STANDARD OPERATING PROCEDURE

Corrosion Protection during MIG - TIG Welding

Weld Areas - Steel & Galvanized Metal

Prep	1	Sand / grind panel to bare metal with 80 grit or coarser.
Clean	2	Clean panels/parts to be welded with solvent-borne degreaser, SCAT #6311 or Speedi SCAT #6321.
Prime	3	Shake aerosol can #4333/4343 vigorously for 1-2 minutes after ball breaks free before each use. Shake can frequently during application.
	4	Before welding, apply Weld Through Primer, #4333/4343 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	5	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.
	6	Weld the surfaces as necessary.
Clean	7	After welding, prior to applying filler or topcoating, remove visible Weld Through Primer using acetone, lacquer thinner or sanding.
Prime	8	Tack off. Apply primer to panel/part. Always use DTM primer on bare metal. Follow with topcoat.

Refer to SOP 051 for Prep & sanding metal substrates; SOP 111 for Steel Finishing; 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

● Tack rags ● Lint-free Towels ● Acetone or Lacquer Thinner ● Sandpaper

● Transtar Weld Through Primer, Copper - #4333 or Zinc - #4343

● Transtar Primer Surfacer / Sealer ● Transtar Topcoat

* Transtar products are for professional use only. * For structural repairs, always follow vehicle manufacturer recommendations.

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

* In low VOC areas, restrictions may apply. Check regulations & TDS for correct product use.

SOP 311 rev 09/24