

B58W910 **RESIN (WHITE)** PART A PART B B58V910 HARDENER (BLACK)

PRODUCT INFORMATION

Revised: December 20, 2018 PRODUCT INFORMATION TRM.67					
Product Description		Recommended Uses			
STEEL-SEAM FT910 EPOXY PATCHING AND SURFACING COMPOUND is a 100% solids epoxy surfacing compound for steel or patching compound for concrete. It is formulated for ease of application with squeegee, trowel, or airless spray on horizontal,		May be used as a versatile filler/surfacer for uneven surfaces found in formed, open or corroded concrete and masonry surfaces. May also be used as a fairing compound for weld seams, riveted con- nections, lap seams and chine angles in steel tanks prior to epoxy coating and lining applications.			
 vertical or overhead applications. Cures down to 35°F/1.7°C. 100% solids Tolerates moisture during cure Outstanding workability 		 Concrete Uses: To smooth rough concrete To fill bugholes, tie rod holes, cavities, honeycombs and other surface defects on horizontal, vertical, or overhead surfaces To form transition coves at vertical and horizontal coves 			
 Easy to use May be applied from 5 mils to 1/2" wft/dft vertically May be applied up to 1" thick with aggregate addition Cured down to 35°F/1.7°C Reduced or low gaps HAPS 		 Steel Uses: To smooth riveted, lapped or welded seams To fill corrosion pits on steel surfaces To form chine coves and fill sharp angles 			
PRODUCT CHARACTERISTICS Color: Gray		Acceptable for use in Canadian Food Processing facilities (Confirm acceptance of specific part numbers/rexes with your SW Sales			
Volume Solids:	, 100%, mixed		Representative).		
VOC (calculated):	<100 g/l; 1.67 l	b/gal, mixed	PERFORMANCE CHARACTERISTICS		
Mix Ratio:	3:1 by volume		Test Name	Test Method	Results
-	mended Spread		Abrasion Resistance	ASTM D4060	69 mg lost
Coverage:	3" cov 1 mil v	/e ~ 38 lf/gal /e ~ 10 lf/gal wft/dft ~ 1604 sf/gal	Adhesion	Concrete, ASTM D4541; Steel, ASTM D1002	350 psi, 100% con- crete failure (ASTM D4541); 1,400 psi
Drying Schedul	<u>e @ 40.0 mils w</u> @ 35°F/1.7°C	<u>/et (1000 microns):</u> @ 73°F/23°C	Elongation	ASTM D412	(ASTM D1002) 17.9%
	@ 35 F/1.7 C	50% RH	Flammability	ASTM D412	Self-extinguishing
To touch:	6 hours	4 hours	Hardness, Shore D	ASTM D2240	55-60
To recoat:			Tensile Strength	ASTM D412	2,672 psi
minimum: maximum: To cure:	12 hours 4 days 7 days	6 hours 2 days 7 days	Thermal Cycling	ASTM C884, 5 cycles	No cracking
If maximum recoat time Maximum recoat time to topcoat data page.	e is exceeded, abrac is shorter when usi perature, humidity, and 50 minutes ife is 20 minutes	days le surface before recoating. ing polyurea topcoat, refer d film thickness dependent. 30 minutes one			
Shelf Life:		nths, unopened			
	Store i 100°F	ndoors at 40°F (4.5°C) to (38°C)			
Reduction: Clean Up:		commended er R7K54			



PART A B58W910 **RESIN (WHITE)** PART B B58V910 HARDENER (BLACK)

PRODUCT INFORMATION

Revised: December 20, 2018 PRODUCT II	NFORMATION	TRM.67	
Recommended Systems	Surfa	CE PREPARATION	
May be applied directly to prepared concrete or steel. May be applied over 100% solids primers to include:	Surface must be clean, dry, and in sound condition. Removil, dust, grease, dirt, loose rust, and other foreign mater ensure adequate adhesion.		
 Cor-Cote HCR Corobond 100 Dura-Plate UHS Primer 	tion information.	on Bulletin for detailed surface prepara-	
 Macropoxy 920 PrePrime Corobond LT EnviroLastic LT 	Minimum recommended s Iron & Steel: Concrete:	surface preparation: SSPC SP-10/NACE2, 3 mils (75 microns) profile SSPC-SP13/NACE 6, or ICRI	
	Surface	No. 310.2R, CSP 4-6 Preparation Standards	
 May be topcoated with a variety of coatings to include: Acrolon 218 HS Cor-Cote HCR, HCR FF Cor-Cote E.N. 7000 Cor-Cote HP, HP FF Cor-Cote SC-Sewer-Cote 	Condition of Surface White Metal Near White Metal Commercial Blast Brush-Off Blast Hand Tool Cleaning Rusted Power Tool Cleaning Rusted Pitted & Ru	BS7079:A1 SIS055900 SSPC NACE Sa 3 Sa 3 SP 5 1 Sa 2.5 SP 10 2 Sa 2.5 SP 6 3 Sa 2.5 SP 10 2 Sa 2 Sa 2 SP 6 Sa 1 SP 7 4 C St 2 C St 2 SP 2 sted D St 2 D St 2	
Dura-Plate 235Dura-Plate UHS Laminate		Tinting	
Dura-Plate UHS Epoxy	Do not tint.		
EnviroLastic PolyureaMacropoxy 646 Epoxy	Application Conditions		
Phenicon HS EpoxySherFlexExpressCote HCR	Temperature: Air and Surface: Material:	35°F (1.7°C) minimum, 120°F (49°C) maximum 50°F (10°C) minimum, 95°F (35°C) maximum	
	Relative humidity:	At least 5°F (2.8°C) above dew point 85% maximum	
The systems listed above are representative of the product's use, other systems may be appropriate.		Bulletin for detailed application information.	
	Order	ing Information	
	Packaging: Part A: Part B:	11.2 lb / 1.3 Kg/L (~1.5 gal / 5.6L) in a 3 gallon (11.3L) pail 4.4 lb / 0.53 Kg/L (~.5 gal / 1.9L) in a 1 gallon (3.78L) pail	
	Weight per mixed unit:	15.6 lbs. ; 1.9 Kg/L (462 cu. in.)	
	SAFET	Y PRECAUTIONS	
	Refer to the MSDS sheet before use.		
	Published technical data and in Contact your Sherwin-Williams instructions.	nstructions are subject to change without notice. representative for additional technical data and	
	WARRANTY		
DiscLaimer The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin- Williams representative to obtain the most recent Product Data Information and Application Bulletin.	ing defects in accord with applic Liability for products proven defe- tive product or the refund of the determined by Sherwin-William OF ANY KIND IS MADE BY SH STATUTORY, BY OPERATION	y warrants our products to be free of manufactur- able Sherwin-Williams quality control procedures. active, if any, is limited to replacement of the defec- purchase price paid for the defective product as is. NO OTHER WARRANTY OR GUARANTEE IERWIN-WILLIAMS, EXPRESSED OR IMPLIED, OF LAW OR OTHERWISE, INCLUDING MER- 5 FOR A PARTICULAR PURPOSE.	



PART A PART B

B58W910 B58V910

RESIN (WHITE) HARDENER (BLACK)

Revised: December 20, 2018

APPLICATION BULLETIN

TRM.67

SURFACE PREPARATIONS

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Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Iron & Steel (immersion service)

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (3 mils /75 microns). Remove all weld spatter and round all sharp edges by grinding. Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

Iron & Steel (atmospheric service)

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns). Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

Concrete and Masonry

For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 4-6. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910.

Follow the standard methods listed below when applicable:

ASTM D4258 Standard Practice for Cleaning Concrete. ASTM D4259 Standard Practice for Abrading Concrete. ASTM D4260 Standard Practice for Etching Concrete. ASTM F1869 Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete. SSPC-SP 13/Nace 6 Surface Preparation of Concrete. ICRI No. 310.2R Concrete Surface Preparation.

Concrete, Immersion Service:

For surface preparation, refer to SSPC-SP13/NACE 6, Section 4.3.1 or 1.3.2 or ICRI No. 310.2R, CSP 2-3.

Surface Preparation Standards

	Condition of Surface	ISO 8501-1 BS7079:A1	Swedish Std. SIS055900	SSPC	NACE
White Metal Near White Metal		Sa 3 Sa 2.5	Sa 3 Sa 2.5	SP 5 SP 10	1
Commercial Blast Brush-Off Blast		Sa 2.5 Sa 2 Sa 1	Sa 2 Sa 2 Sa 1	SP 6 SP 7	2 3 4
Hand Tool Cleaning	Rusted Pitted & Rusted	C St 2 D St 2	C St 2 D St 2	SP 2 SP 2	-
Power Tool Cleaning	Rusted Pitted & Rusted	C St 3 D St 3	C St 3 D St 3	SP 3 SP 3	2

APPLICATION CONDITIONS

Temperature: Air and Surface:

Material:

35°F (1.7°C) minimum, 120°F (49°C) maximum 50°F (10°C) minimum, 95°F (35°C) maximum At least 5°F (2.8°C) above dew point

Relative humidity:

85% maximum

APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

ReductionNot recommended

CleanupReducer R7K54

Squeegee:

Squeegee.....Flat

Trowel:

TrowelFlat blade For applications over severely damaged or eroded concrete, use a rubber faced grout float trowel.

Putty KnifeAcceptable

Airless Spray

Pump	45:1 (minimum) with gravity feed hopper connected to a high volume lower unit (minimum 220 cc/cycle)
Pressure	
Hose	3/8" ID, with 1⁄4" whip hose
	acceptable
Тір	019031
	Graco Silver Plus, XTR, or Pistol
	Grip Mastic
Filter(s)	remove
Reduction	not recommended

Have material agitated with lids open to ensure rapid mixing. Multiple passes will allow film thickness up to 250 mils. An orange peel appearance is normal. If a smoother finished is desired, 1-2 hours after application use a 1/8" nap roller dampened with R7K54 to smooth the surface. Use a large spatula to continually wipe the material down into the hopper.

If specific application equipment is not listed above, equivalent equipment may be substituted.



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APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

Mixing Instructions: Stir each component with low speed power agitation prior to mixing. Mix 3 parts Part A (white) to 1 part Part B (black) by volume. Mix with low speed drill and Jiffy Mixer for approximately three minutes until uniform gray with no white or black streaks.

Temperature:

Do not apply product when ambient or surface temperatures are below 35°F (1.7°C). Surface temperature must be at least 5°F (2.8°C) above dew point.

Apply paint at the recommended film thickness and spreading rate as indicated below:

Recor	mmended Spread	ing Rate:		
Coverage:	1" cove ~ 38 lf/gal			
-	3" cove	e ~ 10 lf/gal		
	1 mil w	ft/dft ~ 1604 sf/gal		
Drying Schedule @ 40.0 mils wet (1000 microns):				
	@ 35°F/1.7°C	@ 73°F/23°C		
		50% RH		
To touch:	6 hours	4 hours		
To recoat:				
minimum:	12 hours	6 hours		
maximum:	4 days	2 days		
To cure:	7 days	7 days		
If maximum recoat tir	ne is exceeded, abrade	surface before recoating.		
Maximum recoat tim	ne is shorter when usin	g polyurea topcoat, refer		

to topcoat data page. Hardening time is temperature, humidity, and film thickness dependent. Pot Life* 50 minutes 30 minutes *@ 90°F/32°C, Pot Life is 20 minutes Sweat-in-Time: None

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Reducer R7K54. Clean tools immediately after use with Reducer R7K54. Follow manufacturer's safety recommendations when using any solvent.

DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

Performance Tips

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

No reduction of material is recommended as it can affect film build, appearance, and adhesion.

Do not mix previously catalyzed material with new.

Do not apply the material beyond recommended pot life.

Check surfaces of primer, FT910, and subsequent coats for amine blush (oily film). If detected, remove before applying the next layer or coat.

For filling larger defects in concrete, one to four quarts of 30 to 100 mesh aggregate may be added per gallon of mixed FT910, depending on the size of hole and slump required.

Ambient air cured FT910 is acceptable for use on interior of potable water storage tanks and reservoirs when overcoated with an ANSI / NSF Std. 61 certified Sherwin-Williams coating.

Refer to Product Information sheet for additional performance characteristics and properties.

SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions

WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MER-CHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.