BUILDING TRUST

PRODUCT DATA SHEET

SikaCor® EG Phosphat

HIGH-SOLID EPOXY ZINC PHOSPHATE PRIMER

DESCRIPTION

SikaCor® EG Phosphat is a 2-pack primer based on epoxy resin containing zinc phosphate.
Suitable for use in hot and tropical climatic conditions.

USES

SikaCor® EG Phosphat may only be used by experienced professionals.
Designed as primer for steel surfaces exposed to atmospheric conditions.
In combination with 2-pack intermediate and top coats SikaCor® EG Phosphat is a mechanical resistant coating system for rural, urban, industry and sea atmosphere according to 'ISO 12944-5'.
Suitable as welding primer in 20 µm thickness. Test report on request.

CHARACTERISTICS / ADVANTAGES

Combined with 2-pack epoxy intermediate coats and 2-pack PUR top coats:
- Very good corrosion protection
- Excellent chemical, weather and colour stability
- Tough elastic and hard but not brittling
- Insensitive against shock and impact

APPROVALS / CERTIFICATES

- Approved according to German standard 'TL/TP-KOR-Stahlbauten', page 87.

PRODUCT INFORMATION

Packaging	SikaCor® EG Phosphat	30 kg, 15 kg and 3 kg net.
	Sika® Thinner EG	25 L, 10 L and 3 L
	SikaCor® Cleaner	160 L and 25 L
Appearance / Colour	Sand yellow approximately RAL 1002. Red brown approximately RAL 8012. Zinc grey approximately RAL 7005.	
Shelf life	3 years from date of manufacture.	
Storage conditions	In originally sealed containers in a cool and dry environment.	
Density	~1.6 kg/l	
Solid content	~62 % by volume ~80 % by weight	

TECHNICAL INFORMATION

Chemical Resistance

Combined with 2-pack epoxy intermediate coats and 2-pack PUR top coats: Weathering, water, sewage, seawater, smoke gas, de-icing salts, acid and lye vapours, oils, grease and short term exposure to fuels and solvents.

Temperature Resistance

Dry heat up to +100 °C, short term up to +150 °C.
In case of higher temperatures please consult Sika Technical Department.

SYSTEMS

Systems

Steel:
1 - 2 x SikaCor® EG Phosphat

Suitable intermediate and top coats:
2-pack top coats of our SikaCor® and Sika® Permacor® range.

APPLICATION INFORMATION

Mixing Ratio

	Components A : B
By weight	90 : 10
By volume	4.9 : 1

Thinner

Sika® Thinner EG
If necessary maximum 5 % Sika® Thinner EG may be added to adapt the viscosity.

In case of using SikaCor® EG Phosphat as weldable shop coating add approximately 20 % by weight Sika® Thinner EG.

Consumption

Theoretical material-consumption/VOC without loss for medium dry film thickness:

Dry film thickness	20 µm	80 µm
Wet film thickness	30 µm	130 µm
Consumption	~0.050 kg/m²	~0.205 kg/m²
VOC	~10.3 g/m²	~41.3 g/m²

The dry film thickness of the primer coat does not respect the correction factors on rough surfaces according to ISO 19840.
With SikaCor® EG Phosphat up to 120 µm dry film thickness can be achieved by airless spraying.

Product Temperature

+5 °C min. / +35 °C max.

Relative Air Humidity

Maximum 85 %, except the surface temperature is significantly higher than the dew point temperature, it shall be at least 3 °C above dew point.

Surface Temperature

+5 °C min. / +35 °C max.

Pot Life

+10 °C	~12 h
+20 °C	~8 h
+30 °C	~5 h

Drying Stage 6

	Dry film thickness 80 µm
+5 °C	10 h
+10 °C	7 h
+20 °C	3.5 h
+40 °C	25 min
+80 °C	15 min

(ISO 9117-5)

Waiting Time / Overcoating

Minimum waiting time until drying stage 6 is achieved to maximum 1 year.
In case of longer waiting times please contact Sika Technical Department.

Make sure that all contamination is removed before overcoating with topcoats (see below: surface preparation).

Drying time

Final drying time
Depending on film thickness and temperature full hardness is achieved after 1 - 2 weeks. Tests of the completed coating system should only be carried out after final curing.

APPLICATION INSTRUCTIONS

SURFACE PREPARATION

Steel:
Blast cleaning to Sa 2 ½ according to ISO 12944, part 4.
Free from dirt, oil and grease.

For contaminated and weathered surfaces we recommend to clean with SikaCor® Wash.

MIXING

Stir component A very thoroughly using an electric mixer (start slowly, then increase up to approximately 300 rpm). Add component B carefully and mix both components very thoroughly (including sides and bottom of the container). Mix for at least 3 minutes until a homogeneous mixture is achieved. Fill mixed material into clean container and mix again shortly as described above.

APPLICATION

The method of application has a major effect on achieving uniform thickness and appearance. Spray application will give the best results. The indicated dry film thickness is easily achieved by airless spray. Adding solvents reduces the sag resistance and the dry film thickness. In case of application by roller or brush, additional applications may become necessary to achieve the required coating thickness, depending on type of construction, site conditions, colour shade etc. Prior to major coating operations a test application on site may be useful to ensure the selected application method will provide the requested results.

By brush and roller

Conventional high pressure spraying:
- Nozzle size 1.5 - 2.5 mm
- Pressure 3 - 5 bar
- Oil and water trap is compulsory

Airless-spraying:
- Pressure minimum 180 bar
- Nozzle size 0.38 - 0.53 mm (0.015 - 0.021 inch)
- Spraying angle 40°- 80°

CLEANING OF EQUIPMENT

SikaCor® Cleaner

BASIS OF PRODUCT DATA

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

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 the exact product data and uses.

ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

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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