

CB 300 - CORRIZON™ - Base primer

DESCRIPTION

Single component, waterborne, Base metal protective **with top painting system**.

RECOMMENDED USE

As a steel primer for new building and maintenance with a tolerant surface preparation

PRINCIPAL CHARACTERISTICS

Fast curing odorless, non-burning, non-exploding, all "green" coat. Applied over corroded steel and new steel. Stops corrosion development & prevents additional damage.

Suitable for use in both new construction and maintenance.

Note:

Protection solution. It is required to get a top paint coating system.

BASIC DATA AT 25°C (68°F)

Number of components	One
Mass density	1.3-1.4 gr/cc
Volume Solids	50-55%
VOC	Under 1.0 gr/lit.
Viscosity	800-1800 mPas•sec
pH	2-4
Dry film thickness	35-45 microns
Wet film thickness	70-90 microns
Theoretical spreading rate	11-14 m ² /lit.
Shelf life	12 months at 4-40°C

APPLICATION CONDITIONS:

Air temperature: 5-40 °C

Substrate temperature: 5-40 °C

Relative Humidity: <85%

SURFACE PREPARATION:

The surface condition can vary from grade A (mill scale) to grade D (pitted steel) as well as partially painted Surface. It must be free from loose particles and oils before application.

Sharp edges, welding's and pits must be stripe coated.

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High Pressure Water Cleaning (HPWC)

Remove all loose paint, mill scale rust, and other foreign materials in accordance with SSPC SP WJ-3 (L) [over 7500 psi/ 500 bar]

The surface to be coated must be clean and free of grease, oil accordance with SSPC-SP-1.

Initial Condition	Degreasing SSPC SP-1	High-pressure water cleaning 500-700 Bar	Degree of flash rust
A - Mill scale	✓	✓	-
B - Mill scale + Rust	✓	✓	L
C - Rust	✓	C WJ-3	L
D - Rust + Pitting	✓	D WJ-3	L
E – Mostly intact paint applied over steel	✓	E WJ-3	L
H – Degraded paint system applied over steel	✓	H WJ-3	L

Corrizon® Base 300 Surface Preparation High-pressure water cleaning -SSPC VIS 4

When high pressure water cleaning is not practical, other surface preparation methods may be used, followed by Degrease to SSPC-SP-1.

power tool cleaning to ISO-St3 (SSPC SP-3)
abrasive blast to ISO-Sa2

in a painted surface which is partially corroded, a high-pressure water cleaning 500 bar or higher is recommended. all loose paint and rust must be removed. Cb300 will treat the rusted surface and adhere to the well adhered paint.

MIXING INSTRUCTIONS:

Mix CB 300 thoroughly to a uniform consistency, with low-speed power agitation (up to 500rpm) prior to use. Thinning is not recommended.

Clean up instructions:

Clean spills and spatters immediately with water.
Clean tools immediately after use with water.

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Methods of Application: Airless Spray, Air spray, Brush, Roller

Spray application

Airless Spray

Pressure	2500-3000 psi
Hose	3/8" ID
Nozzle orifice	0.013"-0.017"
Filter	70 mesh
Dilution	Not recommended

Wash the spray system with water after finishing

CB300 can be applied by:

The following is a guide. Changes in pressures and Nozzle sizes may be needed for proper spray characteristics. Always purge spray equipment before use with water only.

Reducer/Clean up Water

Conventional Spray

Nozzle orifice	1.8 mm
Atomization Pressure	40-60 psi
Fluid Pressure	20-30 psi

Brush

Recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness

Brush Natural Bristle
Dilution Not Recommended

Roller

Cover
Dilution Not Recommended

Use brush for stripe coat, pitted surfaces, holes, edges where there might be a problem applying a uniform even coat with spray

Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity appearance.

In case of wind speed over 11-16knots / 20-29km/h use brush or roll only.

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Wet film thickness (WFT) measurement -To ensure correct film thickness, it is recommended to measure the wet film thickness continuously during application using a painter's wet film comb (ISO 2808 Method 1A).

Dry film thickness (DFT) measurement - When the coating has cured to hard dry state the dry film thickness can be checked to SSPC PA 2 or equivalent

DRYING TIME

Drying time @ 2 mils wet (50 microns):

@	5°C	15°C	25°C	38°C
Surface (touch) dry	4 hours	1 hour	30 min.	15 min.
Dry to over coat, minimum	16 hours	3 hours	1.5 hours	1 hours

RECOMMENDED SYSTEM:

	Material	Thickness (DFT) µm	Thickness (WFT) µm
Primer	CB300	40	80

Note:

For top-coat system, please refer to the Coreteel professional team for advice.

LIMITED WARRANTY

Coreteel warrants its products to conform to Coreteel's claims of performance, Coreteel declares that its products do not infringe on any patent. Coreteel warrants its product to conform to its claimed shelf life.

LIMITATIONS OF LIABILITY

In no event will Coreteel be liable to any party, for damages direct or indirect caused by Coreteel's materials. Coreteel will be liable for a damaged or spilled product, as long as the material handling is performed according to Coreteel's written instructions, and not more than the value of the product.



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RECOMMENDED PAINT APPLICATION LIST

There are several paint manufacturers and many more painting products.

The availability of these materials differs from region to region.

This list shows the options for choosing the products according to the availability of the material in the application region:

Paint System Tambur:

PRODUCT NAME	COATS NO.	MIN. INTERV. BEFORE NEXT COAT [hrs]	WFT [μm]	NDFT [μm]
CB300	1	2	70	30
EPOXY DIVINEX	1	24	220	100
POLYURETHANE	1		100	50
Total				180

PRODUCT NAME	COATS NO.	MIN. INTERV. BEFORE NEXT COAT [hrs]	WFT [μm]	NDFT [μm]
CB300	1	2	70	30
ECOPOXY 80	1	6	210	170
POLYURETHANE	1		100	50
Total				250

Paint System International:

PRODUCT NAME	COATS NO.	MIN. INTERV. BEFORE NEXT COAT [hrs]	WFT [μm]	NDFT [μm]
CB300	1	2	70	40
Intergard 263	1	8	175	100
Interthane 990	1		88	50
Total				190

PRODUCT NAME	COATS NO.	MIN. INTERV. BEFORE NEXT COAT [hrs]	WFT [μm]	NDFT [μm]
CB300	1	2	70	40
Intergard 300	1	10	250	150
Interthane 990	1		88	50
Total				240

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PRODUCT NAME	COATS NO.	MIN. INTERV. BEFORE NEXT COAT [hrs]	WFT [μm]	NDFT [μm]
CB300	1	2	70	40
Interseal 670HS	1	10	250	150
Interthane 990	1		88	50
Total				240

Paint System PPG:

PRODUCT NAME	COATS NO.	MIN. INTERV. BEFORE NEXT COAT [hrs]	WFT [μm]	NDFT [μm]
CB300	1	2	70	40
amercoat 235	1	4	225	150
amercoat 450H	1		75	50
Total				240

Paint System Hempel:

PRODUCT NAME	COATS NO.	MIN. INTERV. BEFORE NEXT COAT [hrs]	WFT [μm]	NDFT [μm]
CB300	1	2	70	40
Hempel's Underwater Primer	1	4.5	130	50
Hempathane HS 55610	1		235	150
Total				240

Note: If it is necessary to choose another paint manufacturer, it is recommended to consult with Coreteel.

It is important to complete a paint application inspection report while performing the application.