

TECHNICAL DATA

PRODUCT: OASIS WELDABLE PRIMER-83

Description	:	OASIS WELDABLE PRIMER-83		
Material Type	:	Economical self curing solvent based zinc silicate shop primer suitable for welding		
Recommended Use	:	Corrosion protection of blast cleaned steel surfaces. Capable of withstanding temperature up to 400°C. Capable of curing at temperature down to 0°C.		
Volume Solids (%)	:	25 ± 3% (ASTM-D2697-91)		
Flash Point	:	Component A: 55°C	Component B : 10°C	
Specific Gravity (Kg/Ltr)	:	1.39 Kg/Litre		
V.O.C.	:	472 gms/Litre		
Colours	:	Grey		
Pack Size	:	5 Litre units when mixed.		
Mixing Ratio	:	2 litre paste in 5 Litre Pail, 3 litres Additive in a polyethylene jerry Can.		
Theoretical Spread Rate (m ² /Ltr)	:	16.7 m ² /Litre		
		Airless Spray	Conventional Spray	
@ Dry Film Thickness	:	15 µm	15 µm	
@ Wet Film Thickness	:	60 µm	60 µm	
		<i>Spreading rates are calculated and due allowance for loss and wastage should be made.</i>		
Drying Time @ temperature	:	15°C	23°C	35°C
To Touch	:	5 minutes	2 minutes	2 minutes
To recoat	:	48 hours	24 hours	14 hours @60%RH
To recoat	:	24 hours	16 hours	10 hours @80%RH
To Handle	:	15 minutes	5 minutes	3 minutes
		These figures are given as a guide only. Factors such as air movement and humidity must also be considered.		
Cleanser or Thinner	:	Oasis Thinner No: 4		
Pot Life	:	15°C 12 hours	23°C 8 hours	35°C 4 hours
Resistance To	:	Moisture - Excellent Abrasion – Excellent	Weather - Excellent (Subject to Zinc Salt) Petroleum Solvents - Excellent	
Recommended Top Coat	:	Prior to overcoating, any water soluble salts produced during weathering must be fully removed by either fresh water washing or flash blasting. The use of a thin sealer or tie coat is recommended before overcoating with high build systems in order to reduce bubbling/pinholing effects. The material is overcoat - able with a wide range of non saponifiable systems such as two pack epoxy ,vinyl, chlorinated rubber and polyurethane etc. The recoating times indicated above are given as guide only. In all cases Oasis Shop Primer should be fully cured prior to overcoating-see test for curing overleaf.		
Application Notes	:	No Dilution Required.		
Shelf Life	:	Use before expiry date on additive bottle – 1 months.		

SAFETY, HEALTH & ENVIRONMENTAL INFORMATION (READ THIS SECTION BEFORE USE) SOLVENT BASED PAINT PRODUCT

- Flammable. Keep away from sources of ignition. Do not smoke.
 - Work only in areas of good ventilation. When used indoors always keep doors and windows fully open during application and drying. When applying for short periods only, a suitable cartridge mask may be worn provided the filter is changed regularly. All respiratory equipment must be suitable for the purpose and meet an appropriate standard approved by the HSE. Refer to your COSSH Assessment.
 - When applying paint it is advisable to wear suitable eye protection. In case of contact with eyes, rinse immediately with plenty of water and seek medical advice.
Remove splashes from skin : use soap and water or a recognized skin cleaner.
 - Keep container tightly closed and keep out of reach of children. Do not use or store by hanging on a hook. Do not empty into wadis, drains or watercourses.
 - Contains no added mercury.
- *This data is subject to change without notice. Please ensure you have the latest copy by checking with our Customer Service Department.

April 2016
Issue 1: Revision:1



APPLICATION DATA

PRODUCT: OASIS WELDABLE PRIMER-83

SURFACE PREPARATION

For better performance we recommend blast clean to Sa 2 ½ BS 7079: Part A1: 1989 (ISO 8501-1: 1988). Average surface profile should be in the range 50 - 75µm. Manually prepared surfaces should be to a minimum standard of St 3 BS 7079: Part A1: 1989 at the time of coating. Ensure surfaces to be coated are dry and free from all traces of surface contaminants.

APPLICATION EQUIPMENT

Airless Spray

Nozzle Size	0.45 mm (18 thou)
Fan Angle	65°
Operating Pressure	120 kg/cm ² (1700 psi)

The airless spray details given above are intended as a guide only. Fluid hose length and diameter, paint temperature and project complexity all have an effect on the choice of spray tip and operating pressure. The operating pressure should be the lowest possible consistent with satisfactory atomisation. As conditions will vary from job to job, it is the applicators' responsibility to ensure that the equipment in use has been adjusted to give optimum performance. In case of any difficulties or queries, please contact Al Gurg Paints L.L.C.

Conventional Spray

Nozzle Size	1.40mm (55 thou)
Atomising Pressure	2.8kg/cm ² (40 psi)
Fluid Pressure	1.4kg/cm ² (20 psi)

The conventional spray details given above are intended as a guide only. It may be found that in some circumstances, slight variations in atomising pressure, fluid pressure and alteration of tip arrangements may provide optimum atomisation. For application by conventional spray, thinning with up to 5% Thinner No. 4 may be required. Adjustment for wet film thickness should be allowed. Thinning will affect VOC compliance.

Brush

The material is suitable for brush application for small areas and for touch up purposes. Application of more than one coat may be required to give the equivalent dry film thickness to one spray applied coat.

APPLICATION CONDITIONS AND OVERCOATING:

Oasis Shop Primer is normally supplied in 2 parts, a paste component and a liquid component. The shelf life of the liquid component before mixing should not be allowed to exceed the expiry date on the container. The Liquid component (which must be homogenous) must be added slowly with mechanical stirring to the paste component (which must be homogenous).

For application by airless spray, sieving through 40 mesh gauze is recommended. Sieving prior to application by conventional spray is not normally required, but may necessary if any lumps or bits are found after mixing. To avoid pigment packing all in gun and pump filters should be removed from the airless spray equipments.

Due to fast drying nature of this product, unused material should not be left in the spray apparatus and all equipment should be immediately cleaned with cleanser thinner no: 4 after use. To prevent settling the mixed product should be continually stirred during the application procedure.

Oasis Shop primer may be applied at temperature down to 0°C, providing that the substrate is dry and at least 3°C above dew point.

The maximum air temperature for the application of this product is 50°C. If it is desired to apply the material at temperature higher than 50°C, please contact Al Gurg Paints Technical Department for advice.

The maximum relative humidity for the application of this product is 95%. To ensure satisfactory curing the minimum is 50%.

Over-application of this material should be avoided as zinc silicate coatings have a tendency to mud cracking if applied at excessive thickness (Typically in excess of 100µm d.f.t). To avoid mudcracking, over application of this product should be avoided.

If is desired to self-overcoat Oasis shop primer to a dry film thickness greater than 100µm, full cure of the first coat must be ensured. Please see the note below on test for curing.

ADDITIONAL NOTES

Drying, curing times and pot life should be considered as a guide only.

Variations in either temperature or humidity can affect the cure rate of Oasis Weldable primer-83.

Test for Curing: First, Rub the applied coating with a clean dry tissue or cloth to remove any dry overspray which may be present. A clean section of tissue/cloth (White) should then be soaked in Oasis Thinner No: 4 and then again rubbed gently on the coating for no longer than 5 seconds, full cure is indicated by the resistance of the film to this test. If No trace of zinc is apparent, then the material is fully cured and overcoatable. If However, there is any removal of the material, it is not fully cured and should not be overcoated. A further test should be carried out after a further period of curing (rating 5 according to ASTM D4752-03).

Both temperature and humidity influence rate of curing of zinc silicate coatings.

Numerical values quoted for physical data may vary slightly from batch to batch.

April 2016
Issue 1: Revision:1



further information please contact –
AL GURG PAINTS L.L.C
Head Office & Factory – P.O. Box 22334,
Sharjah, U.A.E
Tel : (+971)6-5343919 Fax : (+971)6 343983
E-mail : enquiries@agp.ae
Web : www.aglpuae.com