

## Selection & Specification Data

<b>Generic Type</b>	Self-curing inorganic zinc silicate.
<b>Description</b>	A weldable pre-construction inorganic zinc primer for shop use only.
<b>Features</b>	<ul style="list-style-type: none"> <li>- Welds made over Carboweld 11 coated steel are equal in every respect to welds made to uncoated steel.</li> <li>- Designed to protect steel during construction phase of projects under normal conditions.</li> <li>- Can be topcoated for additional long term protection for atmospheric exposures.</li> <li>- Weld spatter does not adhere to or damage the coating.</li> <li>- Can be welded as quickly and easily as bare steel at production line speeds without loss in strength or consistency of the weld.</li> <li>- Dries to touch and to handle in 3 to 5 minutes.</li> </ul>
<b>Colour</b>	Pink
<b>Finish</b>	Flat Consult StonCor Africa Technical Service for appropriate topcoat specific for intended service.
<b>Dry Film Thickness</b>	15 to 20 microns in a single coat Thicknesses up to 40 microns are also acceptable
<b>Solids Content</b>	By Weight 48% Percentage Zinc in Dry Film 85% ± 1%
<b>Theoretical Coverage Rate</b>	18,2m <sup>2</sup> /litre at 15 microns
<b>VOC Values</b>	Thinner # 33 (20%) 730g/l As Supplied 696g/l These are nominal values
<b>Limitations</b>	For projects with extended construction phases consult StonCor Africa Technical Service for more suitable primers. <b>For shop use only.</b>

## Substrates & Surface Preparation

<b>General</b>	Remove all oil or grease from the surface to be coated with Carboclean 250 in accordance with SSPC-SP1.
<b>Steel</b>	Abrasive blast to achieve a sharp angular profile of 25 to 40 microns for most applications. Where high build topcoats are used, 40 to 60 microns blast profile is recommended. <b>Service:</b> <b>Immersion</b> (see Limitations): ISO 8501 Sa2½ <b>Non-Immersion:</b> ISO 8501 Sa2
<b>Welding Data</b>	Automatic – Carboweld 11 when applied at recommended thickness may be welded at speeds up to 1.2m per minute. This is dependent upon plate thickness and bead size. This includes the following process: 1) Submerged arc 2) Flux core 3) Short arc and 4) Metal Inert Gas (MIG).

## Mixing & Thinning

<b>Mixing</b>	Power mix base, then combine parts, sifting zinc filler slowly into base and mix with continuous agitation. Mix until free of lumps. Pour mixture through 30 mesh screen. <b>DO NOT MIX PARTIAL KITS.</b> Keep under mild agitation during application.
<b>Thinning</b>	Not normally required, but may be thinned using Thinner # 33 up to 20%. Use of thinners other than those supplied or recommended by StonCor Africa may adversely affect product performance and void warranty, whether express or implied.
<b>Pot Life</b>	48 Hours at 25°C and less at higher temperatures. Pot life ends when coating becomes too viscous to use.

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## Application Equipment

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

**Conventional Spray** Pressure pot with dual regulators, agitator, 10mm I.D. minimum hose, 15m maximum material hose length 1.8mm I.D. fluid tip and appropriate air cap. Keep pot at same level as application.

**Airless Spray**

Pump Ratio	45:1 (min)
GPM Output	3.0 (min)
Material Hose	10mm I.D. (min)
Tip Size	.019 to .023"
Output PSI	1500-2000
Filter Size	60 Mesh

Teflon packings are recommended and available from the pump manufacturer.

**Brush** For touch-up of areas less than 0,1m<sup>2</sup> only. Use medium bristle brush and avoid over brushing.

**Roller** **DO NOT APPLY BY ROLLER**

**Spray Application (General)** The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

Agitate the mixed material continuously during the spraying operation. If spraying stops for more than 15 minutes, recirculate the material remaining in the spray line.

## Application Conditions

Condition	Material	Surface	Ambient	Humidity
Minimum	-18°C	-18°C	-18°C	30%
Maximum	54°C	93°C	54°C	95%

This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

## Curing Schedule

Surface Temp & 50% Relative	Dry to Handle	Final Cure General
-18°C	2 Hours	5 Days
4°C	40 Minutes	12 Hours
16°C	15 Minutes	6 Hours
27°C	5 Minutes	4 Hours
38°C	3 Minutes	2 Hours

Drying times are based on a 20 to 40 micron dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. For shop applications or if the relative humidity is too low, the curing time can be reduced by raising the relative humidity by steam or water spray on the coated surface after an initial dry time of 1 hour at 25°C.

## Cleanup & Safety

**Cleanup** Use Thinner # 2. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

**Safety** Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

**Ventilation** When used as a tank lining or in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to insure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved respirator.

## Packaging, Handling & Storage

**Shelf Life**

Part A	12 Months at 25°C
Part B	24 Months at 25°C

Shelf life (actual stated shelf life) when kept at recommended storage conditions and in original unopened container.

**Shipping**

	<b>5L Kit</b>
Part A	4.18kg
Part B	3.20kg
	<b>15L Kit</b>
Part A	13.85kg
Part B	9.25kg

**Storage Temperature & Humidity**

4 to 43°C  
0 to 90% relative humidity

**Flash Point (Setaflash)** 11°C for Base

**Storage** Store indoors



Co. Reg. No.: 1996/01848/07  
Tel No: +27 11 254 5500  
Website: [www.carboline.co.za](http://www.carboline.co.za)  
E-mail: [carboline@carboline.com](mailto:carboline@carboline.com)

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