

TECHNICAL DATA SHEET

COATIX®

Steelcoat Primer M50

(Surface Tolerant Epoxy Primer)

Product Description

Two component, surface tolerant epoxy primer containing anti corrosive pigments, with high filling power and mechanical strength. It is specially formulated for surfaces where optimum surface preparation cannot be achieved or is not desired. It adheres well to rusted surfaces and prevents rust bleeding. It has excellent adhesion, filling, and sandability properties. Provides excellent results on surfaces such as iron, steel, aluminum, galvanized steel, and polyester. Suitable for properly prepared carbon steel surfaces and previously painted substrates.

Product Code:

Areas of Application

- Industrial facilities and pipelines
- Offshore environments, refineries, power plants, bridges, buildings, mining equipment, and general structural steel
- Marine applications
- Automotive, agricultural, and commercial vehicles

Advantages

- Can be used as an intermediate coat, topcoat, or single coat on structures exposed to atmospheric conditions and underwater areas.
- Provides long term protection in highly corrosive environments.
- Excellent adhesion strength.
- Easy to apply and user friendly.
- Suitable for outdoor use.

Technical Properties

Gloss (GU 60°)	Semi-matt (30–40)
Color	Oxide red. Can also be produced in other RAL colors upon request.
Density	1.45 ± 0.10 g/ml
Hardener Ratio (by volume)	5/1
Thinner	Coatix® Thinner E100
Solids by Volume	82 ± 2%
Pot Life (20°C)	1.5 – 2 hours
Flash Point	> 32°C
Application Method	Airless spray, roller, brush

Drying Time (20°C)	Dust free: 1–2 h / Touch dry: 7–8 h / Assembly dry: 8–10 h / Full cure: 7 days
Dry Film Thickness	150 µm
Wet Film Thickness	180 µm
Theoretical Coverage	5 – 5.5 m ² /L (for 150 µm DFT)

User Guide

Surface Preparation and Application Procedure

On steel surfaces: Oil, grease, dust, and other contaminants must be removed using suitable organic solvents, detergents, or high-pressure water cleaning. For best results, after cleaning, the surface should be blast-cleaned to Sa 2½ grade according to the Swedish Standard. If temporary protection is required, the surface should be primed with Coatix® Steelcoat Primer S45 workshop primer. In production conditions or when unavoidable, a minimum surface preparation of St2 – St3 –Sa2 is acceptable. For repair and maintenance: The surface should be cleaned from oil, grease, dust, and contaminants using solvents, detergents, or pressurized water. Damaged areas must be mechanically abraded. Loose rust should not remain on corroded areas.

Application Conditions

For best results: during application and/or curing, temperature should be between 5°C and 35°C. Surface temperature should be at least 3°C above the dew point, and relative humidity must not exceed 80%. Adequate ventilation must be ensured during application.

Mixing Instructions

First, Component A should be mechanically mixed until homogeneous. Then Component B should be prepared separately and added to Component A.

Mix thoroughly at 350–500 rpm until a uniform blend is obtained. To ensure complete homogenization, pour the mixture into a clean container and remix. Viscosity can be adjusted by adding the appropriate hardener and Coatix® Thinner E100 according to the technical specifications. Allow the prepared mixture to stand for 15 minutes before application.

Paint Application

For optimal results, apply at 20°C. Application conditions, ambient temperature, film thickness, and equipment parameters should be considered.

Airless Spray:

Nozzle size: 0.019–0.025 inch

Pressure: 150–200 bar

Roller/Brush:

Recommended for small areas and touch-ups. Care must be taken to achieve the required dry film thickness.

Mixing Ratio

A/B = 16.0 kg + 4.0 kg = 20 kg

Cleaning of Tools

All tools and equipment used should be cleaned with Coatix® Thinner E100 immediately after use.

Storage Conditions and Shelf Life

Containers must be tightly closed and properly labeled. Store in a dry, cool, and well-ventilated area at 15–25°C, away from direct sunlight and open flames. The product must be stored in accordance with the Material Safety Data Sheet (MSDS) and relevant legal requirements. Shelf Life: 12 months from production date under proper storage conditions.

Safety Precautions

Please pay attention to the safety labels and warnings on the package. Comply with the health and safety information stated in the Material Safety Data Sheet (MSDS).

Provide good ventilation during application. Use protective equipment such as mask, gloves, and goggles. Avoid direct contact and do not inhale vapors. Keep away from open flames.

Liability

Our company is responsible only for the quality of the product itself. We are not responsible for any misuse or incorrect application of the product outside written recommendations. For more detailed information, please request a product brochure or contact our company representatives.

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