zandleven coatings

# ZANDEX® WELDPRIMER LV

alkyd

One component fast drying welding and transport primer, free from lead and chrome.

- Manageable within 10 minutes at a surface temperature of 30°C and a film thickness of 25 µm.
- Excellent welding properties, does not develop any harmful vapours.
- Term of protection about 6 months at a film thickness of 25 µm, depending on the roughness of the surface and atmospheric circumstances.
- After drying recoatable with practically any paint system.

## Product information

| | | |
|---|---|---|
| Finish | Mat | |
| Colour | Red-brown | |
| Mass density | approx. 1.3 kg/L | |
| Solids content by volume | approx. 35 volume % | |
| VOC | approx. 600 gr./L (volatile organic compound) | |
| Recommended film thickness | As welding primer | 25 µm d.f.t. per layer |
| Theoretical spreading rate | At 25 µm d.f.t. 14.0 m²/L | |
| Practical spreading rate | Depending on several factors like shape of object, profile of surface, method of application, application circumstances and experience. | |
| | A few guiding principles are: | |
| | Brush/roller | 85-90% of the theoretical spreading rate |
| | Spraying | 50-70% of the theoretical spreading rate |
| Flashpoint ISO 1523 | Paint | 25°C |
| | Thinner FGM 631 | 26°C |
| | Thinner WTD 107 | 14°C |
| Dry temperature resistance | 200°C | |
| Durability | At least 12 months, provided that it has been stored in closed original packing at a dry and cool spot. | |

## Drying times

| For d.f.t. up to 25 µm | 30°C | 20°C | 5-10°C |
|---|---|---|---|
| Dust dry | 2 minutes | 3 minutes | 10 minutes |
| Manageable | 3 minutes | 5 minutes | 20 minutes |
| Recoatable: | | | |
| Minimum interval | 2 hours | 4 hours | 6 hours |
| Maximum interval | Unlimited, provided that the surface is dry and clean. | | |
| | Film thickness, ventilation, temperature an relative humidity are of great influence on the drying times. | | |
| Recoatable with two components paint systems | After 1 to 4 weeks, depending on the temperature and layer thickness | | |

## Application instructions

Application conditions

During application and hardening the temperature should be above 5°C to obtain optimal qualities.

The surface should remain free from water and ice and the temperature of the surface should at least be 2°C above dew point.

During application and hardening in closed or small spaces, it is necessary to refresh the air continually to remove the solvent vapours, this because of drying, health and safety.

## Usage information

| | Airless-spray | Air spray |
|---|---|---|
| Type of thinner | FGM 631 / WTD 107 | FGM 631 / WTD 107 |
| Recommended thinner (depending on application and equipment) | 0 – 5 vol. % | 0 – 5 vol. % |
| Nozzle orifice | 0.33 – 0.46 mm<br>0.013 – 0.018 inch | 1.0 – 1.5 mm |
| Nozzle pressure | 120 – 150 bar | 2 – 3 bar |
| Maximum attainable d.f.t. | 40 µm | 40 µm |
| Cleaning of tools | Thinner FGM 631 / WTD 107 | |

## Surface conditions

Steel

New steel:
Blasting according to the ISO norm 8501-1:1988 Sa 2½.
Roughness profile Ra 10-12 µm Rz 50-60 µm.
Surface must be clean and dry.

Repair and maintenance:
Clean the surface thoroughly with a suitable cleaning preparation or by means of steam cleaning.
Remove salts and other water-soluble impurity by spraying with clean tap-water under high pressure.
Remove rust a.o. by (water)blasting Sa 2½ or derust mechanical until St. 2-3.
Apply the advised paint system on a clean and dry surface.

- Mechanical or hand derusting gives less quality than (water)blasting and will result in less protection of the applied paint system.

## Safety description

See safety data sheet

## Ventilation rules

Minimum required quantity of air to comply with:

| | MAC | 10 % LEL |
|---|---|---|
| Zandex Weldprimer LV | 3500 m³/L | 130 m³/L |
| Thinner FGM 631 | 3995 m³/L | 160 m³/L |
| Thinner WTD 107 | 4085 m³/L | 168 m³/L |

MAC = Maximum Acceptable Concentration
LEL = Lower Explosion Limit
Also consult the security information sheets

## Pretreatment / Labeling / Technical Terms (downloadable from www.zandleven.com)

A 1 Labeling of paint products in the European Community
A 2 Physical data
A 4 General guidelines for steel preservation
A 6 Pretreatment of construction steel