

## CORROLESS G3

### MULTI-METAL COATING

#### DESCRIPTION

A single pack MIO coating for use on new and weathered galvanising, and other metals.

#### PRODUCT FEATURES AND RECOMMENDED USES

- Single pack – easy to apply.
- No etch primer or barrier coat required on galvanising.
- Excellent adhesion and flexibility.
- Applications include street furniture, piping, mechanical equipment, railings, tank externals and other steelwork.

#### TECHNICAL DATA

**Volume Solids (±2%)** 43%.

**Volatile Organic Content** 507 g/litre

**Specific Gravity** 1.59 kg/litre.

**Film Thickness** **Wet Film** 116-174 microns. **Dry Film** 50-75 microns per coat (two coats recommended).

**Theoretical Coverage** 8.6 m<sup>2</sup>/litre at 50 microns dft. Practical coverage rate can vary depending on application method, temperature, profile and porosity of the substrate.

**Application** Spray, brush or roller.

**Mixing Ratio** Single pack.

**Pot Life (at 18°C)** Not applicable.

**Drying Times**  
at recommended dft

	10°C	18°C	30°C
<b>Dust Free</b>	2 hours	1 hour	½ hour
<b>Hard Dry</b>	24 hours	16 hours	12 hours
<b>Overcoating Min</b>	24 hours	16 hours	12 hours
<b>Max</b>	Indefinite*	Indefinite*	Indefinite*

**Thinners and Cleaning solvent**

Corroless Thinners No 3. (Solvent Gun Wash may be used for cleaning only).

**Finish** MIO.

**Colours** Grey (approximately similar to 00A05).

**Storage** Product has a shelf life of 2 years when stored in dry, cool conditions and protected from frost.

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### APPLICATION DETAILS

**Surface Preparation**

If required, due to obvious dirt/grease contamination or suspected salt or chemical contamination, clean all surfaces with a water soluble degreaser, wash down with clean, fresh water and allow to dry, before commencing main preparation.

**Recommended substrate:** New and weathered galvanising and zinc coated metal, new and weathered aluminium (for steel, apply over a suitable Corroless primer - consult Corroless for advice).

**Manual preparation:** Clean down and degrease as required. All corrosion products and zinc salts must be removed, ideally by abrading or scrubbing followed by fresh water washing. Any areas of new, bright, smooth galvanising or other metal surface should be abraded to provide a key. Wash down with clean fresh water prior to application. Allow to dry.

**Mechanical Preparation:** Sweep blast to remove loose material and salts and to provide a key. Wash down with clean fresh water prior to application. Allow to dry.

All surfaces when coated should be firm, clean, dry and free from all oil, grease, corrosion salts and other contamination.

**Application**

Method	Airless Spray	Conventional Spray	Brush	Roller
Output Fluid Pressure	2000 psi	Yes – thinning required	Yes	Yes
Tip size	17-19 thou			
Fan angle	30-50°			

**Spraying**

For conventional spray up to 10% Corroless Thinners No.3 should be added.

**Brushing/Rolling**

When brushing, apply unthinned, lay on, do not over brush. When rolling, use a lambs wool roller and a maximum addition of 5% Corroless Thinners No.3.

**Mixing**

Stir thoroughly before use.

**Stripe coating**

Stripe coat all edges, nuts, bolts, welds etc.

**Application Temperature**

Range 2°C - 35°C.

**Ambient Conditions**

Only apply in conditions of good ventilation, which should be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point.

**Overcoating\***

Overcoatable with itself. May also be overcoated with Corroless RF16, when both G3 and topcoat thicknesses should not exceed 50 microns dft. If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water rinse and allow to dry before continuing. \*While overcoating time is indefinite, overcoating within 3 days at 18°C is recommended for best results. Ensure that finely textured MIO surface has not become contaminated before overcoating.

**Flash Point**

Between 21°C - 32°C.

**Health and Safety**

At all times observe precautionary notices on containers. Refer to Material Safety Data Sheets available from Corroless on request.

**AN AXALTA COATING SYSTEMS BRAND**



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