

MDTS-062 REV.-NIL

DATED: 05-01-2000

**SPECIFICATION OF TECHNICAL REQUIREMENTS OF
WELDABLE PRIMER**

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ISSUE	DETAILS OF CHANGES	DATE
0.0	First Issue	05-01-2000

SCANNED

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MDTS-062

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**SCHEDULE OF TECHNICAL REQUIREMENTS OF
WELDABLE PRIMER**

1.0 Scope -

This specification covers the physical requirements of weldable primer used for application on sheets/plates before welding/ cutting to avoid corrosion on sheets.

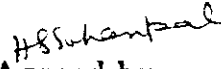
2.0 General Requirements -

The material used should be suitable for application with airless spray as well as by brush, Should not produce any hazardous fumes, Should not burn during welding/ Gas cutting. It should emit least amount of smoke during welding/ cutting without pungent odour. It should not block the nozzle of the spray gun during application. Weldable primer should be compatible with alkyd paint and primer. Transverse tensile strength of butt welded joint should not be less than the parent metal tensile strength.

3.0 Requirements For Single Pack System :

<u>REQUIREMENT</u>	<u>OBSERVATION</u>	<u>METHOD OF TEST</u>
3.1 Finish	Matt or Smooth	IS:101-64 cl. 7.5
3.2 DFT	25 Microns Max.	IS:101-89 pt-3 sec-2
3.3 Drying Time:-		IS:101-89 pt-3 sec-1
a) Surface Dry	15-20 Minute	
b) Hard Drying	Not more than 16 hrs.	
3.4 Binder basis	Modified Alkyd Resin	
3.5 Pigmentation	Aluminium Pigment of fine grade	
3.6 Solid Content	45± 5 % By Weight	
3.7 Solvant Content	50 ± 5% By Weight	IS:101-64 cl-26
3.8 Coverage	Approx. 10 M ² / Litr.	IS:101-64 cl.-8
3.9 Storage	6 month minimum	IS:101-64 cl.-31
3.10 Method of application	By Airless Spray as well as by Brush	
3.11 Viscosity	20-25 Sec.	IS:101-87 pt-1 sec-5
3.12 Pot Life	6 Hrs. Minimum	
3.13 Colour	Aluminium Metallic	

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<u>REQUIREMENT</u>	<u>OBSERVATION</u>	<u>METHOD OF TEST</u>
3.14 Thinner	Suitable Thinner	
3.15 Surface Preparation	The surface should be free from grease, Dust and moisture.	IS:101-86 pt-1 sec-3
3.16 Flash Point	Above 20° C	IS:101-64 cl.24
3.17 Protection against corrosion under condition of condensation	Should not show any corrosion	IS:101-64 cl-18
3.18 Wt.in Kg./10 liter	9.9±0.1 kg.	IS:101-64 cl-25
3.19 Flexibility & Adhesion	No visible damage, detachment or cracking shall observed.	IS:101-88 pt-5 sec-2
3.20 Fineness of grind	20 microns (Max.)	IS:101-87 pt-3 sec-5

4.0 Packing -

Unless otherwise agreed between purchaser and supplier, the primer shall be packed in metal container.

5.0 Marking-

Each container shall be marked with the followings:-

- i) Name of the material
- ii) Source of supply
- iii) Volume of the material
- iv) Batch no. or lot No.
- v) Month and year of manufacturing
- vi) Manufacturer's Name
- vii) Expiry Date

6.0 Inspection-

Samples received from different suppliers shall be tested by RCF before the bulk supply.

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