

## PRODUCT DATA SHEET

# Sika® FerroGard®-950 IN

Epoxy based zinc rich protective coating and primer for steel reinforcement

### DESCRIPTION

Sika® FerroGard®-950 IN is two component, low solvent, zinc rich epoxy resin based protective coating and anti-corrosive primer for steel. The use of Sika® FerroGard®-950 IN provides a method of applying galvanic protection by standard paint application methods. It is a cold galvanizing compound preventing corrosion of steel substrates similar to hot dip galvanizing. When applied to a ferrous surface, the zinc in Sika® FerroGard®-950 IN acts as the anode and sacrifices itself to protect the steel, which acts as the cathode.

### USES

- Single coat finish on steel objects which are subject to atmospheric exposure or in multiple coat paint systems as a protective primer
- Anti-corrosion coating for steel structures which are subjected to mechanical wear, e.g., weirs, interior of pressure pipe line, gates, steel liner of penstocks and tanks, etc.

- Protective coating for reinforcement steel bars in reinforced concrete and as a repair material for galvanized steel which has been damaged by cutting, punching, drilling or mechanical damage suffered during transit or during erection works.

### IMPORTANT

Not recommended for:

- Immersion without suitable top coats
- Exposure to strong acids and alkalis

### CHARACTERISTICS / ADVANTAGES

- Excellent corrosion protection
- Easy to apply
- Fast application
- High mechanical properties
- Good adhesion to substrate
- Fast drying and curing
- Resistant to weathering
- Single coat protection for steel

### PRODUCT INFORMATION

<b>Chemical base</b>	Zinc rich epoxy resin	
<b>Packaging</b>	Part A+B	2.00 kg
	Part A	1.88 kg
	Part B	0.12 kg
<b>Shelf life</b>	12 months from date of production	
<b>Storage conditions</b>	The product must be stored properly in original, unopened and undamaged sealed packaging, in dry conditions at temperatures between +5 °C and +35 °C. Protect from frost.	
<b>Appearance / Colour</b>	Part A	Grey liquid
	Part B	Light brown liquid
<b>Density</b>	~2.15 kg/L (Part A+B mixed, +27 °C)	

Solid content by weight	Total solids	~76 %
	Zinc content in mix	~66 %
	Zinc content in dry film	> 85 %

## TECHNICAL INFORMATION

Tensile adhesion strength	≥ 2.0 N/mm <sup>2</sup> (steel substrate, 7 days, +30 °C)	(ASTM D4541)
Thermal resistance	Permanent exposure of dry heat upto +50 °C (No simultaneous chemical and mechanical exposure)	

## SYSTEM INFORMATION

Systems	<b>As primer coat (exposed conditions)</b>	
	Primer coat	1 × Sika® FerroGard®-950 IN
	Top coat	Suitable Sikagard® protective coating
	<b>As primer coat + top coat (covered conditions)</b>	
	Primer coat	1 × Sika® FerroGard®-950 IN
	Top coat	1 × Sika® FerroGard®-950 IN
	Contact Sika representative for available options of Sikagard® protective coating.	

## APPLICATION INFORMATION

Mixing ratio	Part A : Part B = 94 : 6 (by weight)	
Consumption	~0.150–0.250 kg/m <sup>2</sup> These figures are theoretical and do not allow for any additional material due to surface porosity, surface profile, variations in level and wastage etc.	
Ambient air temperature	+8 °C min. / +35 °C max.	
Relative air humidity	75 % max.	
Substrate temperature	+8 °C min. / +35 °C max.	
Substrate moisture content	< 4 % Test method: Sika® Tramex meter, CM - measurement or Oven-dry-method. No rising moisture according to ASTM (Polyethylene-sheet).	
Pot life	~2 hours (2 kg, +30 °C)	
Curing time	<b>Temperature</b>	<b>Full cure</b>
	+10 °C	~10 days
	+20 °C	~7 days
	+30 °C	~7 days
Tack free time	~20 min (+30 °C)	
Waiting time / Overcoating	Before applying Sika® FerroGard®-950 IN on Sika® FerroGard®-950 IN	
	<b>Temperature</b>	<b>Overcoating time</b>
	+10 °C	~4 hours
	+20 °C	~2 hours
	+30 °C	~1 hour
	Before applying top coat on Sika® FerroGard®-950 IN	
	<b>Temperature</b>	<b>Overcoating time</b>
	+10 °C	~8 hours
	+20 °C	~4 hours
	+30 °C	~2 hour

## BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

## APPLICATION INSTRUCTIONS

### EQUIPMENT

#### Mixing Equipment

- Electric single paddle mixer (300–400 rpm)

#### Application Equipment

- Brush: Soft bristle
- Spray: Airless spray machine

### SUBSTRATE QUALITY

The substrate must be clean, dry and free of all contaminants such as rust, dirt, oil, grease, coatings and surface treatments, etc. If in doubt apply on a test area first.

### SUBSTRATE PREPARATION

Steel must be blast cleaned to Sa 2.5 according to EN ISO 12944, Part 4. Alternatively, use a rust remover such as Sika® Rustoff-100 and use waterjet to make steel rust free.

### MIXING

#### IMPORTANT

Mix full units only

1. Mix Part A (resin) until the material is dispersed and a uniform colour is achieved.
2. Add Part B (hardener) to Part A.
3. Mix Part A+B continuously for 2 minutes until a uniformly coloured mix is achieved. Note: Avoid excessive mixing to minimise air entrainment.
4. To ensure thorough mixing, pour materials into another container and mix again for 1 minute to achieve a smooth and uniform mix.
5. During the final mixing stage, scrape down the sides and bottom of the mixing container with a flat or straight edge trowel at least once to ensure complete mixing.

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#### Product Data Sheet

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## APPLICATION

### Brush Application

Apply 1 or 2 coats of coating with a soft brush.

### Spray Application

Using a airless low pressure sprayer, apply a single application sufficient to wet the surface. Avoid over application.

### CLEANING OF TOOLS

Clean all the tools with Sika® Thinner C immediately after use. Hardened material can only be removed mechanically.

## LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for exact product data and uses.

## LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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