

Mipa Weld-Primer

Item no. 21317 + Colour number

Technical data sheet

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Intended use

Mipa Weld-Primer is a thin-layer primer with very good adhesion to steel, iron and galvanised substrates. Mipa Weld-Primer is suitable for many welding processes such as MIG, TIG or spot welding. Due to the very fast drying time, welding work can begin shortly after application. Due to the very high proportion of active pigments, Mipa Weld-Primer guarantees very high corrosion protection and covers even in thin layers. With the zinc variant, the corrosion protection properties on iron and steel are higher due to the active corrosion protection properties, while copper has a higher conductivity with Mipa Weld-Primer.

Processing instructions



Substrates

Iron, steel and zinc

Pre-treatment / cleansing

Pre-clean with Mipa Silikonentferner.

Detailed information can be found under "Substrate preparation".

Characteristics

Very high coverage

Fast drying

Overcoatable with all common solvent- and water-based 1K and 2K topcoat systems

Can be welded over with various welding processes such as MIG, TIG or spot welding

Excellent adhesion

Very high corrosion protection

Very good conductivity

Colour / gloss level

Zinc (0007), copper (0008) / matt



Preparation

Before use, shake can vigorously for 1 - 2 min!

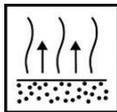


Application

Spray to test - spray distance approx. ca. 20 - 30 cm

1 - 2 spray coats, dry film thickness 10 - 20 µm

Can be welded over up to a max. dry film thickness of 20 µm



Flash-off time

3 - 5 min between sprays



After use

After use, turn can upside down and spray until the valve is clean, this prevents the valve from clogging up.



Drying time at 20 °C

Dust dry after approx.	5 min
Weldable after approx.	20 min



Subsequent processing

Dry sanding:	For 1-layer top coats P 400 For 2-layer top coats P 500 - 600
Wet sanding:	For 1-layer top coats P 600 For 2-layer top coats P 800 - 1000



Processing conditions From +10 °C and up to 80 % relative air humidity. Ensure adequate air ventilation.

Storage Can be stored for 2 years in a cool, dry place.

VOC- regulation EU limit value for this product (cat. B/e): 840 g/l
This product contains max. 750 g/l of VOC.

Safety information See safety data sheet

Processing instruction

Do not overcoat with polyester-based materials

Can be welded over up to a maximum dry film thickness of 20 µm

Substrate preparation:

The substrate must be clean and dry. Remove oil, grease, rust, mill skill, rolling skin as well as other substances impairing the function of the coating!

Remove old coatings or primers that have not cured or are not sound.

Do not use on thermoplastic substrates.

Steel substrates:

1. Pre-clean with Mipa Silikonentferner.
2. Then dry sand with P 180.
3. Afterwards degrease with Mipa Silikonentferner.

Galvanised substrates (strip galvanising / continuous hot-dip galvanising) and electrogalvanising:

1. Pre-clean with Mipa Silikonentferner.
2. Then dry sand with P 220.
3. Afterwards degrease with Mipa Silikonentferner.

Galvanised substrates (batch galvanising / discontinuous hot-dip galvanising), surface cleansing with the ammonia solution Mipa Zinkreiniger:

1. Mix Mipa Zinkreiniger 1 : 1 with water.
2. Wet sand thoroughly with a corundum synthetic non-woven web to a matt finish.
3. Allow the resulting metallic grey suspension to work for approx. 10 minutes.
4. Sand again.
5. Afterwards, rinse thoroughly with water and allow the surface to dry.