



PFI, INC.
PAINTS FOR INDUSTRY

METALIZE® WELDABLE PRIMER

A heavy duty, rust preventative primer designed for structural steel which will be subjected to severe or extended exposure. High purity zinc oxide pigments promote maximum corrosion resistance while allowing the primer to be welded through with no adverse effect on the integrity of the weld point.

- ✓ Military grade
- ✓ Meets SSPC-PAINT #25, SSPC-PAINT #15, MIL-P-11414E, and TT-P-664D performance specifications
- ✓ Outstanding rust and corrosion protection
- ✓ Fully weldable
- ✓ High solids
- ✓ Fast drying
- ✓ Interior / Exterior
- ✓ VOC compliant per SCAQMD

www.pfiinc.net

Rev. October 2018

RECOMMENDED USES

For interior or exterior application to structural steel and other properly prepared ferrous and non-ferrous metal surfaces.

RECOMMENDED SYSTEM

- 1 coat Metalize® Weldable Primer
- 1 coat Metal-Clad® Alkyd Enamel

SURFACE PREPARATION

Surface should be clean, dry, and free of all contaminants such as oil, rust, loose paint, mill scale, and any other detrimental matter to ensure proper adhesion. Ultra-Bond® Metal Cleaner is the recommended cleaning solution for all steel surfaces. The use of Ultra-Bond® will significantly improve adhesion on nonferrous metal surfaces such as aluminum and galvanized steel.

SSPC-SP1 Solvent Cleaning or SSPC-SP2 Hand Tool Cleaning is recommended. For best possible performance, use Commercial Blast Cleaning per SSPC-SP6/NACE 3.

WARNING! The removal of old paint may release lead dust. Lead is toxic and can cause serious illness and brain damage, especially in children and pregnant women. Before removing old paint, ensure the use of proper protective equipment, including a NIOSH approved respirator. For more information, call the National Lead Information Center at 1-800-424-LEAD.

CLEAN UP

Equipment, hoses, and spills can be cleaned with **AC-3 Zero VOC Reducer** or acetone.

TECHNICAL DATA

Vehicle	Modified alkyd
Finish	Flat (0 - 10 units @ 60°)
Color	White, red, gray, and black
Volume Solids	57 - 65% ¹
Weight Solids	76 - 80% ¹
Viscosity	70 - 75 KU ¹
VOC	Less than 275 g/L (2.3 lbs/gal)
Shelf Life	3 years unopened
Packaging	1 gallon, 5 gallon, and 55 gallon containers
Coverage	300 - 400 ft ² / gal (theoretical)
Recommended DFT	2.0 - 3.0 mils
Application	Airless or conventional spray
Drying Time	76°F with 50% relative humidity
To Touch	1 hour
To Handle	3 hours
To Topcoat	12 hours

Note: Drying time is temperature, humidity, and film thickness dependent.

¹ Values may vary by color.

APPLICATION

Ambient Temperature	40°F - 120°F
Relative Humidity	85% maximum
Recommended Reducer	AC-3 Reducer or acetone

Airless

Pressure	2,200 - 3,200 PSI
Hose	0.25" ID
Tip	.015" - .017"
Filter	60 mesh
Reduction	Not Recommended

Conventional / HVLP

Spray Gun	Binks 95 or similar
Fluid Nozzle	63C
Air Nozzle	63PB
Atomization Pressure	50 PSI
Fluid Pressure	15 - 20 PSI
Reduction	As needed up to 20% by vol.

Brush (touch up only)

Material	Nylon/Polyester
----------	-----------------

PRECAUTIONS / ADDITIONAL INFORMATION

Coating performance is dependent on adequate surface preparation and proper application. The information contained in this bulletin is correct to the best of our knowledge. The recommendations and suggestions herein are made without guarantee or representation as to the end result, since the conditions of use, including variations in customer handling and methods of application, are not known and beyond our control. Such information is subject to change and pertains only to the product offered for sale at the time of publication. The user is encouraged to test the complete coating system for adhesion and compatibility prior to full-scale production.

THIS PRODUCT IS INTENDED FOR PROFESSIONAL INDUSTRIAL USE ONLY. Thoroughly review the product label and Safety Data Sheet (SDS) before using. Product information, including the SDS and a copy of this PDS is available online at www.pfiinc.net or by request. This product is free of lead and chrome.

WARRANTY & LIMITATION OF SELLER'S LIABILITY: PFI, Inc. warrants only that the products represented herein meet the formulation standards of PFI, Inc. This warranty shall be in lieu of any other warranty, expressed or implied, including but not limited to any implied warranty of merchantability or fitness for a particular purpose. There are no warranties that extend beyond the description on the face hereof. The buyer's sole and exclusive remedy against PFI, Inc. shall be for replacement of the product in the event a defective condition of the product should be found to exist and the exclusive remedy shall not have failed its essential purpose so long as PFI, Inc. is willing to provide comparable replacement product to the buyer. No other remedy (including but not limited to incidental or consequential damages for lost profits, lost sales, injury to persons or property, environmental injuries, or any other incidental or consequential loss) shall be available to the buyer.