

Pipetank EA900

Holding Primer



DESCRIPTION

Two component solvented epoxy holding/welding primer

INTENDED USE

A high performance general-purpose holding primer on blast cleaned steel and other metal surface. Used as a weld-able prefabrication primer followed by a full painting system. Also used as a cutback protection on external and internal pipe ends until welded and a new paint system is applied.

PRODUCT FEATURES

- Provides a high degree of corrosion protection in one thin coat
- Can be over-coated in up to 3 months
- Weld-able prefabrication primer
- Excellent adhesion onto correctly prepared surfaces
- Excellent Chemical Protection

LIMITATIONS

- The product will chalk on the surface when exposed to sunlight
- Not resistant to strong acids and alkalis

STANDARD COLOUR AVAILABILITY

Red Oxide



PRODUCT INFORMATION

- **Number of Components:** 2
- **Mixing Volume Ratio:** 4 to 1
- **Density:** 1.22 kg/litre
- **Volume Solids:** 35%
- **Pot Life:** 8 hours @ 20°C
- **Film Thickness:** Wet - 70µm
Dry - 25µm
- **Spreading Rate:** 14m² /lt @ 25µm DFT
- **Temperature Resistance:** Dry 100°C
- **V.O.C.** 586g/litre

PACKAGING

- 5lt and 20lt Kits

SURFACE PREPARATION

Steel Surfaces

- Degrease surfaces with **Speccoats Hydrosolve** followed by a high pressure water rinse
- Grind and fettle weld spatter, protrusions & sharp edges to a minimum radius of 2mm
- Abrasive blast clean to grade SA 2 ½ of ISO 8501-1 with a blast profile 70 - 100µm
- Alternatively mechanically abrade the surface using grinding discs to achieve a similar profile

Galvanizing

- New Galvanizing – degrease using **Speccoats Galvanized Iron Cleaner**
- Old Galvanizing – Abrade or abrasive blast with ultra-fine grit to remove corrosion product

Aluminium

- Abrade lightly with aluminium oxide paper/water paper 200 grit to bright metallic finish
- Alternatively use an approved chemical conversion process



Pipetank EA900

Holding Primer

APPLICATION

Mixing – Two Components

- Stir the base component well with a flat-bottomed paddle or mechanical mixer until product is uniform. Continue stirring and add the entire contents of the activator container. Continue stirring until the mixture is homogeneous.

Application – Equipment & Methods

Brushes	Apply uniform, even coating with high quality brushes from Speccoats
Rollers	Apply uniform, even coating with short pile rollers from Speccoats
Airless Spray	Pump Ratio - 30 to 1 Min Nozzle Orifice - 13 to 15 Thou Tip Pressure - 145 Bar Min
Conventional Spray	<ul style="list-style-type: none"> Air Assisted Airless Pressure Pot - Pressure Feed Gun Gravity Feed Gun Various Nozzle sets are available to suit the guns

Thinning

- Thin up to 10% with **Speccoats SA65 Thinners**

Cleaner

- Cleaning is done with **Speccoats SA65 Thinners**

APPLICATION ENVIROMENT

Level	Surface Temperature	Ambient Temperature	Relative Humidity
Minimum	10°C*	7°C	No lower limit
Maximum	40°C	45°C	85%

*or 3° above the dew point

DRYING TIME

Touch dry	Over-coating interval		Dry to handle	Full Cure
	Minimum	Maximum		
30 minutes at 25°C for 50µm at 65% RH	4 hours at 25°C at 65% RH	3 months	4 hours at 25°C at 65% RH	7 days

STORAGE AND HANDLING

Storage - Store at temperatures between 5°C and 40°C, away from direct sunlight, open flames or sparks

Shelf Life - Minimum 1 year when packed in original containers

HEALTH AND SAFETY

- Flammable – keep away from sources of ignition – No smoking!!!
- Adequate ventilation should be provided during use
- Avoid contact with the skin by using gloves, barrier creams and face mask
- If the product comes into contact with the skin, wash immediately with lukewarm water and soap, if the eyes are affected flush with water of diluted boric acid solution and seek medical attention immediately
- Refer to Material Safety Data Sheet (MSDS)

DISCLAIMER

Whilst we endeavour to ensure that all advice we give about the product is correct, the information given in this data sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so entirely at his own risk. As conditions of use, method of application and suitability of the substrate prior to painting are beyond our control, no guarantee is implied by the recommendations contained herein. We therefore do not accept any liability whatsoever or howsoever arising from the performance of this product or for any loss or damage arising out of the use of this product. The information contained in this sheet is liable to modification from time to time in the light of experience and ongoing product development programmes. It is the user's responsibility to ensure that this sheet is current prior to using the product. **ISSUE DATE 06/10/2010**