



71009

DATA SHEET

Flash Weld Primer

Very Quick Dry Industrial Primer

General Properties

A very fast drying shop primer designed to give temporary protection to shot or sandblasted steel. It provides excellent adhesion and abrasion resistance and good weathering protection for up to 9 months if left uncoated. This primer can be welded with no effect on weld integrity or toxic emissions.

Recommended Uses

For use as a temporary primer on structural steel, plate, sheet stock etc. requiring yard storage and/or welding.

Product Information

GENERIC TYPE	Polyvinyl Butyral
PIGMENT TYPE	Red Iron Oxide
COLOR	Red Iron Oxide
BASES	N/A
FINISH	Low Sheen
AVERAGE VOLUME SOLIDS	12%
AVERAGE WEIGHT SOLIDS	23%

RECOMMENDED FILM THICKNESS	Wet: 4 - 6 mils Dry: 0.5 - 0.75 mils See your Cloverdale Representative for project recommendations.
THEORETICAL COVERAGE	192.4 ft ² /gal @1 mil (25 microns) DFT 4.7 m ² /L @ 1 mil (25 microns) DFT Actual coverage may vary depending on substrate and application methods.
VISCOSITY	20 - 25" #4 Ford Cup
TEMPERATURE RESISTANCE (DRY)	70°C (160°F)
V.O.C. AS APPLIED	less than 741 g/L (6.18 lbs/gal)
THINNER	Not required

Methods of Application

AIRLESS SPRAY	Speeflo Atlas 30:1 with tip sizes .013" - .015" or equivalent Atlas 15:1 with 800 - 1000 psi fluid pressure and 25 - 30 psi atomizing pressure.	Speeflo
H.V.L.P.	Binks Model Mach 1 92 x 95AP (pressure) or equivalent	
CONVENTIONAL	Binks Model 95GUN 63CSS X 63PB (pressure) or equivalent	
BRUSH / ROLLER	Not recommended	

Drying Time - Temperature, Relative Humidity, and Film Thickness will affect dry and re-coat times.

Substrate Temperature	Touch Dry	Hard Dry	Overcoat Interval		Normal
			Minimum	Maximum	
25°C (77°F)	5 minutes	30 minutes	N/A	N/A	N/A

Recommended Topcoat

Industrial / Maintenance alkyd or water-borne finishes.

Surface Preparation

Steel surfaces should be prepared to SSPC-SP1 Solvent Cleaning followed by SSPC-SP6 Commercial Blast Cleaning. Anchor profile should not exceed 1 mil (25 microns).

Limitations

Do not exceed recommended coverage rates. Always test topcoat compatibility prior to proceeding. Not recommended for wood or concrete.

Mixing Instructions

Mix well before using. Keep containers tightly sealed when not in use.

Safety Precautions

This product is for industrial use only. **Refer to Material Safety Data Sheet for proper health and safety information.**

Storage and Handling

FLASH POINT	12°C (54°F) TCC
PRODUCT WEIGHT	7.84 lbs/gal (container extra)
STORAGE	Cool, dry, secure location. See your Cloverdale Paint Representative.
PACKAGE SIZE	5 gallon pail, 55 gallon drum

Some package sizes or colors may be by special order only. Please check with your Cloverdale Representative when ordering.

Warranty Disclaimer

Cloverdale Paint manufactures quality products. In the event that this product is defective or in any way unsuitable for the application for which it is sold, Cloverdale Paint Inc. will replace the product free of charge. The warranty provided by this data sheet is the only warranty or guarantee of quality made in respect of this product by Cloverdale Paint Inc. By purchasing this product the customer accepts this warranty in lieu of all others, and waives all claims to any other remedy arising from any warranty or guarantee of quality, whether such warranty or guarantee of quality was made expressly to the customer or implied by any applicable law.

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