

# Corroless ACO Weldcoat

(formerly Acothane Weldcoat)

Issue Date: Aug 2020  
 Issue: 5  
 Page 1 of 2

<b>Product Description</b>	<b>A highly specialised, high build, solvent free, two pack polyurethane</b> coating designed for brush application to pipe girth welds.				
<b>Features &amp; Use</b>	<ul style="list-style-type: none"> <li>• Use for complete corrosion protection in water immersion, soil burial or atmospheric exposure conditions for pipe girth welds</li> <li>• Outstanding physical properties in terms of flexural strength, tensile strength, impact and abrasion resistance</li> <li>• High build, solvent free</li> <li>• Rapid drying and curing characteristics, allowing early completion of coating to recommended film thicknesses</li> </ul>				
<b>Approvals/ Certification</b>	<ul style="list-style-type: none"> <li>• Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection</li> <li>• Meets the performance requirements of BS EN 10290 and AWWA C222</li> <li>• Malaysian SPAN approved</li> <li>• Approvals held in the former name of 'Acothane'</li> </ul>				
<b>Finish</b>	Sheen				
<b>Volume Solids</b>	100%				
<b>VOC Content</b>	0 g/litre				
<b>Film Thickness Range And Coverage</b>		<b>Dry Film Thickness</b>	<b>Wet Film Thickness</b>	<b>Theoretical Coverage</b>	
	<b>Typical</b>	1.0 mm	1.0 mm	1.0 m <sup>2</sup> /litre	
	<b>Typical</b>	1.5 mm	1.5 mm	0.67 m <sup>2</sup> /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
<b>Drying Times</b>	Applied to 1 mm DFT		<b>+10°C</b>	<b>+20°C</b>	
	<b>Dust Free</b>		1 hr	30-45 min	
	<b>Hard Dry</b>		4 hr	3 hr	
	<b>Overcoating</b>	Minimum	1 hr	30 min	
		Maximum	24 hr	24 hr	
Drying and recoating times are related to the substrate temperature					
<b>Colours</b>	Grey, Cream and special shades to order				
<b>Mix Ratio/ Product Code</b>	<b>10WCT</b> (base) and <b>10ACT</b> (activator) Base        3 parts by volume        3.23 parts by Weight Hardener   1 part by volume        1 part by Weight				
<b>Pot Life</b>	Approx. 8 min at 25°C				
<b>SG</b>	1.29 kg/lit mixed				
<b>Storage Conditions</b>	Store in dry, cool conditions and protect from frost				
<b>Shelf Life</b>	Minimum 24 months if stored as above in unopened containers				
<b>Flash Point</b>	Above 60°C				

# Corroless ACO Weldcoat

Issue Date: Aug 2020  
Page 2 of 2

<p><b>Surface Preparation</b></p>	<ul style="list-style-type: none"> <li>All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams</li> <li><b>Steel:</b> blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u></li> <li><b>Concrete:</b> remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of &lt;16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer</li> </ul>										
<p><b>Mixing</b></p>	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Activator must be added to base and thoroughly mixed to ensure an even mix throughout the container – at least 2 minutes mixing time is recommended. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating has cured.</p>										
<p><b>Thinner / Cleaner</b></p>	<p>Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)</p>										
<p><b>Application Conditions</b></p>	<p>Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.</p>										
<p><b>Application Methods</b></p>	<table border="1" data-bbox="443 1099 1476 1232"> <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>No</td> <td>No</td> <td>Yes</td> <td>No</td> </tr> </tbody> </table> <ul style="list-style-type: none"> <li>This product is specifically designed for brush. Other Corroless ACO grades are available for spray application</li> </ul>	Method	Airless Spray	Conventional Spray	Brush	Roller		No	No	Yes	No
Method	Airless Spray	Conventional Spray	Brush	Roller							
	No	No	Yes	No							
<p><b>Product Notes</b></p>	<ul style="list-style-type: none"> <li><b>Activator contains isocyanates</b> – refer to Safety Data Sheet</li> <li>Overcoating: normally after 1 hour and within 24 hours of initial application. Abrading will be required after 24 hours for adhesion</li> <li>In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous</li> <li>Corroless ACO Weldcoat has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice</li> </ul>										
<p><b>Health &amp; Safety</b></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.