

## Product Data

- Use as a weldable preconstruction primer or field or shop applied primer
- Permits almost immediate handling, welding, cutting and fabricating
- Can be used with a wide range of topcoats
- Easily applied by automatic spray equipment
- Simple 1:1 mixing ratio
- Chromate and lead free
- EPA compliant in the UK as a blast primer

### Typical Properties

Amercoat 139 is a fast drying, two pack epoxy preconstruction primer, providing protection against corrosion during construction.

- Anti-corrosive, fast drying, weldable preconstruction primer.
- Two pack epoxy based, pigmented with zinc phosphate and iron oxides.
- Tough and adherent on abrasive blast cleaned steel.
- Provides at a dry film thickness of 20-25 µm up to 6 months protection in mild industrial environments.
- Suitable for application by airless or conventional spray, using automatic or manual spray equipment.
- Permits automatic or manual welding and cutting of steel plates and profiles.

### Typical Uses

As a weldable preconstruction primer in shoppriming plants over abrasive blast cleaned steel for flat steel plates and structural steel shapes. A single coat applied at 15 to 25 µm protects against weathering during handling and fabricating. Can be readily cut and welded by automatic and manual methods. After fabrication, overcoat with suitable topcoat systems.

**INDUSTRIAL** - Structural steel, machinery, pipes and tank exteriors in paper mills, oil refineries, power plants, chemical process and waste treatment plants.

**MARINE** - Decks, hulls, bottoms and superstructures of ships, barges and workboats. Piers, offshore platforms and related structures.

### Physical Data

Finish .....	matt		
Colour .....	oxide red and grey		
Substrate .....	abrasive blasted steel		
Components .....	2		
Curing mechanism .....	solvent release and reaction between components		
Dry film thickness .....	15 - 25 µm		
Number of coats .....	1		
Volume solids .....	25% (ASTM D2697, modified)*		
VOC .....	58% by weight / 646 g/l		
Calculated coverage .....	12.5 m <sup>2</sup> /l at 20 µm		
Allow for application losses, surface irregularities, etc.			
Application methods .....	airless or conventional spray		
Potlife (at 20°C) .....	16 hours		
Potlife is dependent on temperature and quantities mixed.			
Drying times (at 25 µm dft)			
	20°C	30°C	40°C
dry to touch (minutes) .....	2	1	½
dry to handle (minutes) .....	10	6	2
before full service (minutes) .....	60	30	15
Induction time .....	10 minutes		
Specific gravity .....	1.13 kg/l (mixed product)		
Mixing ratio (by volume)			
resin .....	1 part		
cure .....	1 part		
Thinner .....	Amercoat 18		
Cleaner .....	Amercoat 12		
Flash points (Closed Cup)			
Amercoat 139 .....	4°C		
Amercoat 18 .....	27°C		
Amercoat 12 .....	24°C		
Packaging			
resin .....	10 l in 20 l can		
cure .....	10 l in 10 l can		
Shipping weight			
resin .....	approx. 15 kg		
cure .....	approx. 10 kg		
Shelf life .....	2 years from manufacturing date when stored indoors in unopened, original containers at 5 to 40°C.		

\* Volume solids is measured in accordance with ASTM D2697 modified. Slight variations ± 3% may occur due to colour and testing variances.

## Approvals and Certificates

Tested and approved as prefabrication primer by Lloyds Register for use in ships  
Testing at the Newcastle occupational Health Agency has shown that no toxic gases are formed in concentrations above the threshold limit values during cutting and welding.  
Approved by the Russian Maritime Register of Shipping.  
Welding test reports are available on request.

## Recommended Systems

TOPCOATING - Suitable topcoats are Ameron epoxies, alkyds, coaltar epoxies, and polyurethanes. Prior to topcoating, the primed surface must be clean and free of contamination, dust and foreign matter; special attention must be given to damaged areas. Damaged areas can be repaired with Amercoat 139 after cleaning by spot blasting or mechanical cleaning methods such as wire brushing, depending on the service conditions. Refer also to the specific requirements and recommendations shown in the product data of the intermediate and topcoats to be applied. For specific recommendations contact your Ameron representative.

## Application Data Summary

For complete information on procedures, equipment and safety precautions, see application instructions. Like all high performance coatings, this product must be applied as recommended to obtain the maximum protection for which this coating is formulated.

SURFACE PREPARATION /EQUIPMENT - Refer to application instructions for Amercoat 139.

### Safety

Since improper use and handling can be hazardous to health and cause fire or explosion, safety precautions included with application instructions must be observed during all storage, handling, use and drying periods. To avoid any confusion that may arise through translation into other languages, the English version of the Product Data/Application instructions will be the governing literature and must be referred to in case of deviations with product literature in other languages.

### Warranty

Ameron warrants its products to be free from defects in material and workmanship. Ameron's sole obligations and Buyer's exclusive remedy in connection with the products shall be limited, at Ameron's option, to either replacement of products not conforming to this warranty or credit to Buyer's account in the invoiced amount of the nonconforming products. Any claim under this warranty must be made by Buyer to Ameron in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. Buyer's failure to notify Ameron of such nonconformance as required herein shall bar Buyer from recovery under this warranty.

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### Limitation of Liability

Ameron's liability on any claim of any kind, including claims based upon Ameron's negligence or strict liability, for any loss or damage arising out of, connected with, or resulting from the use of the products, shall in no case exceed the purchase price allocable to the products or part thereof which give rise to the claim. In no event shall Ameron be liable for consequential or incidental damages.

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