



Weld Thru II Coating

05917

Technical Data

June 2020

3M Part Number	3M Part Descriptor
05917	3M™ Weld Thru II Coating

Product Description 3M™ Weld Thru II Coating is a zinc rich aerosol coating designed to be applied to metal surfaces prior to spot or MIG/MAG welding.
Note: for best results when MIG plug welding remove coating from weld site.

- Features**
- Aerosol Dispensing
 - Zinc Rich
 - Corrosion Resistant Formula

Typical Physical Properties

Container	12.75 oz Net Weight Aerosol Can
Base	Zinc
Density lbs./Gallon (Approx.)	6.7
Color	Gray
Coverage	~ 250 ² ft. (2 coats)
Solids Content (Approx.)	22 %
Consistency	Aerosolized Liquid
Service Temperature (°F)	-20°F to 180°F

Product Uses 3M™ Weld Thru II Coating is primarily used as a corrosion preventative coating which withstands high temperatures associated with spot and MIG welding. Most common uses include automotive repair and sheet metal fabrication where corrosion resistance is desired.

Note: for best results when MIG plug welding remove coating from weld site. Always clean 3M™ Weld Thru II Coating overspray from surrounding outer panels prior to the next operation, (this is not a primer or paint).

For professional use only. Not intended for retail sale.

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Directions For Use

1. Prior to actual finished weld operations are performed prepare a test weld panel using representative metal and 3M™ Weld Thru II Coating. Weld the panel and test welds to determine correct welder settings.
2. Remove all surface contaminants from the mating flange areas of affected panels using an abrasive, blow off and clean the surface with a VOC compliant surface cleaner.
3. Shake can well (one minute after agitator ball is loose).
4. Apply coating to prepared areas from a distance of 10 to 12 inches (25 to 30 cm), apply two light coats allowing 5 minutes flash time between coats.
5. Allow the coating to dry 10 to 15 minutes at room temperature prior to assembling.
6. When the application is complete invert the can and spray for 3 to 5 seconds to clear the actuator and dip tube of coating to prevent clogging.
7. After assembling and clamping in place if you plan to MIG/MAG plug weld, remove the coating from the plug weld site prior to welding. If spot welding is planned cleaning of the welding site is not required.
8. Weld the panels using settings determined during your test weld session.
9. After completing the welding and weld dressing operations remove excess overspray from the outer portion of the panels using a mild VOC compliant solvent (3M™ Weld Thru Coating II is not a primer or paint).

Applications

Corrosion protective coating used between welded steel panels.

Storage and Handling

HANDLING

Avoid eye contact with vapors, mists or spray. Do not breathe vapors. Avoid prolonged or repeated skin contact. Do not eat, drink or smoke when using this product. Wash exposed areas thoroughly with soap and water.

STORAGE

When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 24 months from the date of manufacture. Store away from acids. Keep container in well-ventilated area.

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Precautionary Information

Before using this product, please reference Product Label and/or Safety Data Sheet for Health and Safety Information. Note: Laws controlling the acceptable amounts of Volatile Organic Compounds (VOCs) vary by state, and in some cases by locality. For surface preparation and clean-up activities, consult federal, state and local regulations regarding use of products containing VOCs in your area.

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