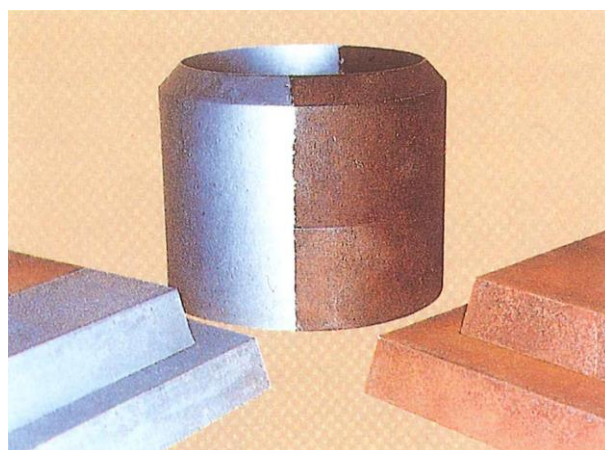


Anti-Corrosive Primer for Welding Groove Face

TASETO SILVER

Rusting at weld groove faces is a serious hindrance not only to the rationalization and labor-saving of welding work but also to the quality control. TASETO SILVER is a weldable primer which helps suppress rusting during a period from edge preparation to completion of welding operation.



● Features

1. No need to remove an agent film before welding does not affect the mechanical (Tensile Strength Test and Bend Test) of weld metal adversely.
2. The rust preventive effect is valid for 3-month outdoor exposure and 6-month indoor exposure
3. Other paints can be painted over.

● Types and characteristics

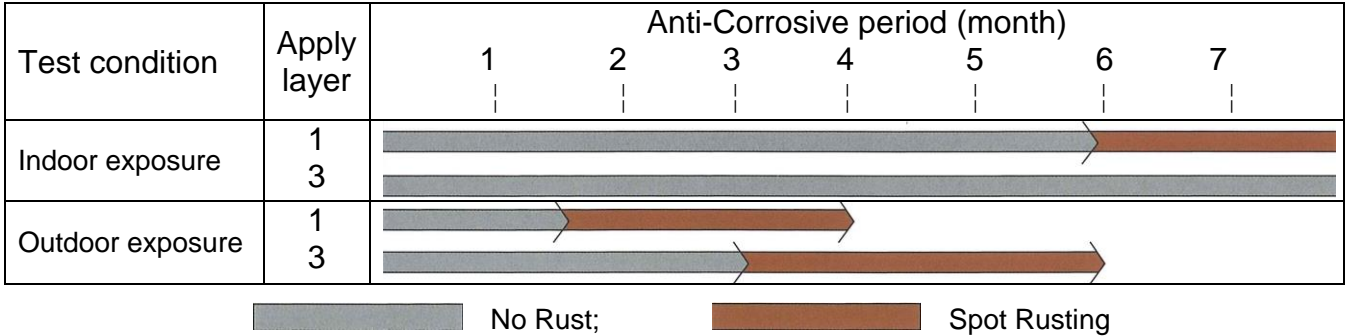
Types	Film color	Recommended film thickness	Drying time	Features
SILVER	Silver gray	7~20 (μ)	5 min.	Normal type for general steel good rust preventive effect. Other paints can be applied over the coat. Approval of Lloyd's Register of Shipping.
SILVER A	Yellow transparent	7~20 (μ)	5 min.	Other paints can be applied over the coat.

(Coating area : 10~20 m²/L)

● **How to use**

1. Remove oil, grease, rust and other attachments off the base metal before application.
2. Whether it is aerosol canned or brushing type SILVER, shake the container thoroughly until you hear the glass balls in the container rattling.
3. Coat within the thickness range of 5 to 20 μ depending on the rust prevention period or ambient conditions (within three coats by brushing or 4 layers by aerosol spraying).
4. When you use a spray gun, TASETO SILVER THINNER is recommended to clean the sprayer or brush and dilute TASETO SILVER.

● **Anti-Corrosive test of TASETO Silver**



● **Welding test of TASETO Silver**

Welding Condition and Used Consumables

	SMAW	CO ₂ welding	SAW
Base metal	SS400	SS400	SS400
Groove face	Fig.1	Fig.1	Fig.2
Welding Consumable	D4301 4.0 φ	YGW-11 1.6 φ	YS-S3 4.0 φ
Flux	—	—	FS-FG1
Current (Amp.)	160~180	220~250	650~700

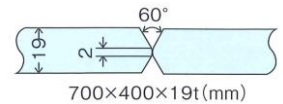


Fig.1

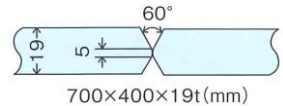


Fig.2

Welding Test Result of SILVER applying or not.

Condition		SMAW		CO ₂ welding		SAW	
		Apply	Non	Apply	Non	Apply	Non
Tensile test	Tensile strength(kg/mm ²)	49.5	49.4	49.6	49.8	49.7	49.7
	Broken portion	B. M.	B. M.	B. M.	B. M.	B. M.	B. M.
Bending Test	Free Bending	Good	Good	Good	Good	Good	Good
	Side Bending	Good	Good	Good	Good	Good	Good
Impact Test (22°C Kgf · m)		7.8	7.5	10.3	10.5	10.0	10.3
Radiographic testing		Passed	Passed	Passed	Passed	Passed	Passed

B. M. stands for Base Metal

● **Note on usage**

1. Apply recommended film thickness.
2. For welding special shapes or applying over a special paint, it is recommended that you carry out the first piece test or consult with us.

● **Packing units**

TASETO SILVER	TASETO SILVER A
4-L can (5 cans/case)	4-L can (5 cans/case)
18-L can	18-L can
420 mL aerosol can (12 cans/set)	420 mL aerosol can (12 cans/set)