



ICI Devoe Coatings is a member of the ICI Paints World Group

CATHA-COAT® 313

Organic Zinc-Rich Epoxy Primer

Cat. # 313KXXXX
(Special Order)

PRODUCT DESCRIPTION

Generic: Organic Zinc-Rich Epoxy Primer

General Description: A high performance, two-component, organic zinc-rich primer for cathodic protection of steel structures.

Typical Uses: Ideal for cathodic protection of steel structures, tanks, bridges, equipment, piping and other steel surfaces exposed in mild to severe industrial environments.

Also ideal for touch-up and maintenance work because of its easy application, wide compatibility and fast dry-to-recoat.

Special Qualifications: Meets SSPC Paint 20, Type II.

SPECIFICATION DATA

Color: Green (313K0250)

Finish: Flat

Reduction Solvent: T-10 Thinner

Clean-up Solvent: T-10 Thinner

Weight/Gallon: 22.4 lbs./gal. (2.64 kg/L)

VOC (EPA 24): 2.37 lbs./gal. (282 g/L)

Solids By Volume: 78% (wet/dry method)

Theoretical Coverage at 1.0 Mil Dry: 1251 sq. ft. (31 m²/L)

Recommended Film Thickness: 2.0-4.0 mils (50-100 microns) dry – 2.6-5.0 mils (65-125 microns) wet

Service Temperature Limits: 250°F (121°C) dry

Minimum Dry Time (ASTM D 1640): At 3 mils (75 microns) DFT

Substrate Temperature	40°F (4°C)	60°F (16°C)	80°F (27°C)
Minimum Recoat	4.5 Hours	2 Hours	1 Hour
Dry Hard	13 Hours	7 Hours	4 Hours
Maximum Recoat			
Self	30 Days	30 Days	30 Days

Warning: The above table provides general guidelines only. Always consult your ICI Devoe Coatings Specialist for appropriate recoat windows since the maximum aged recoat time of this product may be significantly shortened or lengthened by a variety of conditions, including, but not limited to humidity, surface temperature, and the use of additives or thinners. The use of accelerators or force curing may shorten the aged recoat of individual coatings. The above recoat windows may not apply if recoating with a product other than those listed above. If the maximum aged recoat window is exceeded, please consult your ICI Industrial Coatings Specialist for appropriate recommendations to enhance adhesion. Failure to observe these precautions may result in intercoat delamination.

Shelf Life: Over 24 months at 77°F (25°C) – unopened

Hardness (ASTM D 3363 – 7 day cure @ 77°F (25°C): 6H

Mix Ratio By Volume: 9 (base): 1 (converter) – see mixing instructions.

Induction: 15 minutes at 60°F (16°C) – see mixing instructions.

Pot Life: 6 hours @ 77°F (25°C) & 50% R.H.

Percent Zinc Content: 81% ± 2% in dry film.

Systems: Please consult the appropriate system guide, the particular job specification or your ICI Devoe Coatings' Industrial Coatings Specialist for proper systems using this product. Systems must be selected considering the particular environment involved.

FEATURES

Advantages:

- Exceptional corrosion resistance
- Provides cathodic protection
- Easy to mix
- Zinc premixed in base component
- Fast dry to handle and recoat
- Applies easily by brush, roll or spray
- Accepts a wide variety of topcoats for severe exposures
- Formulated without lead, chromate, or mercury components
- Low VOC

Limitations of Use: Do not topcoat with alkyd or alkyd-urethane coatings. Not suitable for solvent or chemical immersion.

PERFORMANCE DATA

Salt Spray Resistance: (ASTM B 117) – Excellent

Adhesion: (ASTM D 4541) – Excellent

Humidity Resistance: (ASTM D 2247) – Excellent



A member of the ICI Paints World Group

FINISHES
SPECIAL COATINGS (9800)

FINISHES
SPECIAL COATINGS (9800)

ICI DEVOE COATINGS
A member of the ICI Paints World Group



GENERAL SURFACE PREPARATION

All surfaces must be sound, dry, clean, free of oil, grease, dirt, mildew, form release agents, curing compounds, loose and flaking paint and other foreign substances. Round off welds and sharp edges and remove weld splatter.

New Surfaces: Steel – Abrasive blast to minimum SSPC-SP6 (SSI-Sa2). A cleaner surface (i.e. SSPC-SP10, SSI-Sa2½ near-white) will enhance primer and system performance. The blast profile should be jagged rather than “peened” and between 1½ to 2½ mils (38-62 microns). After blasting, vacuum or blow off all abrasive dust and

ensure surface remains clean before painting.

Previously Painted Surfaces: Remove old paint to bare metal. Prepare surface and prime as for new steel. Achieve a minimum of SSPC-SP6 (SSI-Sa2) on rough or pitted steel.

DIRECTIONS FOR USE

Tinting: Do not tint.

Thinning: Thinning is not normally required or desirable. However, at lower temperatures, small amounts (10% or less) of Devco T-10 Thinner can be added to the mixed components depending on local VOC and air quality regulations.

Mixing: CATHA-COAT 313 Primer is supplied in either a 5 gallon or 1 gallon kit which contains the proper ratio of ingredients. The entire contents of each container must be mixed together. The zinc metal is ready-mixed in the base portion. Stir thoroughly with a slow speed mixer while slowly adding the converter. Continue to mix at slow speeds to a homogeneous condition. At temperatures of 60°F (16°C) or below, allow a 15 minute induction time before using. Add about 10 minutes for each 10°F (6°C) lower temperature. The pot life, 6 hours at 77°F (25°C), will be longer at lower temperatures and shorter at higher temperatures.

Application: Spray, roller or brush. Use brush and roller primarily for touch-up and repair. Spray is preferred for uniform film build. Use agitated spray pots. For air spray, use a .070” or larger tip, 15 psi fluid pressure, fluid hose 1/2” I.D. and maximum 50 ft. length. For airless

spray, use a sprayer capable of 3,000 psi (207 bars) and able to support a .025” diameter tip, fluid hose 3/8” I.D. and maximum 50 ft. length. Pressure pots or pumps should be kept at same level or above spray guns. Keep fluid pressures to minimum. Rough or heavily pitted steel requires higher (or increased) dry film thickness for optimum protection. Care should be taken to ensure that proper film thicknesses are applied.

Spreading Rate: Apply at 225-450 sq.ft. per gallon (6-11 m²/L) depending on surface texture and porosity. Make allowances for any losses due to overspray or surface irregularities.

Topcoats: CATHA-COAT 313 can be readily recoated with itself for easy touch-up. May be topcoated with DEVCO® 224HS or BAR-RUST™ Epoxy Coatings. No tie coat is required before applying finish coat. Do not topcoat with alkyd or alkyd-urethane coatings.

Dry Time: At 77°F (25°C) & 50% R.H., dries to recoat in 1½ hours; hard in 6-8 hours.

Clean-up: Use T-10 Thinner.

PRECAUTIONS

For industrial use only. Keep out of reach of children. Consult Material Safety Data Sheets appropriate for this product for important health and safety information prior to use.

	COMPONENT	HEALTH	FLAMMABILITY	REACTIVITY
HMIS DATA	313 BASE 313B0250	2*	3	2
	313 CONVERTER 313C0910	2*	3	1

* Indicates possible chronic health hazard

SHIPPING

Freight Classification: Paint, 3, PG III, UN1263 (Flammable Liquid)
Flash Point: 80°F (27°C)
Packaging: 1 gallon kit (3.785L) 5 gallon kit (18.925L)
 0.90 gallon base 4.50 gallon base
 0.10 gallon converter 0.50 gallon converter

Shipping Weight: 4 - 1 gallon kits - 99 lbs. (44.9 kg)
 5 gallon kit - 118 lbs. (53.5 kg)

313KXXXX (10/01)
 Ad Stock #68655A



Cleveland,
 Ohio, U.S.A.
 800-654-2616
www.devcocoatings.com

ICI Devco Coatings is a member of the ICI Paints World Group

LIMITATION OF LIABILITY: To the best of our knowledge, the technical data contained herein are true and accurate at the date of issuance but are subject to change without prior notice. We guarantee our product to conform to the specifications contained herein. WE MAKE NO OTHER WARRANTY OR GUARANTEE OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND FITNESS FOR PARTICULAR PURPOSE. Liability, if any, is limited to replacement of the product or refund of the purchase price. LABOR OR COST OF LABOR AND OTHER CONSEQUENTIAL DAMAGES ARE HEREBY EXCLUDED.