

Corroless ACO Weldcoat

(formerly Acothane Weldcoat)

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Product Description	A highly specialised, high build, solvent free, two pack polyurethane coating designed for brush application to pipe girth welds.			
Features & Use	<ul style="list-style-type: none"> • Use for complete corrosion protection in water immersion, soil burial or atmospheric exposure conditions for pipe girth welds • Outstanding physical properties in terms of flexural strength, tensile strength, impact and abrasion resistance • High build, solvent free • Rapid drying and curing characteristics, allowing early completion of coating to recommended film thicknesses 			
Approvals/ Certification	<ul style="list-style-type: none"> • Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection • BS6920 Factory and site application and WRAS water fittings directory • Meets the performance requirements of BS EN 10290 and AWWA C222 • Malaysian SPAN approved • Approvals held in the former name of 'Acothane' 			
Finish	Sheen			
Volume Solids	100%			
VOC Content	0 g/litre			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Typical	1.0 mm	1.0 mm	1.0 m ² /litre
	Typical	1.5 mm	1.5 mm	0.67 m ² /litre
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 1 mm DFT		+10°C	+20°C
	Dust Free		1 hr	30-45 min
	Hard Dry		4 hr	3 hr
	Overcoating	Minimum	1 hr	30 min
		Maximum	24 hr	24 hr
Drying and recoating times are related to the substrate temperature				
Colours	Grey, Cream and special shades to order			
Mix Ratio/ Product Code	10WCT (base) and 10ACT (activator) Base 3 parts by volume 3.23 parts by Weight Hardener 1 part by volume 1 part by Weight			
Pot Life	Approx. 8 min at 25°C			
SG	1.29 kg/lit mixed			
Storage Conditions	Store in dry, cool conditions and protect from frost			
Shelf Life	Minimum 24 months if stored as above in unopened containers			
Flash Point	Above 60°C			

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<p>Surface Preparation</p>	<ul style="list-style-type: none"> All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Steel: blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u> Concrete: remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of <16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer 														
<p>Mixing</p>	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Activator must be added to base and thoroughly mixed to ensure an even mix throughout the container – at least 2 minutes mixing time is recommended. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating has cured.</p>														
<p>Thinner / Cleaner</p>	<p>Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)</p>														
<p>Application Conditions</p>	<p>Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.</p>														
<p>Application Methods</p>	<table border="1"> <thead> <tr> <th>Method</th> <th>Airless Spray</th> <th>Conventional Spray</th> <th>Brush</th> <th>Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>No</td> <td>No</td> <td>Yes</td> <td>No</td> </tr> </tbody> </table>	Method	Airless Spray	Conventional Spray	Brush	Roller		No	No	Yes	No				
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	No	No	Yes	No											
<ul style="list-style-type: none"> This product is specifically designed for brush. Other Corroless ACO grades are available for spray application 															
<p>Product Notes</p>	<ul style="list-style-type: none"> Activator contains isocyanates – refer to Safety Data Sheet Overcoating: normally after 1 hour and within 24 hours of initial application. Abrading will be required after 24 hours for adhesion In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous In order to comply with WRAS certification, a minimum cure time of 14 days at 7°C is required before contact with drinking water Corroless ACO Weldcoat has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice 														
<p>Health & Safety</p>	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>														

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