recommended only for smaller areas, formation of a product-specific surface structure is possible

COMMENTS ON PROCESSING



Pot life
Not relevant

Drying/Curing times at 120 µm DFT

Ambient air temperature 20 °C



dust-free:

after 45 to 60 minutes



tack-free:

after 1.5 to 2 hours



overcoating interval / dry to handle:

after 16 to 24 hours

Notes referring to Directive 2004/42/EC "Decopaint-Directive"

Subcategory as referred to in Annex IIA	VOC limit values	Max. VOC content of the product in its ready for use condition (including the max. amount of diluents as given in "Application methods")
	(Phase II from 2010)	
i ("One-pack performance coatings") Type WB	140 g/l	< 140 g/l

INSTRUCTIONS FOR APPLICATION

Surface preparation

Hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances, especially zinc salts, e. g. cleaning, washing, alkaline wetting agent washing, alternatively
- Sweep blast-cleaning according to EN ISO 12944-4.
The surface must have a uniformly dull appearance after surface preparation.

Optional shop primer (see below)

- Remove adhesion-reducing substances
- Before overcoating of other priming coats, compatibility tests are recommended



Air and surface temperatures
10 to 35 °C



relative humidity ≤ 80 %
dew point distance ≥ 3 °C
Ensure sufficient air movement during drying

PAINT SYSTEMS

EXAMPLES

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461

		Product(s) (other paint systems on request)	NDFT (µm)
	Optional shop primer	RWE Code No. DB-12-H-8001 GEHOTEX-W912	60
	Monolayer	RWE Code No. DB-12-H-7033 DB-12-H-DB601 GEHOTEX-W912	100

SAFETY MEASURES



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

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