



TECHNICAL DATA SHEET

P-80 Quick Drying Metal Primer

Description

P-80 is a quick drying lead and chromate free weldable rust inhibitive primer formulated for ferrous metals both interior or exterior. A valuable maintenance primer due to its ability to replace a multitude of primers usually required to ensure compatibility with various topcoats. P-80 has good weathering characteristics to protect metal in storage, transit or during construction.

Coating Properties

Coating Category	Phenolic Alkyd
Package Size	Five gallon cans
Mix Ratio	N/A
Viscosity (Mixed) - KU	64 - 69
Recommended Film Thickness	Actual coverage will vary depending on substrate and application method. Please contact your Sales Representative for specific project recommendations.
Wet	5.0 - 6.0 mils
Dry	1.5 - 2.0 mils

Coverage Information

Mixed Volume Solids May vary by Base / Color	32%
Theoretical Coverage	Theoretical coverage at 1.0 mils dry film thickness is 480 sq ft per gallon Actual coverage may vary depending on substrate, application methods, and specified dry film thickness
Applied Coverage	Application at 256 Sq. ft/gallon should yield 1.5 mils DFT.
Pot Life (at 50% RH)	Not applicable, one part product
Shelf Life	Minimum of two years when stored in unopened cans at 70F
Storage	Store in container sized for minimal air pocket
Gloss	0 to 10
Sheen	0 to 10

Approvals / Certifications

Conforms to AWS D11 Weldability testing as a weldable primer at thickness less than 2 mil DFT

Benefits

Fast Dry
Outstanding Application
High Level of Adhesion
Corrosion Resistant
Rust Inhibitive
Excellent Weathering

Markets / End-Uses

For priming interior and exterior iron and steel

Use on Structural Steel and Storage tank exteriors

Excellent coating for protecting metal in storage transit or during construction

Well suited for fab shops for its speed of dry to handle

Bases / VOCs (g/L)

7981	Red Oxide	<570 g/L
731750	Gray	<570 g/L

Substrates

Ferrous Metals





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Substrates and Surface Preparation

Surface preparation is important. All surfaces must be smooth, clean, dry, free of mildew, grease, soap film, sanding dust or other contaminants. Remove all loose or peeling material from previously-painted surfaces. Wash with a mild detergent and water solution. Rinse thoroughly, allow to dry and if needed on glossy or smooth surfaces: scuff sand using 80-120 grit sandpaper. Remove all sanding dust. Do not apply at ambient temperatures below 50F.

Ferrous Metal: Clean metal of any contaminants by pressure washing or solvent wiping per SSPC-SP-1. As a minimum power tool clean the metal per SSPC-SP-3 being careful not to polish the metal. The metal surface should have a profile for the paint to mechanically bond to. Better performance is always achieved with an abrasive blast to a minimum of SSPC-SP-6 Commercial Blast.

Methods of Application

Application Parameters

Relative Humidity	90%
Minimum Temperature	35F (ambient)
Maximum Temperature	110F (ambient)
Continuous:	175F
Intermittent:	225F
Application Comment	In order for the primer to be weldable the wet film thickness applied can not exceed 3.0 mils. <u>Be mindful of film thickness on flatsurfaces and inside corners and do not exceed 5.0 wet mils as this can affect recoatability.</u>
Technical Notes	At 77F and 50% relative humidity: Dry to touch in 30 to 60 minutes Dry to Recoat with <u>Alkyd Enamels</u> in one hour Dry to Recoat with <u>2 part Epoxies or Urethanes</u> in 12 hours
Performance Tips	When topcoating this primer with 2 component Epoxies and Urethanes the dry time should be <u>at least</u> 12 hours A patch test should be <u>done</u> on a flat surface (where excessive film thickness may be) to observe any wrinkling or other surface resulting defects

Equipment Settings

Airless Spray: Pressure 2,000 psi. Tip: .015" to .019"

Brush: Use a good quality pure bristle brush for brushing small areas.

Roller: Use a 1/4" -3/8" nap synthetic cover depending on the degree of texture of the surface to be painted. Use only in small areas.

Note: Because of the fast drying nature of this primer brushing and rolling is limited to stripe coat areas such as edges and welds.

Reducers

Use 799260 Synthetic Reducer as needed

Use 799249 Flow Thinner to brush/roll product and as an additive to prevent dry spray

Equipment Cleaning

Use the recommended thinner for this paint:

799260/Synthetic Reducer

Product Weight

9.52 lb per gallon

Tint Type

This primer is NOT formulated for tinting



Safety Precautions

Safety Precautions: For detailed information please refer to this product's material safety data sheet. A copy of which may be found at our website: www.rodmapaint.com under Products:Product Data Sheets and MSDS.

Flammable & Combustible: Use only in a well ventilated area. Keep away from potential sources of flames or sparks, such as a pilot light on a furnace or an electric motor. Keep out of reach of children. Materials such as rags that are used with this product may begin to burn by themselves. After using, completely immerse used rags in water or lay them out flat separately to dry and then discard.

Updates

Please visit www.rodmapaint.com for the most recent versions of Technical Data Sheets and Material Safety Data Sheets.

Recent Amendments

Check for recent amendments to this data sheet at www.rodmapaint.com

Last Modification date: 02/02/2017

Limitation of Liability

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