

Selection & Specification Data

Generic Type	Self-curing, water-based inorganic zinc primer.	
Description	Carboweld 11 WB is a water-based inorganic zinc rich primer that protects steel galvanically, eliminating subfilm corrosion. It meets VOC regulations while providing the proven performance of silicate zinc rich technology. It may be used as a weldable pre-construction primer or as a primer under many different types of topcoats.	
Features	<ul style="list-style-type: none"> ▪ Excellent corrosion protection ▪ High zinc loading per square foot ▪ Zero VOC ▪ Good resistance to salting ▪ Fast curing, quick handling ▪ Excellent application characteristics (less likely to pump packing or tip plug) 	
Color	Gray (0700) standard. Green (0300) and Red (0500) available on special order.	
Finish	Matte	
Topcoats	May be topcoated with epoxies, acrylics, silicones, or others as recommended. (Mist coats over the CW 11 WB may be required to prevent topcoat bubbling.)	
Dry Film Thickness	0.75 - 1.25 mils (20 - 30 microns) per coat with 50 lbs. zinc for weldability applications Don't exceed 6 mils (150 microns) in a single coat.	
Solids Content By Weight	73% ± 1%	
Zinc content By Weight	77 ± 1%	
Theoretical Coverage Rate (Per mixed gallon by ASTM D2697)	Carboweld 11 WB - 814 mil ft ² Allow for loss in mixing and application.	
VOC Values	As supplied or applied: 0 lbs./gal (0 g/l)	
Dry Temp. Resistance	Continuous:	750°F (399°C)
	Non-Continuous:	800°F (427°C)
Limitations	Do not recoat/topcoat with itself.	

Substrates & Surface Preparation

General	Remove any oil or grease from the surface to be coated with clean rags soaked in Carboline Thinner #2 or Surface Cleaner #3 (refer to Surface Cleaner #3 instructions) in accordance with SSPC-SP1.
Steel	Abrasive blast to a minimum commercial finish in accordance with SSPC-SP6 with a minimum 1 mil (25 microns) blast profile. An angular profile will provide maximum adhesion.

Application Equipment

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

General Guidelines:

Spray Application (General)	Remove any oil or grease from the surface to be coated with clean rags soaked in Carboline Thinner #2 or Surface Cleaner #3 (refer to Surface Cleaner #3 instructions) in accordance with SSPC-SP1.
Conventional Spray	Conventional spray is the preferred method of application for Carboweld 11 WB. Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, with a maximum length of 50', 0.070" I.D. fluid tip and appropriate air cap.
Airless Spray	Airless spray is acceptable if some spray tails can be tolerated. Carboweld 11 WB may be sprayed airless or conventional. Pump Ratio: 30:1 (minimum) GPM Output: 3.0 (minimum) Material Hose: 3/8" I.D. (minimum) Tip Size: 0.017-0.019" Output PSI: 1750-2400 Filter Size: 60 mesh Teflon packings are recommended and available from the pump manufacturer. Prior to use, flush all equipment with Thinner #21 followed by clean potable water. Keep material under mild agitation during application. If spraying stops for more than 10 minutes, recirculate the material remaining in the spray line. Do not leave mixed primer in the hoses during stoppages.
Brush & Roller (General)	Brush for touch-up only. Avoid excessive rebrushing. Use of a roller is not recommended.