

SIGMAWELD 199

(SIGMAWELD MC)

5 pages

January 2007
Revision of September 2005

DESCRIPTION two component moisture curing, low 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 regular, smooth weld seams
 - low fume release during welding and cutting
 - no adherence of weldspatter at surrounding primed surface
 - excellent thermal stability minimizes heat damage during hot work procedures
 - can be used as a first coat in various paint systems
 - suitable for seawater immersion in combination with controlled cathodic protection systems
 - approved by Lloyd's Register of Shipping for use as prefabrication primer (see sheet 1880)
 - Health certificate from North of England Industrial Health Service (see sheet 1881)

COLORS AND GLOSS redbrown (grey on request) - flat

BASIC DATA AT 68°F (8.25 lb/US gal = 1 g/cm³; 40.7 ft²/US gal = 1 m²/l)
(data for mixed product)

Mass density	10.85 lbs/gal (1.3 g/cm ³)
Solids content	25 ± 2%
VOC (supplied - EPA 24)	max. 521 g/kg (Directive 1999/13/EC, SED) max. 5.6 lb/gal (approx. 676 g/l)
Recommended dry film thickness	0.7 mil (18 µm) - see further: "Recommended substrate conditions and temperatures"
Theoretical spreading rate	463 ft ² /gal (11.4 m ² /l) for 0.7 mil (18 µm)
Touch dry after	6 min. at substrate temperature of 68°F (20°C) 3 min. at substrate temperature of 104°F (40°C)
Overcoating interval	min. 3 days max. 6 months longer overcoating intervals can be permitted when primer is still in sound condition

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(data for components)

Shelf life (cool and dry place)

binder: at least 9 months
paste: at least 12 months

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- steel; shot blast cleaned to SSPC SP10/NACE 2 (ISO-Sa2½), blasting profile (R_z) 1.4 - 3 mils (35 - 75 µm)
- on steel blasted to above profile, the recommended dft, 0.7 mil (18 µm), corresponds to 0.9 mil (22 µm) as measured on a smooth test panel
- minimum thickness for a closed film is 0.6 mil (15 µm) measured on a smooth test panel
- substrate temperature may be up to max. 95°F (35°C)
- for automatic application a substrate temperature of 86°F (30°C) is recommended
- substrate temperature should be at least 5°F (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)

SYSTEM SPECIFICATION

primers

system sheet 3015

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

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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	SSPC SP3 (SPSS-Pt2)
burned	ISO-Sa2½ (SPSS-Pt3) or ISO 8501-3 grade P2	SSPC SP7/NACE 4 (SPSS-Ss) (SSPC SP3 or SPSS-Pt2)
damaged corroded	ISO-Sa2½ (SPSS-Pt3) or ISO 8501-3 grade P2	SSPC SP7/NACE 4 (SPSS-Ss) (SSPC SP3 or SPSS-Pt2)
white rust	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.

INSTRUCTIONS FOR USE

mixing ratio by volume: binder to paste 66.7 : 33.3

- the temperature of the mixture of binder and paste should preferably be above 59°F (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 (Sigma thinner 90-53) might be necessary depending on routing, line speed and steel temperature
- agitate continuously during application

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Pot life 24 hours at 68°F (20°C)

AIRLESS SPRAY

Recommended thinner no thinner should be added
 Nozzle orifice approx. 0.017" - 0.021" inch (= 0.43 - 0.53 mm)
 Nozzle pressure 1140 - 1700 p.s.i (= approx..8 - 12 MPa; 80 - 120 bar)

CONVENTIONAL SPRAY

Recommended thinner no thinner should be added
 Nozzle orifice 0.039" - 0.059" inch (1 - 1.5 mm)
 Nozzle pressure 43 p.s.i. (= approx. 0.3 MPa or 3 bar)

CLEANING SOLVENT

recommended Sigma thinner 90-53

SAFETY PRECAUTIONS

for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets

this is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapor as well as contact between the wet paint and exposed skin or eyes

Worldwide availability

Whilst it is always the aim of SigmaKalon Marine & Protective 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

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LIMITATION OF LIABILITY

The information in this data sheet is based upon laboratory tests we believe to be accurate and is intended for guidance only. All recommendations or suggestions relating to the use of the Sigma Coatings products made by SigmaKalon Marine & Protective Coatings, whether in technical documentation, or in response to a specific enquiry, or otherwise, are based on data which to the best of our knowledge are reliable. The products and information are designed for users having the requisite knowledge and industrial skills and it is the end-user's responsibility to determine the suitability of the product for its intended use.

SigmaKalon Marine & Protective Coatings has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. SigmaKalon Marine & Protective Coatings therefore does not accept any liability arising from loss, injury or damage resulting from such use or the contents of this data sheet (unless there are written agreements stating otherwise).

The data contained herein are liable to modification as a result of practical experience and continuous product development. This data sheet replaces and annuls all previous issues and it is therefore the user's responsibility to ensure that this sheet is current prior to using the product.

In the event of any disparity or dispute in the wording of this document, the original English text shall prevail.

PDS	7177
179165 redbrown	2008002180
179167 grey	5000002180