

TECHNICAL DATA SHEET

AQUAWELD

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Vibol Aquaweld is a fast drying, anti-rust welding primer based on water.

As welding primer for blasted steel, perfect for automatic blast-spray-installations.

PRODUCT INFORMATION

Type of paint	Acrylate
Finish	Mat
Color	Redbrown, grey, green, black
Density	1.34 kg/L
Solids content	43 vol%
VOC (Volatile Organic Compounds)	<30 g/L
Viscosity (DIN 4)	25-30 sec
Recommended dry film thickness (DFT)	25 µm
Theoretical spreading rate (At 60 µm DFT)	17.2 m²/L
Practical spreading rate (Depending on several factors like shape of object, profile of surface, method of application, application circumstances and experience)	Brush/Roller: 85-90% of the theoretical spreading rate Spraying: 50-70% of the theoretical spreading rate
Flashpoint	N/A
Dry temperature resistance	120°C

DRYING TIMES

For d.f.t. up to 25µm 20°C

Dust dry	5 min
Manageable	20 min
Overpainted	
Minimum interval	4 hours
Maximum interval	12 months

Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times.
In automatic application installations with heating : the paint is dry at the end of the drying area.

APPLICATION-INSTRUCTIONS

Application conditions

During application and hardening the temperature should be above 5°C to attain maximum resistance against chemical and mechanical influences.

Application at lower temperatures (-10°C) is possible, however hardening will take considerable more time and complete resistance will be achieved much later.

The surface should remain free from water and ice and the temperature of the surface should at least be 3°C above dew point.

Can be covered with different waterbased systems.

For alkydsystems: between the layers use the All Meta Prim

Top coat must be an alkyd endlayer: e.g. Vibol Industrial coat

For epoxy and Pu systems: between the layers use the epoxy znf or the All Meta Cryl.

Top coat can be a different kind of coatingsystem. (pu,alkyd..)

For more specific information about the different systems take contact with VIBOL Coatings

Usage information	Air spray	Brush/roller
Type of thinner	Aqua thinner	Aqua thinner
Recommended thinner	0-5 vol%	0-5 vol%
Nozzle orifice	13	/
Material pressure	60 bar	/
Atomizing pressure	1.5 bar	/
Cleaning	Aqua spoelmiddel NKT	Aqua spoelmiddel NKT

SURFACE CONDITIONS

Blasting according to Sa2½

DURABILITY

At least 6 months, provided that it has been stored in closed original packing at a dry and cool spot. Frost free

PACKAGING

5 L -20 L -VAT

These data have been drawn up to the best of our knowledge and were correct at the data of issue. However we cannot accept full responsibility, because de choice of products and circumstances during elaboration of the systems fall outside our judgement. This documentation sheet will not automatically be replaced in case of modification.