



A self-curing, zinc filled inorganic coating. It is packed with two different component, Liquid and Zinc Paste, which need to be mixed before application. It is specially designed weldable inorganic primer. Welds made over Galvany Shopprimer IZ182, coated steel are equal in every respect to welds joining uncoated steel prior to fabrication. It protects the substrate from corrosion with cathodic protection mechanism 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 of consistency of the weld. Dry to touch paint and coatings.

Recommended use	As a shopprimer in shipyards, tank and structural steel fabricating shops and steel mills. It has many cost saving advantages over conventional shopprimers. It is not recommended for exposure to acid, alkalis.
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Physical Properties

Finish and Color	Flat. Grey (1184)
Specific gravity	Approx. 1.1~1.3 for Mixture of Paste and Liquid.
Solids by volume	Approx. 30 %
Spreading rate (Theoretical)	20 m ² /L in 15 μm dry film thickness on a smooth surface.
Flash point	IZ182-A : 4 °C/39 °F (Closed cup) IZ182-B : 13 °C/55 °F (Closed cup)

Application details

Surface preparation	Remove any oil, grease, dirt and any other contaminants 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 : 4.5 ~ 14.6 MPa Fan : 45 °~ 90 ° * For conventional spray ; Use agitated pot and maximum 15 m 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	IZ182-A(PASTE) : IZ182-B(LIQUID) = 6 : 4 (by volume) Mix separately, then combine and mix thoroughly prior to application. Use the mixture after filtering with 50 mesh screen.			
Thinning	Under the temperature condition below 25 °C/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		Paint Temperature	Substrate Temperature	Ambient Temperature
	Standard	4 ~ 35 °C	4 ~ 43 °C	4 ~ 35 °C
	Minimum	-18 °C	-18 °C	-18 °C
	Maximum	54 °C	93 °C	54 °C
	* The surface should be completely cleaned and dried. The surface temperature should be at least 2.7°C (5°F) above dew point to prevent condensation.			
Film thickness	15 ~ 25 μm dry			
Drying time	Substrate temperature	5°C/41°F	20°C/68°F	30°C/86°F
	Set to touch	40 mins	10 mins	5 mins
	Dry through	25 hours	10 hours	5 hours
	* 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.			
Pot life	24 h at 20 °C /68 °F			
Heat resistance temperature	Continuous : 400 °C / 752 °F (Non-immersion service) Non-continuous : 427 °C / 800 °F (Non-immersion service)			
Storage and package				
Shelf life	12months			
Packing Unit	18 L (IZ182-A : 10.8 L, IZ182-B : 7.2 L)			
Remarks				
Note	Automatic welding ; About 48 inch per minutes of welding rod speed is recommended for Galvany Shopprimer IZ182 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 can be easily welded by all electrodes with MIL-E numbers between 6010 and 10018. Galvany Shopprimer IZ182 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.
1'st issue	2015-09-01
Revision	

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.

