



Advisory Note

GEN/7/1

Repair of Field Welds on Hot Dip Galvanizing

August 2006

- Power tool clean to Australian Standard 1627.2 Class 3. *
Remove all welding scale, slag and corrosion products.
- Degrease and remove all surface contaminants.
- **Severe Corrosion Service**
 - Semi Immersion or severe corrosive zones – apply 2 coats of 2 pack epoxy zinc to AS 3750.9 to 150µm minimum followed by 2 pack epoxy enamel to 150µm.
- **Moderate Corrosion Service – Atmospheric**
 - Apply 2 coats of Galvanite epoxy zinc rich primer or equivalent to 125 - 150 µm dry film thickness
- **Decorative Finish**
 - Apply 2 coats of Galvanite epoxy zinc rich primer or equivalent to 125 - 150 µm dry film thickness
 - Stipple edges of the painted area to achieve optimum appearance of the repair.
 - If a very close colour match is essential, immediately on completion apply 1 coat of leafing aluminium** paint over the zinc rich primer for appearance only. Otherwise a more uniform metallic colour match will be achieved over time.
- **General**
 - Observe normal good painting practice with respect to weather and application conditions. Apply strictly in accordance with paint manufacturers recommendations

- * Suitable tools
- power wire brush
 - needle gun
 - disc sander
 - angle grinder
 - chipping hammer

** Leafing aluminium should be dry sprayed or stipple brush applied, giving a light coat only, for best appearance for architectural finish

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GALVANITE

Data Sheet 2302

PRODUCT DESCRIPTION : Galvanite is a single pack, Zinc Rich primer for repair of damaged or degraded galvanised surfaces or as a zinc primer for properly prepared steel surfaces.

RECOMMENDED USE : General purpose primer for repair of welding or other damage to galvanised surfaces. May also be used as a zinc rich primer for steel surfaces.

TECHNICAL INFORMATION :

- Colour : Light metallic grey. Weathers to a galvanised appearance.
- Solids (% by volume) : 50 ± 2
- Specific Gravity : 2.72
- Flash point : 25 °C 2 (Closed Cup)
- Gloss : Metallic finish
- Chemical resistance : Comparable to galvanising
- Flexibility : Good
- Abrasion resistance : Good
- Water resistance : Good

	Film thickness per coat in microns		Theoretical spreading rate m ² /l
	Dry	Wet	
Application range :	30 - 75	60 - 150	16.7 - 6.67
Typical :	40	80	12.5

APPLICATION DATA :

- Application methods : Usually brush or roller. May be Airless or conventional sprayed.
- Thinner/Cleaner : Jotun Thinner No.7
- Guiding data airless spray
- Pressure at nozzle : 5 - 10 MPa (700 - 1400 psi)
- Nozzle tip : 0.38-0.53 mm (0.015-0.021")
- Spray angle : 40-80°
- Filter : Check to ensure that filters are clean.

SURFACE PREPARATION : Remove oil and grease etc. Power tool cleaning to AS 1627:2 class 3. Under certain circumstances other methods of surface preparation may be acceptable.

CONDITION DURING APPLICATION : The temperature of the substrate should be at least 5 °C and a minimum 3 °C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate.

DRYING TIME :

The drying times are evaluated according to BS 3900 Part C2 and BS 3900 Part C3. Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- * Good ventilation (Outdoor exposure or free circulation of air)
- * Recommended film thickness
- * One coat on top of inert substrate

Substrate temperature	Surface ¹ Dry	Hard ² Dry	Dry to recoat ³	
			Minimum	Maximum ⁴
5 °C	120 min	8 h	48 h	-
10 °C	60 min	4 h	24 h	-
23 °C	30 min	2 h	16 h	-
35 °C	10 min	1 h	8 h	-

¹ Evaluated according to BS 3900 Part C2

² Evaluated according to BS 3900 Part C3

³ Recommended data given for recoating with the same generic type of paint.

⁴ The surface should be dry and free from any contamination prior to application of the subsequent coat.

Given data must be considered as guidelines only. Actual drying time can only be decided at site, depending on age of existing system, generic types, numbers of coats, thinning, temperature, ventilation, etc.

TYPICAL RECOMMENDED PAINT SYSTEM :

Galvanite 2 x 40 µm (Dry Film Thickness)

STORAGE AND PACKING :

STORAGE : The product must be stored in accordance with national regulations. Preferred storage conditions are to keep the containers in a dry space provided with adequate ventilation. The containers should be sealed tightly.

PACKING CONTENT : 4 Litre & 1 Litre

HEALTH AND SAFETY :

Please observe the precautionary notices displayed on the container. Spray under well-ventilated conditions. Do not breath or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleaner, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, please refer to the Material Safety Data Sheet.

DISCLAIMER: *The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we can not guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.*

ISSUED NOV 1994.

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