

Technical Data Sheet

30533 CORAWELD SHOPPRIMER

DESCRIPTION

Epoxy/phenalkamine shop primer with fast drying and high hiding at low film thickness. Formulated for pre-fabrication protection and to support welding, with additives that help resist burn-through and gas formation.

AREAS OF USE

- Steel structures
- Industrial plants
- Tanks and equipment
- Marine and offshore structures
- Prepared metal surfaces

COLOUR

Oxide Red

PRODUCT PROPERTIES

Gloss	0 - 10 GU
Volume solids	45 ± 3
Density	1,30 ± 0,05
Theoretical coverage (m ² /kg)	17,30 (20 mic)

MIXING INFORMATION

Hardener code: 32533

Mix ratio by weight: 10 / 1

Thinner: Epoxy Thinner

Thinner by weight: 0 – 10

Thinning depends on application equipment and required dry film thickness. Use only the recommended thinner. Mix mechanically until homogeneous. For best homogeneity, condition the material above 15°C. Allow the mixed material to stand for at least 10 minutes before application and use within its pot life.

DRYING TIMES

Stage	5°C	20°C	60°C
Dust dry	5 - 10	1 - 5	-
Touch dry	10 - 20	5 - 10	-
Hard dry	30 - 45	15 - 30	-
Full cure	-	7 days	-

Drying times apply at the specified film thickness and below 85% relative humidity. Greater film thickness may extend drying time.

SURFACE PREPARATION

Steel: Remove oil, dirt and dust. Abrade the surface if the primer has exceeded its maximum overcoating interval. Previously painted surfaces: remove oil, grease, salts and other contamination. Wash salts and contaminants with high-pressure water. Abrade sound old coatings to improve adhesion. Remove loose and degraded coating mechanically to St 2-St 3 in accordance with ISO 8501-1; Sa 2, preferably Sa 2½, may be used where conditions require. For touch-up, the surface must be clean and dry; prepare to Sa 2½ and repair with the same coating.

STORAGE

Store in the original, tightly closed container at 10-35°C in a dry, enclosed and ventilated place, protected from direct sunlight. Day/night temperature variation should not exceed 10°C. If Component A is stored for more than 3 months, turn the container upside down during the next 3 months. Shelf life under these conditions: 6 months.

PACKAGING

Filling quantity: 20 kg