



STANDARD OPERATING PROCEDURE

Corrosion Protection during MIG - TIG Welding

Weld Areas - Steel & Galvanized Metal

Clean	1	Clean panels/parts to be welded with solvent-borne degreaser, SCAT #6311 or Speedi SCAT #6321.
	2	Clean with waterborne degreaser, Aqua SCAT 2 #1394.
Prime	3	Shake aerosol can #4353 vigorously for 1-2 minutes after ball breaks free before each use. Shake can frequently during application.
	5	Before welding, apply Weld Through Primer, #4353 to inner edges of all lap/butt seams. Apply 1-2 medium wet coats on mating weld surfaces. Allow 5-10 minute flash time between coats.
Weld	6	Allow primer to dry 15 minutes before welding. Assure primer is dry before welding. Dry time may vary due to film thickness, temperature, humidity, etc.
	7	Weld the surfaces as necessary.
Clean	8	After welding, prior to applying filler or topcoating, remove visible Weld Through Primer using acetone, lacquer thinner or sanding.
Topcoat	9	Tack off. Apply primer surfacer, sealer or basecoat to panel/part. Always use DTM primer on bare metal. Refer to SOP 051 for Prep & sanding metal substrates; SOP 111 for Steel Finishing; or SOP 509 for topcoating.

Note: Always wear gloves and appropriate personal protection equipment.

SUGGESTED MATERIALS FOR JOB

- Solvent-borne degreaser, SCAT #6311 or Speedi SCAT #6321
 - Transtar Waterborne Degreaser, #1394
 - Tack rags
- Lint-free Towels • Acetone or Lacquer Thinner • Sandpaper
- Transtar Weld Through Primer, #4353 • Transtar Primer Surfacer / Sealer • Transtar Topcoat

* Always refer to Transtar Technical Data Sheet (TDS) for specific product application, suitable substrates & other product information.