

## MAIN PRODUCT PROPERTIES

- 1C-AY Hydro Primer for high-grade corrosion protection of steel constructions
- Slightly hazardous for water (WGK 1)
- WIEKORANT-A80B-Korrogrund with a dry film thickness of up to 80 µm shows excellent adhesion on steel
- Brush application will be recommended

## PRODUCT DATA

### GEHOTEX-W20B-Metallgrund



W20B-115

Light ivory, approx. RAL 1015




#### Mixing ratio by weight

Not relevant



Demineralised water or water of low hardness  
(also for cleaning of equipment)

### GEHOTEX-W20B-Metallgrund / Guide values <sup>1)</sup>

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
	1.4	63	4.5	47	335
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (g/m <sup>2</sup> ) <sup>2)</sup>	Spreading rate (kg/m <sup>2</sup> )	Spreading rate (m <sup>2</sup> /L)
	60	127	1.3	0.179	5.6

1) Guideline averaged data, slight deviations 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



High pressure



Roller/Brush application

Application viscosity (s) (Epprecht, MKC 25 °C)	320 to 360		
Nozzle diameter (mm)	-	-	-
Material pressure (bar)	-	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (µm)	-	-	80
Addition of thinner (%)	-	-	0 to 2 at low temperatures




## COMMENTS ON PROCESSING



#### Pot life

Not relevant

\* DFT = Dry Film Thickness

Drying/Curing times at 80 µm DFT		Ambient air temperature 20 °C
	touch dry:	after approx. 60 minutes
	tack free:	after approx. 2 to 3 hours
	ready for overcoating:	after 16 hours

## INSTRUCTIONS FOR APPLICATION

### Surface preparation

#### Steel surfaces

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4 alternatively
- Mechanical or manual derusting in preparation grade PMA resp. St 2 according to EN ISO 12944-4

#### Weathered, hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances, particularly zinc salts, e.g. cleaning, washing alkaline wetting agent washing, alternatively
- Sweep blast-cleaning according to EN ISO 12944-4.  
After sweep blast-cleaning, the surface shall have a uniformly dull appearance.

#### Existing coatings

- Remove adhesion-reducing substances, e. g. cleaning, washing
- Before overcoating of old coatings compatibility tests are recommended.

### 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 reactive performance coatings") Type WB	140 g/l	< 140 g/l




**Air and surface temperature**  
5 to 40 °C



Relative humidity ≤ 80 %  
Dew point distance ≥ 3 K

**PAINT SYSTEMS**

**EXAMPLES**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT (µm)</b>
	<b>Priming coat</b>	GEHOTEX-W20B-Metallgrund	80
	<b>Topcoat</b>	GEHOTEX-CW17B	80

**SAFETY MEASURES**



The relevant data can be found in the current material safety data sheets, available at [www.geholit-wierner.de](http://www.geholit-wierner.de).

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