



# Dampney Protective Coatings

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## Epodur® 1890 Weld-Thru Primer

### Description

Epodur 1890 weld thru primer is a ready-to-use weldable coating. Apply to metal surfaces in order to provide a rust proof surface and maintain quality welds. This coating offers increased heat resistance, reduced porosity and pin-holing as compared to traditional weldable coatings. Epodur 1890 is a versatile primer easily applied to improve weld efficiency preventing the formation of corrosion that forms between welded substrates especially during prolonged storage periods.

### Uses

- Industrial and marine fabrication facilities
- Industrial and commercial OEM
- Protects plate edges from rusting during storage
- Automotive and fleet repair shops

### Features

- Provides weld-thru aluminum finish
- Easily strike a welding arc
- Minimum burn-back during the welding process
- Increases weld quality by reducing porosity/pinholes
- Safe for use on most metals
- Simple brush, roller or spray application
- Single package - no pot life - low odor
- Air dries quickly - set to touch in 45 minutes

### Surface Preparation

**Steel:** For best results, surfaces should be free from oil, grease, dirt, mill scale, rust, corrosion products, oxides, paint and foreign matter. Abrasive blast surface to commercial grade per Steel Structures Painting Council Specification SSPC-SP6/NACE 3, "Commercial Blast Cleaning". If abrasive blasting is not possible or cannot be permitted, remove mill scale, rust or other surface contaminants per Specification SSPC-SP3, "Power Tool Cleaning."

**Non-ferrous metals:** Prepare in accordance with SSPC-SP16 "Preparation of Non-Ferrous Metals" or NACE 4 "Brush-off Blasting".

### Mixing

Stir thoroughly until the aluminum filler is completely dispersed.

### Application Guidelines

Epodur 1890 may be applied by brush, roller or spray. Airless spray is acceptable (but not preferred) due to possible over application. Thinning is not normally required.

**Steel and non-ferrous metals:** Apply one coat to a .75-1.0 mil dry film thickness.

### Drying Time

At room temperature, Epodur 1890 sets to touch in 45 minutes and may be recoated with itself (if required) in 1 hour.

### Application Equipment

**Brush:** Apply after thorough mixing. If thinning is required, reduce maximum 3% by volume with Dampney 100 thinner. Mix thoroughly after thinner addition.

**Roller:** Apply after thorough mixing. Use short-nap rollers with phenolic cores. Cross roll for uniform coverage. If thinning is required use up to 3% by volume maximum of Dampney 100 thinner.

**Conventional Spray Equipment:** Apply after thorough mixing. If thinning is required, reduce maximum 3% by volume with Dampney 100 thinner.

As a guide only...

Spray Gun	DeVilbiss P-MBC or JGA
Fluid hose*	3/8" I.D.
Air hose	5/16" I.D.
Air cap	704
Fluid nozzle	FF(.055")
Pot pressure	10-15 lbs.
Atomizing pressure	45-50 lbs.
Needle adjustment	Full open
Work distance	8-10"

\*Smaller diameter hoses, or hose lengths greater than 25 feet, may require increased pressure.

**Bulletin 1890**

**Storage**

Store in a cool, dry place, preferably below 80°F

**Clean up**

Clean equipment with Dampney 100 Thinner.

**Precautionary Information**

Keep away from heat, sparks, and open flame. Use only with adequate ventilation. Avoid contact with eyes and skin. Avoid prolonged breathing of vapor or spray mist.

FIRST AID: In case of contact with skin, flush with plenty of water. For eyes, immediately flush with plenty of water for 15 minutes and get medical attention. If exposed to high concentration of vapor, remove to fresh air. If swallowed, CALL A PHYSICIAN IMMEDIATELY. DO NOT induce vomiting. In confined

spaces, observe safety precautions and follow procedures described in OSHA regulations.

Provide adequate forced air ventilation. Require workmen to wear NIOSH-approved air line respirator, and non-sparking footwear. Use only non-sparking tools and equipment. Use only explosion-proof lights and electrical equipment. Make certain all equipment is grounded. Use protective clothing and skin cream. For further information on safety precautions, see appropriate Material Safety Data Sheet (MSDS).

**FOR INDUSTRIAL USE ONLY**

Shipping Weights	1's	5's
Epodur 1890	11 lbs.	48 lbs.
Dampney 100 Thinner	8 lbs.	40 lbs.

**Technical Data**

Characteristics	Endcor 1890
Color	Aluminum Gray
Finish	Flat
Weight per gallon (3.78 liter unit)	9.2 lbs./ 4.17kg.
% Solids by volume	20
Theoretical coverage per gallon*	675 sq. ft. @ 3/4 mil
Operating temperature range	+1150°F/621°C (dry)
Surface temperature at time of application	50°F/10°C minimum
Dry film thickness per coat	0.75-1.0 mil (19-25µm)
Wet film thickness per coat	3.5 – 5 mils (101-127µm)
Flash Point (Pensky-Martens)	45°F (7°C) minimum
Drying time at 70°F	
Set to touch	45 minutes
Recoat time/Cured through	1 hour/12 hours
Shelf Life	1 year
VOC (Volatile Organic Compounds)	5.75 lbs/gal.

\*Note: Epodur 1890 is designed as a weld-thru coating to protect plate edges and weld seams during the fabrication process and is not intended as a long term stand-alone coating system. In most instances Epodur 1890 will be removed during the final blasting and coating process. However, if applying coating directly to Epodur 1890 a test application is suggested to determine suitability of subsequent topcoats.

**Warranty** Dampney protective coating products are expressly warranted to meet applicable technical and quality specifications. The Technical data contained herein are accurate at the date of issuance but are subjected to change without prior notification. No warranty of current accuracy is hereby given or implied. User must contact Dampney to verify correctness before ordering. Dampney assumes no responsibility for coverage, performance or injuries resulting from handling or use and LIABILITY, IF ANY, SHALL BE LIMITED TO PRODUCT REPLACEMENT. In no event will Dampney be responsible for consequential damages, except insofar as mandated by law. Dampney DISCLAIMS ALL OTHER WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.