


**RAIL COACH FACTORY KAPURTHALA**

MD35131

03.03  
Dated: 27.02.2015

Sub: issue of specification no MDTS28272 Rev-nil schedule of technical requirements of Aluminum welding paint.

Please find enclosed a copy of specification no. MDTS28272 Rev- nil schedule of technical requirements of Aluminum welding paint, for information and necessary action at your end.

  
03.03.15  
Dy CME/D-1

CQM, CPLE, CWE(FUR), CMM/HSQ, CMM/TKJ, Dy CMM/Fur/LHB, Dy CCMT,  
Dy CPLE-III

SSE/LIB. Design

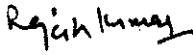



✓ SSE/Records

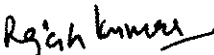
SE/Design/RCF/TKJ

Copy to kind information to:

CDE

Specification	Technical Requirements of Aluminum Welding Paint	MDTS28272 Rev-Nil Page 1 of 3 Date: 26.02.15
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NAME	DESIGNATION	SIGNATURE	DATE	LEVEL
Rajesh Sharma	SSE/Design		24/2/15	Prepared
Joginder Singh	SME/DEV-1		22/2/15	Agreed
Suraj Prakash	Dy CME/D-1		27.02.15	Reviewed
Parmanand Singh	CDE		02.3.15	Approved

  
Prepared By \_\_\_\_\_ Agreed By \_\_\_\_\_

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**1. Scope:-**

This specification covers the physical requirements of aluminum welding paint, for application on sheets/plates before welding/cutting to avoid corrosion on sheets. The coated surfaces are weldable and spot weldable.

**2. General Requirements:-**

The material used should be suitable for application with airless spray as well as by brush, should not produce any hazardous fumes, and should not burn during welding/Gas cutting. It should emit least amount of smoke during welding/welding without pungent odor. 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. This coating material is mainly suitable for the corrosion protection of working surfaces between high-grade steel and sheet-steel (structural steel).

**3. Surface preparation:**

The surface must be free of grease, dust, rust and dross. Radiation derusting is strictly recommended. Coating of phosphated surface is also possible.

**4. Technical data:-**

- 4.1 Binder basis: combination of different resin
- 4.2 Pigmentation: aluminum pigment of fine grade. /Grey color
- 4.3 Undergrounds: all types of steel
- 4.4 Weight in kg/10liter: 9.9±0.1 kg.
- 4.5 Solids content: 43±2 % by weight
- 4.6 Solvent content: max. 59 % by weight
- 4.7 Supply viscosity: > 60 sec.
- 4.8 Thinner: if necessary, use synthetic, for inst. R 11573.
- 4.9 Recommended dry film thickness: 15-30 µm
- 4.10 Drying time:
  - a) Surface Dry 15-20 Minute

Prepared By <i>Rajesh</i>	<i>[Signature]</i> Agreed By
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b) Hard Drying                      Not more than 6 hrs.

- 4.11 Application viscosity:              20-25 sec.
- 4.12 Pot life:                                6 hrs. minimum.
- 4.13 Color:                                  Aluminum metallic/Grey color
- 4.14 Method of application:            brushing, rolling, compressed air-spraying.
- 4.15 Theoretical covering rate:        approx. 12.5 m<sup>2</sup> at 20 μm dry film thickness and 23°C air- temperatures at 50% air-humidity.
- 4.16 Storage stability:                  6 months. minimum
- 4.17 Flash point:                          + 22°C
- 4.18 Protection against corrosion under condition of condensation:                      it should pass 400 hrs salt spray with < 3mm scrip age of salt spray
- 4.19 Fineness of grind:                  20 microns (max)

**5. Marking:**

Each container shall be marked with the following:

- a) Name of the material
- b) Source of supply
- c) Volume of material
- d) Batch no. or lot no.
- e) Month and year of manufacturing
- f) Manufacturer's name
- g) Expiry date