

# PRODUCT DATA SHEET

## SikaCor® Zinc W

Water dispersed 2-pack-epoxy zinc rich primer for steel

### DESCRIPTION

2-pack, highly pigmented water dispersed zinc-rich primer for steel, based on epoxy resin.

### USES

SikaCor® Zinc W may only be used by experienced professionals.

Heavy duty corrosion protection for steel on bridges, pipelines, vessels, steel constructions etc. in aggressive atmosphere and for surfaces exposed to water. Particularly suited for workshop application as transportable primer.

### CHARACTERISTICS / ADVANTAGES

- Water dispersed
- Favourable environmental rating
- Water- and mechanically resistant
- Overcoatable with solvent containing top coats e.g. SikaCor® EG-1 or SikaCor® EP Color

### APPROVALS / CERTIFICATES

- Tested by the German Railway in accordance to German Standard "TL/TP-KOR-Stahlbauten", Blatt 87.
- Tested for contact areas of plan pre-strengthened screw connections.

### PRODUCT INFORMATION

<b>Packaging</b>	SikaCor® Zinc W	25 kg net.
	Sika® Thinner EG	25 l, 10 l and 3 l
<b>Appearance / Colour</b>	Zinc grey, mat	
<b>Shelf life</b>	6 months	
<b>Storage conditions</b>	In originally sealed containers in a cool and dry environment. <b>Protect against frost!</b>	
<b>Density</b>	~3.1 kg/l	
<b>Solid content</b>	~62 % by volume	
	~88 % by weight	

## TECHNICAL INFORMATION

Chemical Resistance	The fully cured material is resistant to weathering, water and mechanical wears.
Temperature Resistance	Dry heat up to approx. + 150°C Damp heat up to approx. + 50°C

## SYSTEM INFORMATION

System	<u>3-layer system on steel:</u> 1 x SikaCor® Zinc W 1 x SikaCor® EG-1, SikaCor® EP Color 1 x SikaCor® EG-4, SikaCor® EG-5 or others  <u>4-layer system for extreme exposure:</u> 1 x SikaCor® Zinc W 2 x SikaCor® EG-1, SikaCor® EP Color 1 x SikaCor® EG-4, SikaCor® EG-5 or others
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## APPLICATION INFORMATION

Mixing Ratio	Components A : B By weight 89 : 11												
Thinner	Water If necessary max. 2 % water may be added to adapt the viscosity.												
Consumption	Theoretical material-consumption/VOC without loss for medium dry film thickness: <table><tr><td>Dry film thickness</td><td>60 µm</td><td>80 µm</td></tr><tr><td>Wet film thickness</td><td>95 µm</td><td>130 µm</td></tr><tr><td>Consumption</td><td>~0.300 kg/m<sup>2</sup></td><td>~0.400 kg/m<sup>2</sup></td></tr><tr><td>VOC</td><td>~10.3 g/m<sup>2</sup></td><td>~13.7 g/m<sup>2</sup></td></tr></table> <p>Apart from small areas the dry film thickness of SikaCor® Zinc W should not exceed 150 µm per layer.</p>	Dry film thickness	60 µm	80 µm	Wet film thickness	95 µm	130 µm	Consumption	~0.300 kg/m <sup>2</sup>	~0.400 kg/m <sup>2</sup>	VOC	~10.3 g/m <sup>2</sup>	~13.7 g/m <sup>2</sup>
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Product Temperature	Min. + 5°C												
Relative Air Humidity	Max. 85 %, except the surface temperature is significantly higher than the dew point temperature, it shall be at least 3 K above dew point.												
Surface Temperature	Min. + 5°C												
Pot Life	At + 20°C ~8 h <b>Attention! End of pot-life is not recognisable. Observe strictly recommended application time!</b> <b>Warning! Ready mixed material shall not be kept in firmly locked cans or containers as expansion may occur!</b>												
Waiting Time / Overcoating	<u>Between SikaCor® Zinc W and top coats:</u> Min. 8 h  In case of longer waiting times contaminations must be removed prior to further applications.  For contaminated and weathered surfaces we recommend to clean with SikaCor® Wash.												
Drying time	<b>Final drying time</b> Depending on layer thickness and temperature final hardness is achieved within 1-2 weeks.												

# APPLICATION INSTRUCTIONS

## SURFACE PREPARATION

### Steel:

Blast-cleaning to Sa 2 ½ according to ISO 12944-4.

Free from dirt, oil and grease.

For contaminated and weathered surfaces we recommend to clean with SikaCor® Wash.

## MIXING

Stir component A very thoroughly using an electric mixer (start slowly, then increase up to approx. 300 rpm). Add component B carefully and mix both components very thoroughly (including sides and bottom of the container). Mix for at least 3 minutes until a homogeneous mixture is achieved. Fill mixed material into clean container and mix again shortly as described above. During mixing and handling of the materials always wear protective goggles, suitable gloves and other protective clothings. When used as a weldable primer add approx. 3 % water while stirring.

## APPLICATION

The method of application has a major effect on achieving uniform thickness and appearance. Spray application will give the best results. The indicated dry film thickness is easily achieved by airless spray. Adding solvents reduces the sag resistance and the dry film thickness. In case of application by roller or brush, additional applications may become necessary to achieve the required coating thickness, depending on type of construction, site conditions, colour shade etc. Prior to major coating operations a test application on site may be useful to ensure the selected application method will provide the requested results.

### By brush

#### Conventional high pressure spraying:

- Nozzle size 1.8 - 2.5 mm
- Pressure 3 - 5 bar

#### Airless-spraying:

- Pressure min. 180 bar
- Nozzle size 0.38 - 0.66 mm (0.015 - 0.025 inch)
- Spraying angle 40° - 80°

## CLEANING OF EQUIPMENT

### Water

Stainless spray equipment may be cleaned with water, others with Sika® Thinner EG.

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#### **PRODUCT DATA SHEET**

SikaCor® Zinc W

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# BASIS OF PRODUCT DATA

All technical data stated in this Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for the exact product data and uses.

## ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data. Further notes and information data sheets on product safety and disposal can be found on the Internet at [www.sika.de](http://www.sika.de).

### **DIRECTIVE 2004/42/CE LIMITATION OF EMISSIONS OF VOC**

According to the EU Directive 2004/42/CE, the maximum allowed content of VOC (product category IIA / j type Wb) is 140 g/l (Limits 2010) for the ready to use product.

The maximum content of SikaCor® Zinc W is < 140 g/l VOC for the ready to use product.

## LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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