Product Data Sheet

Transozinc Epoxy Primer ST 1.50

Wintergrade

Product description.

A two pack epoxy primer pigmented with zinc dust for an excellent protection of steel structures against corrosion in industrial and marine environments. The product cures at temperatures down to -10°C.

Physical properties.

Colour/Texture	Green/Flat
Volume Solids	49%
Specific gravity	2.1 gr/ml
VOC	442 gr/liter
Flashpoint	>25°C

	Dry film thickness per coat (µ)	Wet film thickness per coat (µ)	Theoretical spreading rate (m^2/l)
Range	50 – 80	105 –165	9.8 – 6.1
Recommended	50	105	9.8

Application data.

Mixing ratio	By weight, base to hardener: 90.9 to 9.1. By volume, base to hardener: 80 to 20.
Potlife	-5°C: 8 hours, 10°C: 6 hours, 23°C: 4 hours.
Guiding data Airless spray	Pressure at nozzle: 180 -300 bar. Nozzle size: 0.38 - 0.53 mm. Spray angle: 40 - 80 degrees. Volume of thinner: 0 – 3%.
Guiding data Airspray	Pressure. 4 - 6 bar. Nozzle size: 1.2 - 2.0 mm. Volume of thinner: 0 – 10%.
Brush/Roller	Suitable but in general recommended for touch-up of small areas. Volume of thinner: 0 – 5%.
Thinner/Cleaner	Transocean Epoxy Thinner 6.03
Conditions	Humidity: below 90% RH. Temperature of the paint before application: min: 5°C, max: 30°C. Substrate temperature: min: -10°C, max: 30°C. The temperature of the substrate should be at least 3°C above the dew point of the air. Air temperatures and relative humidity must be measured in the vicinity of the substrate.

Drying and recoating times.

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat (1)	
				Minimum	Maximum
-5 °C	6 hours	24 hours	21 days	36 hours	3 months
5 °C	2 hours	16 hours	14 days	24 hours	3 months
10 °C	90 minutes	16 hours	10 days	18 hours	3 months
23 °C	60 minutes	12 hours	7 days	8 hours	3 months

(1) The surface should be dry and free from ice, grease and other contaminants prior to overcoating. When the maximum recoating time is exceeded it may be necessary to roughen the surface to ensure intercoat adhesion. When in doubt, consult your nearest Transocean office.

Surface preparation.

Steel	Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blasting: min. Sa2,5 – ISO 8501:1. Hydroblasting: DW-3 according to STG-2222. Water pressure > 1000 bar (or 15000 psi) Apply Transozinc Epoxy Primer ST 1.50 Wintergrade immediately after the steel has been blasted and the quality of preparation has been approved.
Repair	Corroded areas should be power tool cleaned to ISO-St3, blast cleaned to ISO-Sa2 or better or Hydroblasted to DW 2-3. Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

Recommended paint system.

Transozinc Epoxy Primer ST 1.50 Wintergrade 1 x 50-80 µ dft.

Subsequent anti-corrosive coating with Transpoxy, Transvinyl or Transoprene products.

Worldwide availability

The product is part of the common Transocean product range but local availability is subject to confirmation. Although we strive to supply the same product through the world, slight modifications of the product in some cases may be necessary in order to comply with local conditions and/or national regulations. In such cases an alternative datasheet will issued.

Health and safety.

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators.
As a general rule, avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spillage on the skin should immediately be removed by thorough washing with lukewarm water and soap or a suitable industrial cleaner. Eyes should be flushed with fresh water and medical attention sought immediately.
Spraying should be carried out under well-ventilated conditions. Avoid inhalation of solvent vapours and paint mist by wearing an air mask.
This product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

Disclaimer

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