



Galvany Shopprimer IZ182(N) is a self-curing, zinc filled inorganic coating. Liquid and Zinc Paste mixed prior to application. It is a weldable inorganic primer. Welds made over Galvany Shopprimer IZ182(N), coated steel are equal in every respect to welds joining uncoated steel prior to fabrication.

It protects cathodically for periods exceeding 12 months in normal and marine environments. Welds splatter does not adhere to damage the coating. Coated steel can be welded as quickly and easily as bare steel at production line speeds, with no loss in strength or consistency of the weld. Dry to touch paint and coatings.

Approved as a Prefabrication primer by Germanischer Lloyd (GL).

Recommended use	It is used as a shop (pre-construction) primer for the protection of steel from corrosion during fabrication. IZ182(N) that is not painting a top coat is applied to pH 5 ~ 10 condition.
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Physical Properties

Finish and Color	Flat. Gray					
Specific gravity	Approx. 1.34 for Mixture of Paste and Liquid.					
Solids by volume	Approx. 35 %					
Spreading rate (Theoretical)	23.3 m ² /L in 15 μm dry film thickness on a smooth surface.					
Flash point	Liquid : 12 °C /54 °F (Closed cup) Paste : 4 °C /39 °F (Closed cup)					
Chemical resistance		Acids	Alkalies	Solvents	Salts	Water
	Splash & Spillage	Fair	Fair	Excellent	Excellent	Excellent
	Fumes	Good	Good	Excellent	Excellent	Excellent
	Immersion	NR	NR	Excellent	NR	NR
* NR : Not Recommended.						

Application details

Surface preparation	Remove any oil, grease, dirt and any other contaminant from the surface before painting by proper method such as solvent cleaning and fresh water washing, etc. * Steel : Blast cleaning to Sa2.5 to obtain 25 ~ 40 μm blast profile.
Method of application	Special thinning and application techniques may be required above or below normal conditions. Spray : Use adequate air volume for correct operation. Hold gun 8 ~ 10 inches from the surface and at a right angle to the surface. Use a 50% overlap with each pass of the gun on irregular surfaces, coat the edges first, making an extra pass later. * For airless spray application ; Nozzle orifice : 432 ~ 584 μm (0.017" ~ 0.023") Output pressure : 9.6 ~ 12.4 MPa

	Fan : 45°~ 90° * For conventional spray : Use agitated pot and maximum 50 feet hose. Keep pot at same elevation as gun. If spraying stops for more than 15 minutes, blow material from hose back into pot. * For Brush or Roller ; For minor touch-up coating only. Use medium bristled brush. Apply with full brush and avoid rebrushing.					
Mixing	Liquid : Paste = 5 : 5 (by volume). Mix separately, then combine and mix the mixture thoroughly prior to application. Use the mixture after filtering with 50 mesh screen.					
Thinning	Under the temperature condition below 25℃/77 °F, diluted up to 40% by volume with Thinner No. 0608. Under the temperature condition above 25 °C/77 °F or windy, use Thinner No. 0614.					
Application conditions		Substrate Temperature		Relative Humidity		
	Normal	4℃~43℃		40%~80%		
	Min.	-18℃		10%		
	Max.	93℃		85%		
Special thinning and application techniques may be required in above or below normal conditions.						
Film thickness	15~25 μm dry.					
Drying time	Substrate temp.	-18℃/0°F	4℃/40°F	16℃/60°F	27℃/80°F	38℃/100°F
	Set to touch	2h	40min	15min	5min	3min
	Dry through	5d	12h	6h	4h	2h
*The actual drying time is subject to the film thickness, ventilation, humidity etc., and drying time under other temperature conditions should be checked and informed by KCC.						
Subsequent Coat	May be topcoated with Galvany IZ 180(N), epoxies, epoxy tars, vinyls, acrylics, chlorinated rubbers, silicones or according to specification. Apply directly to the substrate compatibility with other coatings.					
Pot life	24h at 20 °C/68 °F,					
Recoating interval	At 20 °C and above 60 % R.H., Minimum : 5h Maximum : Free					
Heat resistance temperature	Continuous : 400 °C / 752 °F Non-continuous : 427 °C / 800 °F					

Storage and package	
Shelf life	12 months.
Packing Unit	18 L (Liquid : 9 L, Zinc Paste : 9 L).

Remarks	
Note	Automatic welding ; About 48 inch per minutes of welding rod speed is recommended for Galvany Shopprimer IZ182(N) applied steel. It is depends on the thickness of steel plate and welding rod. This includes the following process; 1) Submerged arc.

2) Flux core.

3) Short arc.

4) Metal inert gas(MIG) Manual welding :

Galvany Shopprimer IZ182(N) can be easily welded by all electrodes with MIL-E numbers between 6010 and 10018.

Galvany Shopprimer IZ182(N) will skin if left in opened cans.

Skin has no effect on performance, but should be removed before using.

Clean tools with Thinner No. 0608 or No. 002 immediately after use.

Remove hardened material with 10 % caustic solution.

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Disclaimer : The information in this data sheet is believed to the best of our knowledge based on laboratory test and practical experience. However, there are many factors affecting the performance of product and the product quality itself, so we are not able to guarantee without the confirmation of the purpose of using the product from us in writing. We reserve the right to change the data without notice and you should check that this data sheet is current prior to using the product.

