

| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|------------------------------------|--|-----|--------|-----|--------|-----|--------|-----|--------|---|--|--|--|--|--|--|-----------------------|--|--|--|--|--|--|--|--------------|------|--|--|--|--|--|--|-----------------------|--------|--|--|--|--|--|--|---------------|-------------------------|--|--|--|--|--|--|-----------|---|--|--|--|--|--|--|------------------|--|--|--|--|--|--|--|----------------------|---|--|--|--|--|--|--|-----------------------|--|--|--|--|--|--|--|-------------|-------------------------------------|--|--|--|--|--|--|
| PRODUCT DESCRIPTION | A two pack, zinc silicate shop (pre-construction) primer providing good corrosion protection even after heating upto 800°C and resistance to damage caused by welding, gas cutting and fairing. Suitable for fast welding processes and offers control of secondary surface preparation requirements. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| INTENDED USES | As a shop (pre-construction) primer for the protection of steel during fabrication and assembly. Suitable for use with controlled cathodic protection. For use at Newbuilding. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| PRODUCT INFORMATION | <table><tr><td>Colour</td><td colspan="7">NQA855-Red Brown, NQA856-Grey, NQA858-Dark Green (Mercosul - Argentina, Brazil, Chile & Uruguay only)</td></tr><tr><td>System Film Thickness</td><td colspan="7">1 coat at 15 microns dry (60 microns wet) per coat</td></tr><tr><td>Finish/Sheen</td><td colspan="7">Matt</td></tr><tr><td>Part B (Curing Agent)</td><td colspan="7">NQA857</td></tr><tr><td>Volume Solids</td><td colspan="7">25% ±2% (ISO 3233:1998)</td></tr><tr><td>Mix Ratio</td><td colspan="7">0.67 volume(s) Part A to 1 volume(s) Part B</td></tr><tr><td>Specific Gravity</td><td colspan="7">Paste (Part A) 1.894-1.991 Binder (Part B) 0.86-0.89 Mixed Paint 1.274-1.332</td></tr><tr><td>Theoretical Coverage</td><td colspan="7">16.7 m²/litre at 15 microns dft, allow appropriate loss factors</td></tr><tr><td>Method of Application</td><td colspan="7">Airless Spray, Brush, Conventional Spray, Roller</td></tr><tr><td>Flash Point</td><td colspan="7">Part A 5°C; Part B 10°C; Mixed 13°C</td></tr></table> | | | | | | | | Colour | NQA855-Red Brown, NQA856-Grey, NQA858-Dark Green (Mercosul - Argentina, Brazil, Chile & Uruguay only) | | | | | | | System Film Thickness | 1 coat at 15 microns dry (60 microns wet) per coat | | | | | | | Finish/Sheen | Matt | | | | | | | Part B (Curing Agent) | NQA857 | | | | | | | Volume Solids | 25% ±2% (ISO 3233:1998) | | | | | | | Mix Ratio | 0.67 volume(s) Part A to 1 volume(s) Part B | | | | | | | Specific Gravity | Paste (Part A) 1.894-1.991 Binder (Part B) 0.86-0.89 Mixed Paint 1.274-1.332 | | | | | | | Theoretical Coverage | 16.7 m²/litre at 15 microns dft, allow appropriate loss factors | | | | | | | Method of Application | Airless Spray, Brush, Conventional Spray, Roller | | | | | | | Flash Point | Part A 5°C; Part B 10°C; Mixed 13°C | | | | | | |
| Colour | NQA855-Red Brown, NQA856-Grey, NQA858-Dark Green (Mercosul - Argentina, Brazil, Chile & Uruguay only) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| System Film Thickness | 1 coat at 15 microns dry (60 microns wet) per coat | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Finish/Sheen | Matt | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Part B (Curing Agent) | NQA857 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Volume Solids | 25% ±2% (ISO 3233:1998) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Mix Ratio | 0.67 volume(s) Part A to 1 volume(s) Part B | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Specific Gravity | Paste (Part A) 1.894-1.991 Binder (Part B) 0.86-0.89 Mixed Paint 1.274-1.332 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Theoretical Coverage | 16.7 m²/litre at 15 microns dft, allow appropriate loss factors | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Method of Application | Airless Spray, Brush, Conventional Spray, Roller | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Flash Point | Part A 5°C; Part B 10°C; Mixed 13°C | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Drying Information | 5°C | | 10°C | | 25°C | | 35°C | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Hard Dry [ISO 9117:90] | | | | | 5 mins | | 4 mins | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Pot Life | 24 hrs | | 24 hrs | | 24 hrs | | 8 hrs | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Overcoating Data - see limitations | Substrate Temperature | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | 5°C | | 10°C | | 25°C | | 35°C | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Overcoated By | Min | Max | Min | Max | Min | Max | Min | Max | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

Note Consult International Paint, minimum of 7 days for appropriate primers.

| | | |
|------------------------|--|--|
| REGULATORY DATA | VOC | 628 g/ltr as supplied (EPA Method 24) 472 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC) |
| | Note: VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances. | |

CERTIFICATION

When used as part of an approved scheme, this material has the following certification:

- Weld Fumes - Trace Gas Measurement during Welding (SLV)
- Weld Fumes - Thermal Degradation on Welding (NOHA)
- Weld Quality - Approved for Overweldable Shop Primers (GL)
- Weld Quality - Approval of Prefabrication Primers (LR)
- Weld Quality - Shop Primers for Corrosion Protection of Steel Plates and Structures (DNV)
- Weld Quality - Russian Maritime Register of Shipping
- Weld Quality - Weldable Prefabrication Shop Primer (ABS)

- IMO PSPC Resolution MSC.215 (82) - Det Norske Veritas (DNV)
- IMO PSPC Resolution MSC.215 (82) - Registro Italiano Navale (RINA)
- IMO PSPC Resolution MSC.215 (82) - Lloyds Register (LR)

Consult your International Paint representative for details.

SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications.
All surfaces to be coated should be clean, dry and free from contamination.

NEWBUILDING

Shop primers should be applied using automatic blasting/spraying equipment.
Blast to a minimum of Sa2½ (ISO 8501-1:2007) or St2 for insulation part inside. Steel grit or a mixture of steel grit of particle size 0.6-1.0mm (24-39 mils) and steel shot of particles size 0.6-1.4mm (24-55 mils) are normally used to give a predominantly angular profile.
Apply Interplate 855 before oxidation occurs. If oxidation does occur the entire oxidised area should be reblasted to the standard specified above.

Consult your International Paint representative for specific recommendations.

Cleanliness

All surfaces to be coated must be clean, dry and free from contamination.

Residual dust levels prior to paint application must not exceed rating "1" for dust size classes "3", "4" or "5" (ISO 8502-3:1993).

Residual soluble salt levels prior to coating application must not exceed 50mg/m² as extracted and measured in accordance with ISO 8502-6 (1995) and ISO 8502-9 (1998) respectively.

Surface profile

The surface profile must lie in the range 30-75 microns (ISO 8503-1/2:1988).

NOTE

**For use in Marine situations in North America, the following surface preparation standards can be used:
SSPC-SP10 in place of Sa2½ (ISO 8501-1:2007)**

APPLICATION

| | |
|-----------------------------------|--|
| Mixing | Material is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. Agitate Paste (Part A) with a power agitator, slowly add binder (Part B) while agitating. Allow to mix for at least 5 minutes, sieve through a 30-60 mesh screen before use. Continue stirring during use. |
| Thinner | GTA820 (Winter Grade), GTA840 (Summer Grade) Not recommended. Use International GTA820, GTA840 only in exceptional circumstances (max 15% by volume). DO NOT thin more than allowed by local environmental legislation. |
| Airless Spray | Recommended Tip Range 0.38-0.58 mm (15-23 thou) Total output fluid pressure at spray tip not less than 60 - 100 kg/cm ² (850 - 1420 p.s.i.) |
| Conventional Spray | Use suitable proprietary equipment. Thinning may be required. |
| Brush | Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness. |
| Roller | Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness. Brush and roller are not suitable for application of full coats. Airless spray should be used for the latter. |
| Cleaner | International GTA820/GTA840 |
| Work Stoppages and Cleanup | Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA820/GTA840. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units. Clean all equipment immediately after use with International GTA820/GTA840. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation. |
| Welding | In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting." |

SAFETY

All work involving the application and use of this product should be performed in compliance with all relevant national Health, Safety & Environmental standards and regulations.

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapour concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.

EMERGENCY CONTACT NUMBERS:

USA/Canada - Medical Advisory Number 1-800-854-6813

Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191

R.O.W. - Contact Regional Office

LIMITATIONS

Drying times will depend on the substrate temperature and ventilation conditions.
If the relative humidity is below 50%, cure will be retarded.
Pot life may reduce to 8 hours (25°C) as Binder (Part B) approaches the end of its shelf life.
Interplate 855 is not recommended for manual spray application.
At higher dry film thickness, fabrication properties (welding and cutting) may be affected.
Shop primers are not recommended for use as touch-up primers after fabrication.

Film Thickness

Minimum Film Thickness

Film thicknesses below the specified 15 microns may result in premature breakdown of the shop primer and substrate corrosion, necessitating additional secondary surface preparation.

Maximum Film Thickness

Film thicknesses above the specified 15 microns may adversely affect welding and cutting properties and may affect the performance of subsequently applied coating systems. Thicknesses above 25 microns should be avoided.

Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations. The temperature of the surface to be coated must be at least 3°C above the dew point. For optimum application properties bring the material to 21-27°C, unless specifically instructed otherwise, prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage in accordance with the information given in the STORAGE section of this data sheet.

Technical and application data herein is for the purpose of establishing a general guideline of the coating and proper coating application guidelines. Test performance results were obtained in a controlled laboratory environment and International Paint makes no claim that the exhibited published test results, or any other tests, accurately represent results actually found in all field environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating.


| UNIT SIZE | Unit Size | Part A | | Part B | |
|--|------------|---|-------|--------|-------|
| | | Vol | Pack | Vol | Pack |
| | 20 Lt | 8 Lt | 20 Lt | 12 Lt | 15 Lt |
| Part B is supplied in a polyethylene container For availability of other unit sizes consult International Paint | | | | | |
| UNIT SHIPPING WEIGHT | Unit Size | Unit Weight | | | |
| | 20 Lt | 26.2 Kg | | | |
| STORAGE | Shelf Life | Low flash storage required. Part A - 12 months at 25°C Part B - 6 months at 25°C Subject to reinspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. | | | |
| | | | | | |

PLACE OF MANUFACTURE

United Kingdom, Brazil. **Selection from this list as appropriate.**

IMPORTANT NOTE

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local International Paint representative that this data sheet is current prior to using the product.

 **International** and product names mentioned in this data sheet are trademarks of, or are licensed to, AkzoNobel.

© AkzoNobel, 2010

www.international-marine.com