



# ARMAWELD

## Product characteristics

### Description

Armaweld is a two-component, solvent-borne zinc ethyl silicate primer. Especially suited, where welding and gas-cutting properties are of importance. The product complies with IMO MSC.215(82) as shopprimer for ballast tank coating systems and IMO MSC.288(87) as shopprimer for cargo oil tank coating systems.

### Recommended use

For short to medium-term protection of abrasive blast cleaned steel plates and other structural steel during the storage, fabrication, and construction periods.

### Service temperature:

- Without topcoat: maximum, dry, atmospheric exposure: 400°C [752°F].

### Certificates / Approvals

- Approved as weldable pre-fabrication primer. Contact Hempel for details.

### Features

- Excellent resistance to weathering
- Excellent resistance to oil and organic solvents - Excellent heat resistance

## Product safety

**Flash point** 22°C [72°F]

### VOC content mixed product

Legislation	Value
EU	g/L [5.17 lb/US gal]
US (coatings)	g/L [5.17 lb/US gal]
US (regulatory)	g/L [5.17 lb/US gal]
China	g/L [5.17 lb/US gal]

Hempel website, [hempel.com](http://hempel.com) or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9.

### Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

## Product data

**Product code:**  
**ARMAW**

**Product components**  
Base 15899  
Curing Agent 99751

**Standard shade / code**  
Grey 19840

**Gloss**  
Flat

**Volume solids**  
28 ± 2%

**Specific gravity**  
1.3 kg/L [11 lb/US gal]

**Reference dry film thickness** 15  
micron [0.6 mils]

## Surface preparation

### Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC). - Remove dust, blast media and loose materials.



# ARMAWELD

## Roughness

- Surface profile Medium (G) (ISO 8503-2). - Surface profile Medium (S) (ISO 8503-2).

Consult Hempel's separate Surface Preparation Guidelines for more details.

## Application

### Mixing ratio

(2 : 3 by volume)

Products containing floating or settling particles/pigments need to be continuously stirred during application. This is especially important in case of heavy thinning.

### Thinner

Hempel's Thinner 08700  
Hempel's Thinner 08570

### Cleaner

Hempel's Thinner 08700  
Hempel's Thinner 08570

### Pot life

**Product**    **20°C temperature**    [68°F]

Spray data are indicative and subject to adjustment. Pressure is for a material

Pot life	hours

### Application method

Tool	Thinning max vol.	Application parameters
Airless spray	30%	Nozzle pressure: 80 bar [1200 psi] Nozzle orifice: 0.019-0.023"
Air spray	30%	Not Applicable.
Brush	15%	Not Applicable.

temperature of 20°C [68°F].

## Film thickness

Specification range	Low	High	Recommended
Dry film thickness	10 micron [0.4 mils]	25 micron [1.0 mils]	15 micron [0.6 mils]
Wet film thickness	40 micron [1.5 mils]	90 micron [3.5 mils]	50 micron [2 mils]
Theoretical spreading rate	28 m <sup>2</sup> /L [1100 sq ft/US gal]	11 m <sup>2</sup> /L [450 sq ft/US gal]	19 m <sup>2</sup> /L [770 sq ft/US gal]

## Application conditions

- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above 0°C [32°F] during application and curing.
- Surface temperature must be below 55°C [131°F] during application and curing.

## Relative Humidity:

- Relative humidity must be above 50% during curing.

## Drying and overcoating

### Product compatibility

- Previous coat: None.
- Subsequent coat: According to Hempel's Specification.

### Drying time

Surface temperature	20°C [68°F]	
Dry to handle	min	5

Determined for dry film thickness 15 micron [0.6 mils] at standard conditions, see Hempel's Explanatory Notes for details.

### Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

### Overcoating details

- Inorganic zinc silicates must be fully cured before overcoating.
- Remove zinc salts or other contamination before overcoating.



# ARMAWELD

## Storage

### Shelf life

**Ambient 25°C 35°C temperature** [77°F] [95°F]

Shelf life from date of production, when stored in original, unopened containers.

---

Base	months	months
------	--------	--------

---

Curing Agent	months	months
--------------	--------	--------

---

Thereafter, the product quality must be re-inspected. Always check the best before date or expiry date on the label.

### Storage conditions

- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.