

FIRETEX® Technical Bulletin

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Stud Weld Blisters

Where stud welding has taken place on the top flange of a beam coated with a FIRETEX material, and this welding has resulted in the formation of blisters in the FIRETEX on the inner top flange, In Sherwin-Williams' opinion these blisters do not need to be repaired from a fire protection point of view providing:

- The blisters remain intact.
- The beams are in a C1 (ISO12944-2) environment.
- The blisters are at least at 80mm centres.

However, where any of the following apply, it will be necessary to repair the blistered area:

- Where aesthetics is a prime consideration.
- Where the construction is still open to the elements and the blisters have cracked.
- Where the end use situation will fall into categories C2-C5 as per ISO12944-2 i.e. external exposure or internal environments where condensation and/or high humidity may occur.

When required the below repair procedure should be used:

1. Remove all blistered coatings back to a firm edge. This includes the primer if this too is damaged, in which case it will be necessary to reapply with a suitable primer.
2. Ensure surfaces to be coated are clean, dry, and free from all surface contamination.
3. For areas of repair up to approximately 25cm² use FIRETEX M72* mastic, levelling off with the previously applied FIRETEX coating. For particularly high dry film thicknesses more than one application may be necessary. In all instances some shrinkage will occur on drying and a second application of FIRETEX M72* may be necessary.
4. For areas of repair of greater than 25cm² the original FIRETEX material should be applied by brush or spray in the appropriate number of applications until the original target thickness for the section is achieved.
5. Topcoat as required.

* FIRETEX M72 can be used for the FIRETEX FX1000, FX2000 and FX5000 series products. FIRETEX FX9500 Epoxy should be repaired with itself and FIRETEX FX6002 should be repaired with FIRETEX FX6002 Repair Kit.

Working with steel fabrication/erection companies has shown that careful setting of the stud welding rig and removing dirt/debris/heavy rusting from the top flange of the beam before welding can help minimise and possibly eliminate blistering of the coating system.

The information herein is subject to revision as a result of additional information or test evidence becoming available, please consult Sherwin-Williams to ensure you have the latest version.

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