

KoldGalv™

High Zinc Dust Content, Galvanized Metal Repair Primer

SELECTION DATA

DESCRIPTION:

920Z KoldGalv (previous code # 920P609) meets the performance of DOD-P-21035, a "high zinc dust content" (zinc rich) epoxy ester primer for iron, steel and galvanized metal. Epoxy ester resins systems are modified alkyds that provide epoxy-like water resistance and adhesion with the simple, single component application and excellent wetting characteristic of alkyds. **920Z** is applied directly to hand cleaned surfaces with brush or spray. Abrasive blasting, etching and special surface treatments are not necessary. Applied **KoldGalv** has +85% pure zinc dust in the dry film. Corrosion protection is nearly equal to hot dipped galvanizing. Salt spray resistance (ASTM B117) is +1,000 hours with literally no effect.

USE:

920Z's design use is "regalvanizing" welds on galvanized metal, i.e. spot priming the welds with a material that deposits equivalent zinc and provides equivalent corrosion exhibition and durability as the original galvanizing. **KoldGalv** is also used as a shop and field applied primer on steel fabrications requiring long term protection in severe atmospheric conditions. Such uses include bridge components, high tension support towers, wind turbine generators and support towers, gas transmission pipe lines and steel shipping containers. Other typical uses include tanks, marine hardware, above water line sip maintenance and construction hardware. **920Z** is acceptable for use as a touchup primer for Cal-trans projects.

ADVANTAGES:

- Meets 420 VOC regulation.
- Excellent long term corrosion inhibition, +1,000 hours salt spray per ASTM B117. No film deterioration, no undercutting.
- Simple, secure, single component application to hand cleaned surfaces.
- No problems when overcoating: no bubbling, no special procedures.

LIMITATIONS:

- Surface must be absolutely dry.
- Do not apply when temperature is less than 5° above dew point.
- Not suitable for submersion service.
- Chemical resistance is function of the finish coat(s). Without a top coat **KoldGalv** has poor chemical resistance.

PHYSICAL PROPERTIES

VOC: [as packaged] 400 g/l – (3.3 lbs./gal.)

ZINC CONTENT: [per ASTM A780] 83%

APPEARANCE: [Gloss at 60°]

Metallic matte 8 – 20

WEIGHT PER GALLON: [average] 19.9 lbs.

FLASH POINT: [setaflash] 54° F.

PACKAGE VISCOSITY: 87 – 97 KU

SOLIDS: [average]

By Weight 83 ± 1 %

By Volume 49 ± 1 %

COVERAGE: [average]

Theoretical at 1 mil DFT 785 sq.ft./gal.

Theoretical at 2 mils DFT 392.5 sq.ft./gal.

Required Minimum DFT 2 mils

Recommended DFT 4 mils

DRY SCHEDULE: [at 50% RH and 2.0 mil DFT]

| | 45° F. | 60° F. | 75° F. | 90° F. |
|-------------------------|---------|---------|---------|----------|
| <i>Dry to Touch</i> | 12 hrs. | 6 hrs. | 3 hrs. | 90 mins. |
| <i>Rainproof-Handle</i> | 32 hrs. | 16 hrs. | 8 hrs. | 6 hrs. |
| <i>Recoat</i> | 48 hrs. | 24 hrs. | 12 hrs. | 8 hrs. |
| <i>Hard Cure</i> | 7 days | 4 days | 48 hrs. | 36 hrs. |

COLOR AVAILABILITY:

Flat metallic gray only. **920Z** cannot be tinted. Color is the zinc metal dust.

ORDER CODE: 920Z
previous code # 920P609

PACKAGING:

Six ea. 1 quart cans per case 34 lbs.

Four ea. 1 gallon cans per case 84 lbs.

One ea. 5 gallon metal pail 103 lbs.

Continued 

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TRIANGLE™



KoldGalv™

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APPLICATION DATA

REQUIREMENTS FOR APPLICATION:

- Surface and ambient temperatures must be +45°F. and a minimum of 5°F. above the dew-point.
- Surface must be cleaned to minimum SSPC-SP1.
- When regalvanizing welds, spatters and any anti spatter must be removed.
- Mill scale must be removed for secure, long term performance.
- Surfaces must be 100% dry and applied material must be protected from all forms of moisture until rainproof as per chart above.
- When spraying a NIOSH respirator is required. Gloves, hood and long sleeves are recommended.

FILM DEVELOPMENT & THICKNESS:

KoldGalv provides optimum performance with a 4 mil DFT. Below 2 mils DFTs corrosion inhibition is inadequate. **KoldGalv** applied to smooth surfaces at a rate of 342 sq.ft./gal will produce a 2 mil DFT with 5% waste.

THINNING:

Limited areas can be brushed at package viscosity. Spray application requires 10 – 30% reduction depending on equipment and available air. In VOC regulated areas **KoldGalv** cannot be reduced with organic solvents. (Maximum reduction to meet 420 g/l requirement is 4 fl. oz. or 3%. **KoldGalv** exceeds 340 as packaged.) Exempt solvents exist but acceptance, health hazard and evaporation rates vary widely. Contact Triangle directly for technical advice/options. Check with appropriate AQMD for acceptance. In unregulated areas reduce with mineral spirits paint thinner in temperatures above 80° F. and with VM&P Naptha in cooler weather.

APPLICATION:

KoldGalv will require mixing with a very low speed or variable speed mechanical mixer before application, but, unless overly thinned, agitation during use is not necessary.

KoldGalv is applied by brush or conventional spray, standard or HVLP. Brushing is used to spot prime welds and to spot prime recessed or otherwise

difficult areas like bolt heads or deep inside corners. Mitt application is appropriate on smaller diameter pipes, channel iron and angle iron. When using a mitt, monitor film thickness closely with a wet gauge.

Spray application requires specialized equipment or 25% ± reduction and multiple coats. A 10% to 25% reduction and a bottom feed pressure pot are recommended.

Airless spray is not recommended. Zinc dust will dry pack behind any tip.

Standard Conventional: Binks 18 Gun 66SS x 67PD lap set, 40 – 50 psi fluid pressure and 80 – 90 psi air pressure. Reduce 10 – 15%.

HVLP: Binks BBR Gun with a 97 fluid nozzle. Reduce 15 – 20%, adjust fluid pressure to produce a 6" stream with no air and use maximum legal air pressure. 20 CFM of free air will be required.

CLEANUP: AT17 Wash Thinner Followed by a rinse with clear mineral spirits. Naptha can be substituted for AT17. Clean skin with a waterless, paint removing hand cleaner.

SAFETY AND HANDLING

FLASH POINT: [setaflash] 54° F. (12° C.)

SHIPPING DESCRIPTION: [CFR 49]

Ground/Air/Vessel: Paint, 3, UN1263, PG II

Required Label: FLAMMABLE LIQUID

Required Marking: PAINT UN1263

IMDG PACKAGING:

FLAMMABLE LIQUID, class 3.2, UN1263, II

IMDG STOWAGE: Category B

UNIFORM FIRE CODE: [CFR 29] CLASS I-B

STORAGE TEMPERATURE: 120° F. max.

SHELF LIFE: [warranted] 1 Year

"HMIS" RATINGS: H - 2; F - 3; R - 0; PP - H

(11/30/01)

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