



New Guard Coatings Group

A global reputation to protect.

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Rights are reserved to change and update the data without notice.

This information is not exhaustive and it is the user's responsibility to ensure that this data sheet is the most current by contacting their local New Guard Coatings Group branch prior to using the coating/product.

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SIGMAWELD 210

4 pages

November 2012
Revision of March 2011

Description

two component moisture curing, zinc (ethyl) silicate prefabrication primer

PRINCIPAL CHARACTERISTICS

- suitable for automatic application on shot blasted steel plates
- fast drying properties
- good cutting and excellent welding properties, including MIG/MAG welding in various positions (either automatic or manual welding)
- provides corrosion protection up to 9 months
- can be used as a first coat in various paint systems
- suitable for sea water immersion in combination with controlled cathodic protection systems
- excellent thermal stability minimizes heat damage during hot work procedures
- no adherence of weldspatter at surrounding primed surface
- approved by Lloyd's Register of Shipping for use as prefabrication primer

COLOURS AND GLOSS

grey, reddish grey – flat

BASIC DATA AT 20 °C

(1 g/cm³ = 8.35 lb/US gal; 1 m²/l = 40.7 ft²/US gal)

(data for mixed product)

Mass density

2.1 g/cm³

Volume solids

38% ± 2%

VOC (Directive 1999/13/EC, SED)

max. 299 g/kg (Directive 1999/13/EC, SED)

VOC (UK PG 6/23(92) appendix 3)

max. 607 g/l (approx. 5.1 lb/gal)

(UK PG 6/23(92) Appendix 3)

Recommended dry film thickness

15 - 20 µm

Theoretical spreading rate

19 m²/l for 20 µm

Touch dry after

2 - 4 min. at substrate temperature of 20°C

1 - 2 min. at substrate temperature of 40°C

Overcoating interval

min. 16 hours

max. 9 months

longer overcoating intervals can be permitted when primer is still in sound condition

(data for components)

Shelf life (cool and dry place)

binder: at least 6 months

paste: at least 12 months

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- steel; shot blast cleaned to ISO-Sa2½, blasting profile 30 - 75 µm
- substrate temperature may be up to max. 35°C
- for automatic application a substrate temperature of 30°C is recommended
- substrate temperature should be at least 3°C above dew point
- relative humidity during curing should be above 50% and below 85%
- dust quantity rating "1" for dust size class "3", "4" or "5", lower dust size classes to be removed if visible on the surface to be coated without magnification (ISO 8502-3:1992)

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SECONDARY SURFACE PREPARATION

- during storage and construction, contamination of the prefabrication primer should be limited
- after fabrication, surface defects should be treated according to the scheme below
- where two possible surface treatments are indicated, the choice of treatment is dependent on the location and on the system to be applied (see system sheets)
- the preferred pretreatment for optimal results is shown; other possibilities are indicated in brackets

areas	immersed conditions	atmospheric conditions
contamination	to be removed or ISO 8501-3 grade P2	to be removed
weldseams	ISO-Sa2½ (SPSS-Pt3) or ISO 8501-3 grade P2	SPSS-Pt2
burned	ISO-Sa2½ (SPSS-Pt3) or ISO 8501-3 grade P2	SPSS-Ss (SPSS-Pt2)
damaged corroded	ISO-Sa2½ (SPSS-Pt3) or ISO 8501-3 grade P2	SPSS-Ss (SPSS-Pt2)
white rust	ISO 8501-3 grade P2 SPSS-ID Pt2 (SCAP *) or ISO 8501-3 grade P2	SPSS-ID Pt1 (SCAP *)

* cleaning by silicon carbide impregnated abrasive pad
 Dust quantity rating "1" for dust size class "3", "4" or "5", lower dust size classes to be removed if visible on the surface to be coated without magnification (ISO 8502-3).
 Note that the back of welded plate may show discoloration (especially on plate where fillets have been welded on), this is not to be confused with burned areas and does not require special treatment.
 Burned through areas may be present (this happens especially when welding thin steel) and these should then be treated as per 'burned areas' above.

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INSTRUCTIONS FOR USE

mixing ratio by volume: binder to paste 50 : 50

- the temperature of the mixture of binder and paste should preferably be above 15°C
 - stir the paste thoroughly before adding the binder
 - add gradually one third of the binder to the pigment paste
 - stir thoroughly till homogeneous
 - add remaining binder and continue stirring until the mixture is homogeneous
 - strain mixture through a 30 - 60 mesh screen
 - mixed paint is ready for use
 - some addition of thinner (Thinner 40-25) might be necessary depending on routing, line speed and steel temperature
 - agitate continuously during application
- Pot life 8 hours at 20 °C

AIR SPRAY

Recommended thinner

Thinner 40-25

Volume of thinner

0 - 35%, depending on required thickness and application conditions

Nozzle orifice

1.0 - 1.5 mm

Nozzle pressure

0.3 MPa (= approx. 3 bar; 44 p.s.i.)

AIRLESS SPRAY

Recommended thinner

Thinner 40-25

Volume of thinner

0 - 35%, depending on required thickness and application conditions

Nozzle orifice

approx. 0.49 - 0.64 mm (= 0.019 - 0.025 in)

Nozzle pressure

8 - 12 MPa (= approx. 80 - 120 bar; 1160 - 1740 p.s.i.)

CLEANING SOLVENT

Thinner 90-58

Worldwide availability

Whilst it is always the aim of Sigma Coatings to supply the same product on a worldwide basis, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances.

Under these circumstances an alternative product data sheet is used.

REFERENCES

Explanation to product data sheets	see information sheet 1411
Safety indications	see information sheet 1430
Safety in confined spaces and health safety	
Explosion hazard - toxic hazard	see information sheet 1431
Cleaning of steel and removal of rust	see information sheet 1490
Relative humidity - substrate temperature - air temperature	see information sheet 1650

SAFETY PRECAUTIONS

- for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets
- this is a solvent borne paint and care should be taken to avoid inhalation of spray mist or vapour as well as contact between the wet paint and exposed skin or eyes

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