



# 3M 50410

## Weld Through Coating

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### I- PART NUMBER - PRESENTATION

3M 50410 Weld Thru II : 377 ml Aerosol spray can

### II- DESCRIPTION AND END-USES

#### 1. Description

3M 50410 Weld Through Coating is a sprayable, weldable zinc based coating designed to prevent corrosion from forming between welded metal panels.

#### 2. End uses

3M 50410 is designed to be used for both spot welding and MIG welding operations in the automotive repair process. It helps restoring the original zinc based protection used in automotive construction and will dramatically reduce risk of corrosion development on welded steel parts and panels.

### III- PHYSICAL PROPERTIES

|                           |  |
|---------------------------|--|
| <b>Color</b>              | Silvergrey   |
| <b>Packaging</b>          | 377ml (361g) aerosol can   |
| <b>Tack Free Time</b>     | 10 minutes (at 23°C, 50% RH)   |
| <b>Solvent</b>            | Acetone  |
| <b>Flash Point</b>        | -104°C, Closed cup   |
| <b>% Solids (Typical)</b> | 64 %   |
| <b>V.O.C.</b>             | 700 g/l  |
| <b>Specific Gravity</b>   | 0.796  |
| <b>Storage conditions</b> | + 5°C to + 30°C  |
| <b>Shelf Life</b>         | 24 months under normal storage conditions (date of manufacturing in American style on bottom of can) |

#### **IV- PERFORMANCE PROPERTIES**

A 500 hours salt spray exposure (ASTM B117) showed significant reduction in corrosion over untreated metal

When compared to a copper based weld through coating, after 250 hours salt spray exposure, the zinc based 3M 50410 coating showed a far better protection of the metal sheet than the copper based product.

#### **V- MAJOR FEATURES**

- Fast drying
- Easy to weld through without altering welder settings
- Excellent and consistent sprayability
- Efficient corrosion protection
- Good adhesion to bare metal

#### **VI- DIRECTIONS FOR USE**

- Remove all paint, rust, oil and other contaminant from the surface to be coated. Sand remaining coatings with p180-P240 grit abrasive.
- Clean and degrease surface with 3M 08984.
- Shake can well for approx. 1 minute after agitator ball is heard. Shake frequently during use.
- Hold can about 15cm from surface to be coated. Apply to all bare surfaces and edges in the vicinity of the intended weld.
- Two thin layers are recommended to obtain the correct thickness and optimum corrosion protection.
- Weld after product has dried (about 10 to 20 minutes).
- Invert can and spray to purge nozzle.

*Note :*

- Do not apply filler or other top coat over 3M 50410 as this may causes lifting. It is recommended to remove 3M 50410 from any surfaces to be painted.
- Spot weld in the first 24 hours. Longer time reduces conductivity.

#### **VII- SAFETY INSTRUCTION**

Please refer to the Material Safety Data Sheet or contact your local 3M Toxicology Department.

Pressurised container. Protect from sunlight and do not expose to temperature exceeding 50°C. Do not pierce or burn, even after use. Do not spray on a naked flame or incandescent material.