

FREOLUX

Hydro-Welding Primer WL1764V

V = Variation to the existing standard system

- Water dilutable one-component welding-primer
- Application in the steel-structure
- Good adhesion on steel and non-ferrous metals
- Outstanding weldability

Technical / Physical Data	Resin/ binder	oxidative drying polymerization resin, water dilutable	
	Colour	oxide red approx. RAL 3009 ivory approx. RAL 1014 (acc. to RAL 840 HR) other colour shades on request	
	Gloss value visual	mat	
	Original viscosity DIN 53211*	40 to 50 sec. / 4mm cup	
	Thinner	demineralised water	
	pH-Value	8,7	+ / - 0,2
	Density calculated	1,25 g / ml	+ / - 0,1
	Solid content calculated	44 %	+ / - 2
	Solid content in volume calculated	240 ml / kg	+ / - 10
	Consumption calculated in original viscosity, without application loss	80 to 90 g / m ² dry film thickness 20 µm see „Special remarks“	

Storability

Approx. 9 month in original packings at an ambient temperature of 5 to 25 °C, in case the original packings are tightly closed. Opened packing must be used very shortly. The minimum storage stability of each batch is mentioned on the product label. A storage time beyond the mentioned date doesn't necessarily mean that the material is unusable. In this case a check of the qualities which are important for the respective



Processing and application

Application

Stir up before the use carefully (e.g. with high-speed mixer).

spraying-airless:	in original viscosity
spraying-high-pressure:	after viscosity adjustment to 30 to 40 sec.
Diping/ Flood:	after viscosity adjustment to 25 to 35 sec.

Substrates

steel, non-ferrous metals

Pretreatment

The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust and surfactant. According to the requirements we recommend to apply the suited chemical (e.g. phosphatizing, chromating) or / and mechanical (e.g. shotblasting) pretreatment.

Proposal for a coating system

substrates:	steel	
primer:	FREOLUX-Hydro-Welding primer	WL1764V
top coat:	FREOLUX-Hydro-Coat	WL1788
	FREIOPLAST-Hydro-Coat	WL1688

Application temperature

above 10 °C

Drying

air drying at 20°C, 40 to 70 % rel. dampness

dust dry:	after 20 min	(degree of drying 1/ DIN 53150)
dry to touch:	after 1 h	(degree of drying 4/ DIN 53150)
complete dry:	after 7 days	(swinging beam hardness/ ISO 1522)

oven drying: up to 70°C possible (object temperature)

Repair coating

after 1 to 3 h/ 20°C

Cleaning of working equipment

immediately after use: water, lightly dried material on the surface of working tools:
organic cleaners, e.g. EFD-Thinner 400424

Advise for safety protection and protection of health

The usual precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

Repair coating

Test condition

*Indication of the delivery viscosity according to DIN 53211:

DIN 53211 was withdrawn in October 1996.

On request the value is available according to DIN EN ISO 2431.

All information is based on a standard climate 20/65 DIN 50014.

For the calculation of the practical consumption loss additions have to be considered. Indications to this are the practical experience and advice's given in DIN 53220.

All information are based on our product knowledge and experience. To the application we have no direct influence. For further information please don't hesitate to contact us.

The information mentioned herein are reference values and are not given as specification.