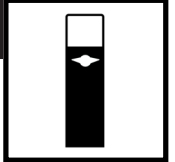


etchweld

self-etching weld-through primer

Product Function



etchweld is a single pack high-performance self-etching primer that provides ultra-high levels of adhesion to steel substrates. etchweld protects surfaces from corrosion and promotes superb adhesion for an enormous range of intermediate and topcoats, even increasing the durability of powder coating. etchweld can be used on some nonmetallic substrates but tests should be conducted before use. etchweld can be used as an adhesion promoter for 2 pack fillers, putties and stoppers. Unlike other etch primers etchweld also provides a weld-through function.

During the assembly of complex steel structures such vehicle bodywork, it is almost unavoidable to use welded seams - often spot welded flanges or folded edges come together so that two bare steel surface are fixed together totally unprotected from corrosive elements. These seams have been proven to be the first sites to corrode in vehicle bodywork.

etchweld is designed to allow any steel surfaces to be protected before assembly, in other words even surfaces destined to be spot welded face-to-face can be painted. Unlike other weld-through primers, which have poor adhesion levels, etchweld combines superb adhesion with exceptional weld through characteristics. etchweld protected steel provides stable arc conditions for MIG and TIG welding and excellent spot-weld performance. etchweld exhibits minimal burn-back from the weld-zone and will continue to protect against corrosion once assembly is complete.

etchweld will also provide high levels of adhesion for coatings applied to non-ferrous substrates such as aluminium

and zinc treated surfaces. etchweld is free of heavy metals and chromates.

How to Use



Aerosol: Always shake the can vigorously for 2 minutes before use. Non-aerosol product should be stirred thoroughly before use and can be thinned up to 50% with cellulose thinners.

WELD-THROUGH

Ensure that the surfaces are clean and free of contaminants such as corrosion, grease, oil, and paint. Where etchweld is to remain uncoated in weld-through applications such as face-to-face flanges two light coats applied at a distance of around 25 cm are recommended at 7 - 10 minute intervals. Before welding it is important to ensure that full flash-off of solvents has occurred - at an ambient temperature of 20°C 1 hour is sufficient, in cold conditions allow up to 3 hours. etchweld can be MIG, TIG, ARC or gas welded. To ensure instant and perfect welds when using spot welding equipment clamp components together initially using clamping equipment such as quick release welder's clamps, mole grips or g-cramps etc. Ensure welder setting is adjusted by testing on scrap steel of identical gauge as the work-piece. Mig welders should be set to produce an even, constant arc, spitting unstable arc is indicative of too high wire speed and can be eliminated by adjustment. After assembly of hollow sections seal seams with seam sealer or further paint coatings, internal sections should be wax injected.

ETCH PRIMER

Adhesion promoter for: Cellulose, synthetic, two-pack, water borne, water based, stoving enamel, powder coat, alkyd etc etchweld should be applied as a uniform coating at around 25cm from the degreased, clean surface, and normally allowed to cure for a period of 30 - 45 minutes before over coating, shorter times are acceptable when using most top coats, however for thick film coatings allow up to 1 hour before top coat application. etchweld will continue to chemically anchor to the substrate under paint films for periods of up to 3 hours. As with any paint system it is good practice to test paint systems at small scale before use.

Please contact our free-of-charge technical help line in the event of any question

BILT-HAMBER laboratories

Radford Way
Billericay
Essex
CM12 0EG

T: +44 (0) 1277 658899
F: +44 (0) 1277 657533
E: sales@bilthamber.com
W: www.bilthamber.com