

# Comparison of Primer ZS 1589 with conventional PVB-primer

## Corrosion protection

- same protect period with reduced coat thickness
- prolonged protect period with the same coat thickness
- high heat resistance due to minimum organic constituents
- high mechanical resistance

## Welding

- very low susceptibility to pore formation during welding through (primer should not be removed before welding! Grinding will result in increased dust)
- low fume emission rate

## Thermal cutting

- low fume emission rate

## Laser cutting

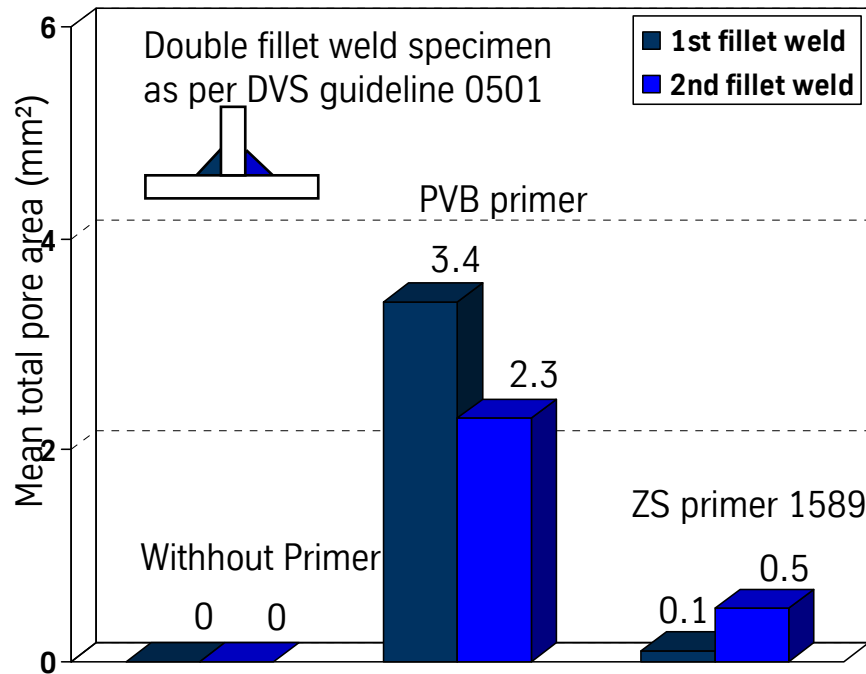
- can be cut with laser without any problems

## Painting

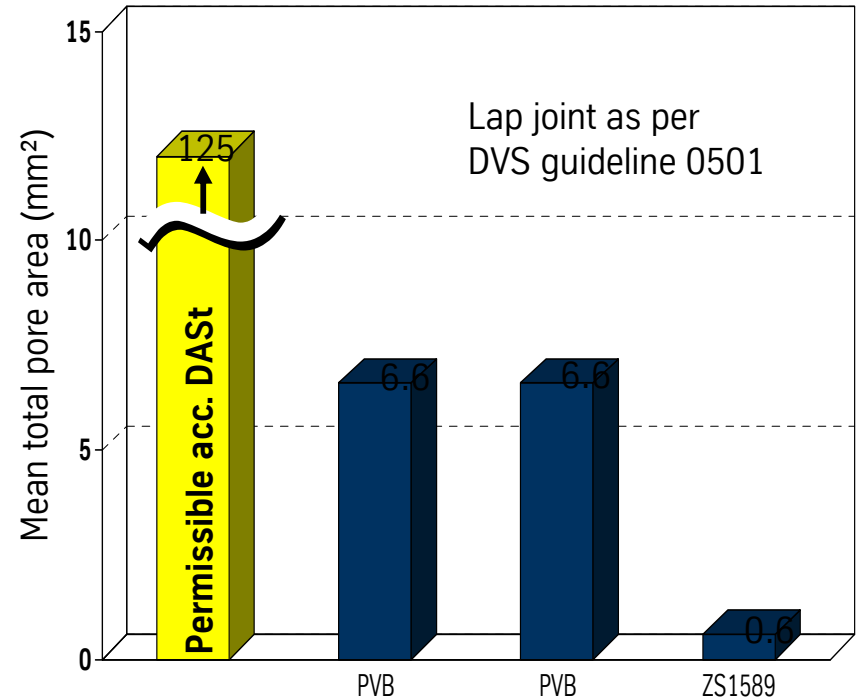
- good suitability for over painting



# Qualification of Primer ZS 1589 for welding through



**Figure 1) Comparison of PVB and ZS shop primers**  
(base metal: S235J2, wire electrode: SG 3, shielding gas: CO<sub>2</sub>)



	Manufacturer A	Manufacturer B	Hempel
Coating thickness in $\mu\text{m}$	17.5	17.7	14.4
Examination	1978	1989	1999

**Figure 2) Investigations of the SLV Duisburg**