# STEELZ<sup>™</sup> BOND WS



# Sweating Pipes/Wet Steel

## PRODUCT DESCRIPTION

A 100% solids, two component Cycloaliphatic Epoxy Coating. STEELZ<sup>™</sup> BOND WS provides very low permeability along with excellent impact and abrasion resistance. Formulated with a unique moisture insensitive polymer, STEELZ<sup>™</sup> BOND WS may be applied on wet surfaces, or underwater without effect on cure. A special resin modification produces a low modulus, flexible film, making STEELZ<sup>™</sup> BOND WS ideal for painting over existing sound paint without "lifting". Recommended for steel and concrete surfaces.

PRODUCT FEATURES	
<ol> <li>Self-priming on steel and on most concrete applications.</li> </ol>	6. Available in an Antimicrobial formula.
<ol><li>Ideal for marginally prepared surface.</li></ol>	7. Can be rolled with no solvent.
<ol><li>High film build - 20 mil DFT per coat on horizontal surfaces.</li></ol>	8. Outstanding impact and abrasion.
4. May be applied on wet or under water surfaces.	9. Excellent coating for manholes.
5. Cures down to 35°F.	10. Meets all EPA and other air pollution regulations.
TECHNICAL DATA	
COLORS: White, Lt. Gray, Med. Gray	POT LIFE: 40-50 minutes @75ºF
FINISH: Gloss	CLEAN UP: SA-17 or S-74
VOLUME SOLIDS: 100%	APPLICATION: Spray, roll or brush
COVERAGE (Theoretical): 1,604 sq. ft. @	APPLICATION TEMPERATURE: 40°F – 120°F
	DRY SERVICE TEMPERATURE: 170ºF
RECOMMENDED FILM THICKNESS: Two coats	
At 8-20 dry mils @ 80-200 sq. ft. per gal.	SHELF LIFE: 1-year minimum
MIXING RATIO: 3:1 by volume. Mix 3 parts	PACKAGE: 1 gallon and 4 gallon kits
Base (Part A) with 1 part Hardener (Part B)	
	<b>V.O.C</b> .: 0 GMS/L
	THINNING: S-74 Reducer

\* Gloss will exhibit slight variation in brush or rolled film due to orientation of fillers. This does not affect product performance.

#### CHEMICAL RESISTANCE

Acetic Acid, 5% Ammonium Hydroxide, 10% Aqueous Salt Solutions Black Liquor Brine Crude Oil Distilled Water Fresh & Salt Water Gasoline Hydrochloric Acid, 32% Hydrogen Peroxide, 5% Hydrogen Sulfide Jet Fuel Lactic Acid Sodium Hypochlorite, 5% Sodium Hydroxide, 50% Sulfuric Acid, 50% Xylene

#### PRODUCT USES

STEELZ<sup>™</sup> BOND WS is a chemical resistance Epoxy coating ideal for use in paper and pulp mills, chemical processes, waste water treatment facilities, fertilizer plants, electric generating stations, ore recovery facilities, mining sites, refineries, dairies, laundries, dams, marine environments such as pilings, submarine pens, wet ends of paper machines, bleach plants, manholes, pits, sumps, cooling towers, clarifiers, piers, underwater applications, etc., and all kinds of wet processes.

Ideal for upgrading the performance of existing "old paint" surfaces, and for remedial painting of "less-than-ideal" surface preparations or conditions during application. Inclement weather will seldom interfere with paint schedules. When mixed with a blend of silica flour and sand, STEELZ<sup>™</sup> BOND WS may be used to repair underwater, or below grade leaks in steel or concrete structures.

Perfect for use in conjunction with wet abrasive or high pressure water blast preparation. STEELZ™ BOND WS may be applied without



waiting for the surface to dry, therefore, elimination "fall out" contamination.

#### SURFACE PREPARATION

Best method is a near white abrasive blast (SSPC-SP10), but STEELZ<sup>™</sup> BOND WS will perform well over minimally prepared surfaces depending on service requirements. Because of the lack of "standards" for minimal surface preparation, test applications should be made to determine adequate surface cleanliness and compatibility with existing paint.

- a. <u>Steel</u>: Remove oil, grease and other chemical contaminants by solvent wipe or steam cleaning. Abrasive blast to a "Commercial" (SSPC-SP6) or "Near White" (SSPC-SP10) metal finish.
- b. Galvanized Steel/Aluminum: Solvent clean per SSPC-SP1 or steam clean. Sweep blast to achieve a minimum 1 mil profile.
- c. <u>Previously Painted Surfaces</u>: Solvent clean per SSPC-SP1 and/or power wash. Remove loose existing paint by wire brush or other hand tools. Feather edges. Make test application to check for compatibility.
- d. **Concrete**: All new concrete must be cured at least 28 days. For on-grade concrete slabs, check that a moisture barrier film has been used. Testing may be necessary. Check for the presence of hardeners or residual forming membrane curing agents. Repair all cracks, bug holes, spalled concrete, voids, and expansion joints.

#### MIXING INSTRUCTIONS

Stir each component to a uniform consistency with an explosion proof variable speed drill with Jiffy mixer. Then mix 3 parts Base A with 1 part Hardener B for 3 minutes. STEELZ<sup>™</sup> BOND WS may be reduced up to 20% with S-74 Reducer per mixed gallon. Do not substitute reducers.

### <u>V.O.C.</u>

Unthinned	Thinned 5%	Thinned 10%	Thinned 20%
0 lbs/GL	1.28 lbs/GL	1.52 lbs/GL	1.95 lbs/GL
(0 GMS/Liter)	(154 GMS/Liter)	(183 GMS/Liter)	(234 GMS/Liter)

Airless Spray	Graco	Conventional Spray	DeVilbiss
Gun	Silver Plus	Gun	MBC 510 or JGA
Pump	33:1 Extreme	Fluid Tip	D
Tip Range	019"025"	Air Cap	64 or 704
Hose	1/2" ID	Atomizing Pressure	40 psi
Pressure	2500-3000 psi	Pot Pressure	50 psi
		Hose	1/2" ID

APPLICATION PROCEDURE

When spraying, use a 50% overlapping crosshatch pattern to minimize the occurrence of pinholes. Do not apply to surfaces below 40°F or above 120°F. Do not apply over dew or frost. The surface temperature should be at least 5° above the Dew Point. <u>Roller</u> - use a medium nap solvent resistant phenolic core roller.

Brush - use a pure bristle brush.

#### CURE TIME

TEMPERATURE	TACK FREE	MINIMUM RECOAT	MAXIMUM RECOAT
90°F	1 - 2 hours	5 - 6 hours	3 days
75°F	3 - 4 hours	7 - 8 hours	7 days
45°F	8 - 12 hours	36 - 48 hours	10 days

Times may be longer for thickness above 5 dry mils. For safety and proper product curing, good ventilation is necessary when painting indoors or in confined areas. Be sure the batch numbers are all the same to provide uniform color. Epoxy coatings may yellow or darken during application and after final cure. This will affect the color but will have no effect on the performance of the product. Heaters that emit carbon dioxide and carbon monoxide can cause the coating to yellow.



#### CAUTIONS

STEELZ<sup>™</sup> BOND WS Base is combustible. Keep away from all sources of ignition during mixing, application, and cure. STEELZ<sup>™</sup> BOND WS Hardener (Part B) is corrosive and can cause eye and skin irritation as well as allergic reactions. The use of goggles, fresh air masks or NIOSH approved respirators, protective skin cream and protective clothing is a recommended standard practice when spraying coatings. Proper ventilation is always required. This product is sold without warranty as to performance expressed or implied. Users are urged to make their own tests to determine the suitability for their particular conditions.

SEE MATERIAL SAFETY DATA SHEET FOR FULL SAFETY PRECAUTIONS. FOR PROFESSIONAL AND INDUSTRIAL USE ONLY. KEEP AWAY FROM CHILDREN. NOT FOR RESIDENTIAL USE.