

Corroless G3

Multi-metal Coating

Issue Date: June 2020
Code: 2806001
Page 1 of 2

Product Description	A single pack MIO coating for use on new and weathered galvanising, steel and other metals.				
Features & Use	<ul style="list-style-type: none"> • Single pack and easy to apply • No etch primer or barrier coat required on galvanised steel • Excellent adhesion and flexibility • Contains Corroless Pigment • Applications include street furniture, piping, mechanical equipment, railings structural steel, tank exteriors, bridges, and other galvanised structures 				
Approvals/ Certification	<ul style="list-style-type: none"> • Sold on track record and customer recommendation 				
Finish	MIO finish				
Volume Solids	43% ± 2%				
VOC Content	507 ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	50 µm	116 µm	8.6 m ² /litre	
	Typical	75 µm	174 µm	5.7 m ² /litre	
	Two coats recommended for best results over rusty steel				
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 50 microns DFT	+10°C	+18°C	+30°C	
	Dust Free	2 hr	1 hr	½ hr	
	Hard Dry	24 hr	16 hr	12 hr	
	Overcoating	Minimum	24 hr	16 hr	12 hr
		Maximum	Indefinite	Indefinite	Indefinite
Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
Colours	Grey approximately BS 00A05				
Mix Ratio	Single Pack				
Pot Life	Not applicable				
SG	1.35 kg/lt				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	23-60°C				

Corroless G3

Issue Date: June 2020
Page 2 of 2

<p>Surface Preparation</p>	<ul style="list-style-type: none"> 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 galvanised steel, zinc coated metal, new and weathered aluminium. For steel apply to 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 surfaces should be abraded to provide a key Wash down with clean fresh water and allow to dry before coating Mechanical preparation: Sweep blast to remove loose material and salts and provide a key. Wash down with clean fresh water and allow to dry All surfaces when coated should be firm, clean, dry and free from all oil, grease, corrosion salts and other contamination 										
<p>Mixing</p>	<p>Stir thoroughly before use</p>										
<p>Thinner / Cleaner</p>	<p>Corroless Thinners No.3 (Solvent Gun Wash may be used for cleaning only)</p>										
<p>Application Conditions</p>	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 90% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C</p>										
<p>Application Methods</p>	<table border="1" data-bbox="443 1050 1477 1160"> <thead> <tr> <th>Method</th> <th>Airless Spray</th> <th>Conventional Spray</th> <th>Brush</th> <th>Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>Yes</td> <td>Yes - Thinning required</td> <td>Yes</td> <td>Yes</td> </tr> </tbody> </table> <ul style="list-style-type: none"> Airless spray: output fluid pressure 2000 psi, tip size 17-19 thou Fan Angle 30-50°. For detailed advice contact Corroless Conventional Spray: An addition of up to 10% Corroless Thinners No.3 will be required Brush: apply unthinned, lay on, do not over brush. When rolling, use a short nap lamb's wool roller and a maximum addition of 5% Corroless Thinners No.3. Lay off with a brush to complete the finish 	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes - Thinning required	Yes	Yes
Method	Airless Spray	Conventional Spray	Brush	Roller							
	Yes	Yes - Thinning required	Yes	Yes							
<p>Product Notes</p>	<ul style="list-style-type: none"> Application Temperature: Range 2°C-35°C (Curing will be retarded below 10°C - product will cure down to 2°C but cure will be slow Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with itself. May also be overcoated with Corroless RF16 when both Corroless G3 and topcoat thickness should not exceed 50 µm 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 3-7 days at 18°C is recommended for best results. Ensure that the finely texture MIO surface has not become contaminated before coating 										
<p>Health & Safety</p>	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>										

AN AXALTA COATING SYSTEMS BRAND



The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights. This product is for professional use only.