



## FUSIONCLAD® PRIMER

### TECHNICAL DATA

### “EASY-PREP” WATERBORNE INDUSTRIAL STEEL COATING

#### THE PRODUCT AND ITS USES

The FusionClad® family of coatings makes it possible to achieve industrial-grade protection for steel and other metals without the necessity of blasting or other elaborate surface preparation. After coating the substrate with Madison FerroGrip™ for 10 minutes and rinsing off the surface, the applicator applies FusionClad® Primer and then a choice of two available topcoats.

FusionClad® Primer is paint-like to use; it is a single component water-reducible acrylic primer coating with very little odor, very low VOCs (volatile organic compounds) and quick curing. Apply by brush, roller or spray. For additional details, refer to the table below and information overleaf.

The FusionClad® system is suitable for protecting virtually any steel structure targeted for, or currently used in, atmospheric (ie. aboveground) exposure. Use in the shop or in the field for coating steel structures, equipment, sheet metal, piping, furniture and storage tanks. An anti-microbial version of this products is available by special order.

Note: for embedded, immersion or continually wet service, your Madison representative will recommend a system rated for “severe service”.

#### TECHNICAL INFORMATION

PROPERTY	TEST DESCRIPTION	RESULTS
Application Temperatures	N/A	5°C(40°F) to 50°C(120°F)
Viscosity		Paint-Like
Initial Setting Time	@20°C (70°F)	30 minutes
Curing Time Before Handling	@20°C (70°F)	4 to 6 hours
Recoat Time <sup>1</sup>	@20°C (70°F)	Up to 48 hours
Solids Content	ASTM D-1259	55 to 60%
Volatile Organic Compounds (VOCs)	ASTM D-2369	Less than 100 grams/litre
Theoretical Coverage	N/A	700 ft <sup>2</sup> /US gal/mil
Adhesion to Steel	ASTM D-4541	Greater than 1000 p.s.i.
Ultraviolet Resistance	ASTM G-154	Excellent
Colors		Wide color choice; Consult Madison Sales Representative
Finish		Semi-gloss

<sup>1</sup> However, recoat window varies depending on ambient and substrate temperature and coating thickness.

NOTE: All statements, technical information and recommendations contained herein are typical of results obtained under laboratory conditions and are not intended to be used as contract specifications. For specification guidelines please contact Madison Chemical. The information contained herein is believed to be accurate as of the date of publication. Madison reserves the right to change product specifications without notice.

## APPLICATION INSTRUCTIONS

CONTACT MADISON FOR DETAILED [APPLICATION INSTRUCTION BULLETIN](#) (also available online).

### A. SURFACE PREPARATION

FusionClad® Primer is designed to be applied over steel surfaces prepared with Madison FerroGrip™ (see separate Application Instructions for FerroGrip™). It also works well over surfaces prepared by traditional means such as power tool cleaning and grit blasting. Do not apply in wet or highly humid conditions or at temperatures below 5°C (40°F).

### B. APPLICATION OF COATING

- 1) This is a single component, self curing product. Before using, mix thoroughly until homogenous. FusionClad® Primer may be diluted with clean tap water, but only when necessary.
- 2) FusionClad® Primer can be applied by brush, roller or single component airless spray equipment.
- 3) This product should only be applied at a maximum thickness of 3-4 dry mils (6-8 wet mils) at a time for ultimate surface appearance. If more than 3-4 mils is to be applied, it has to be done in multiple coatings.
- 4) Use a good quality brush and roller (low pile) designed for water dispersible paints.
- 5) Use a new roller and brush every time. Alternatively, ensure that the used brush or roller is thoroughly cleaned immediately after initial use and wrapped in a plastic bag to maintain moisture. It should be brushed or rolled out on a dry cloth to remove excess moisture before subsequent use. Brush or roller application may require multiple coats to achieve uniformity of appearance.

### C. CLEAN-UP AND STORAGE

Clean spills and spatters, including hands and tools, immediately after use, with soap and warm water. See application instructions for details. Store at or near room temperature. DO NOT FREEZE. Use product within 12 months of receiving.

## HEALTH AND SAFETY

Product is intended for industrial use only. Provide ample ventilation. Product is non-flammable and contains no "regulated" substances. If swallowed, throat irritation can be minimized by drinking water; contact physician and treat as ingested water-based paint. If splashed on skin, remove coating with with soap and water. If splashed in eyes, wash liberally with clean water and contact physician; temporary irritation of eyes may last several days. Although product contains no known carcinogens or mutagens, prudence dictates that applicators use rubber gloves, safety goggles and protective clothing. Resins are inert when cured. See MSDS for more information. Review [Application Instruction Bulletin](#) for additional safety information.

## LIMITED TWO YEAR WARRANTY

Madison will replace any product which, in service for which it is suitable, fails to meet specifications within two years of sale and which is proven to be defective when applied according to instructions by a Madison Approved Applicator or Certified OEM Applicator. Madison accepts no responsibility or liability for any other loss, claim, damage, injury or expense, direct or consequential, in contract or negligence. This product replacement warranty is in lieu of any other right, warranty, guarantee or condition, statutory or otherwise, expressed or implied, whether as to fitness for a particular purpose or as to merchantable quality or otherwise.

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