



# CARBOWELD 11 P

- Zinc rich shop primer, self-curing silicate ethyl type.
- With zinc in paste (1)
- The anticorrosive protection of the Carboweld 11 P is excellent even in small thickness.
- Carboweld 11 P does not affect quality and speed of welding and cutting operations.

SPECIFIC GRAVITY ..... 1.35 ( $\pm 0.05$ ) SOLIDS CONTENT BY WEIGHT ..... 48 % ( $\pm 2$ ) SOLIDS CONTENT BY VOLUME ..... 20 % ( $\pm 2$ ) (practical) DELIVERY VISCOSITY AT 20°C ..... 16 sec ( $\pm 2$ ) FLASH POINT ..... < 21°C PACKING ..... 2 components GLOSS ..... Flat COLOUR ..... Grey STANDARD DRY FILM THICKNESS ..... 18 $\mu$ STANDARD WET FILM THICKNESS ..... 90 $\mu$ THEORITICAL COVERAGE ..... 11,1 m <sup>2</sup> /L	<b>CONDITIONS OF USE</b> - TEMPERATURE ..... > - 15 °C * - HUMIDITY ..... < 95 % * MIXING RATIO ..... by weight Veh : 45% by weight zinc : 55% MATURATION BEFORE USE AT 20°C ..... 5 mn POT LIFE AT 15°C ..... 48 hours AT 20°C ..... 36 hours AT 30°C ..... 18 hours DRYING TIME BETWEEN COATS MINIMUM ..... 24 hours with a R.H. of MAXIMUM ..... 70 % DRYING TIME ..... (Humidity 70%) at 100 microns at 20°C ..... at 40°C ..... DUST DRY ..... 3 mn ..... 30 sec TACK FREE ..... 5 mn ..... 60 sec DRY HARD ..... 10 mn ..... 3 mn
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SURFACE PREPARATION PRECEDING COAT TOP COAT	Dry abrasive blast to SA 2,5 grade minimum Profile : 9 < Ra < 15 $\mu$ / CARBOZINC 11 (60 $\mu$ ) or undercoats and finishing paints, pure epoxy, tar epoxy, chlorinated rubber, acrylic types. Do not apply paints with saponifiable binder (take our advice for choice of the middle coat)
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APPLICATION CONDITIONS	AIRLESS SPRAY	CONV. SPRAY	BRUSH/ROLLER
PAINT PRESSURE (Bars)	(depends on the spray machine used and on the thickness)	(depends on the spray machine used and on the thickness)	
AIR PRESSURE (Bars)			
NOZZLE SIZE $\varnothing$ (mm)			
APPLICATION VISCOSITY AT 20°C AF 4	15 seconds	15 seconds	15 seconds
THINNING (% BY VOLUME)	None	None	None
RECOMMENDED THINNER	N° 21, 33 or 15	N° 21, 33 or 15	N° 21, 33 or 15

REMARKS : (1) CARBOWELD 11P distinguishes from CARBOWELD 11 only by preparation of zinc in paste.  
 The dry film thickness on steel is the same as for standard CARBOWELD 11 with zinc powder.  
 Drying time before topcoat depends on the percentage of the relative humidity.



10 rue Pergolèse - 75 116 Paris - TEL : +33 1 45 00 39 85  
 FAX: +33 1 45 00 39 84 - Email: [contact@marineshoppriming.com](mailto:contact@marineshoppriming.com)