



**Public**

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Status: Active

## 3M™ Weld-Thru II

### Data Sheet

<b>3M Part No.(s)</b>	<b>3M Part Descriptor(s)</b>
05917	3M™ Weld-Thru II

**3M Fax on Demand Identification Number :** 05917

#### Description

A sprayable, weldable, corrosion-resistant coating designed to prevent corrosion from forming between two welded metal surfaces.

**NOTE:** This product was also labeled 5917 Weldable Primer beginning in 6/04 for sale in California. The name was changed to Weld-Thru II for national launch, to denote the product as a replacement for 5913 Weld-Thru Coating, which is being discontinued 1Q 2005. The part number remains 5917.

#### Features, Advantages, Benefits

<b>Features</b>	Good corrosion protection Fast drying Easy to weld Easy, consistent sprayability
<b>Advantages</b>	Helps prevent corrosion on otherwise bare metal Technician is able to weld quickly Minimal spatter from welding associated with many weldable primers Repeated use of aerosol can without plugging
<b>Benefits</b>	Prevent comebacks for corroded parts associated with welds Allow technician to finish job quickly and move on to next task Minimize burns to technician and other items in area from weld spatter Reduced frustration and cost of plugged aerosol cans

#### Typical Physical Properties

<b>Container</b>	12.75 oz. aerosol
<b>Base</b>	Zinc Powder
<b>Density lbs/Gallon (Appx.)</b>	13.2 lb/gal
<b>Color</b>	Gray
<b>Flash Point - °F</b>	-156 deg F (propellants)
<b>Viscosity (CPS) Brookfield</b>	
<b>Viscometer</b>	
<b>Solids Content (Appx.)</b>	64%
<b>Consistency</b>	Solid suspended in solvent
<b>Solvent</b>	Acetone
<b>Service Temperature - °F</b>	-20 to 200 deg F
<b>Propellant</b>	Propane, Isobutane, N-Butane

## Product Uses

A sprayable, weldable, corrosion-resistant coating designed to prevent corrosion from forming between two welded metal surfaces. Additionally, this product can be used to prevent corrosion on metal surfaces that will not be receiving any further treatment (i.e., body filler, primer, paint, etc). However, for non-weld mating surfaces, products such as primer/paint, 3M undercoatings, or 3M Rust Fighter I will provide a higher level of corrosion protection.

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## Performance Properties

500 hour salt spray testing per ASTM B117 showed significant reduction in corrosion over untreated metal.

Theoretical coverage 528 square feet, based on a 1.0 mil dry film.

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## Handling and Application Information

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### Directions for Use

PURGE AFTER EACH USE

Directions for use:

1. Remove all paint, rust, oil, and grease from the area to be coated, and wipe with 3M General Purpose Adhesive Cleaner (PN 08984, 08986, 08987). Surface must be bare metal that is clean and dry.
2. Shake can of 3M Weldable Primer for one minute after agitator is heard. Shake frequently during use.
3. Hold can 10-12 inches from surface to be coated. Press actuator tip firmly and use steady and even strokes when spraying.
4. Apply two light coats (1 mil dry thickness) on both mating surfaces. Allow solvents to flash between coats. Coating must be dry to the touch (normally 5-10 minutes at room temperature) before parts can be MIG welded. If using a resistance spot welder, allow 15-20 minutes of dry time before welding.
5. Invert can and spray to purge nozzle.
6. Grind weld with a 3M GREEN CORPS™ fibre disc, being sure to remove any exposed 3M Weldable Primer prior to applying plastic filler or other top coat.

General Corrosion Protection:

In non-cosmetic areas where plastic filler is not to be used, you may apply 3-4 coats of 3M Weldable Primer to the weld areas after grinding. A preferable treatment is to top coat the uncoated weld area with 3M Rust Fighter-I (PN 08892), a 3M Undercoating product, or primer and paint.

\* If 'Directions for Use' reference P.N.'s 08984, 08986, or 08987, please read. Federal and local air quality regulations may regulate or prohibit the use of surface preparation and cleanup solvents based on VOC content. Consult your local and Federal air quality regulations for information. When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe precautionary measures for handling these materials. Refer to product label and MSDS for P.N. 8984, 8986, or 8987 for detailed precautionary information.

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## Applications

Between two welded mating surfaces

Other non-cosmetic areas where additional corrosion protection is required.

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## Storage and Handling

Store at room temperature. Rotate stock on a "first-in - first-out" basis. When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 12 months.

Always use in a well-ventilated area.

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## Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product.

## Country

US

**This document is public. It may be distributed.**

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### **Warranty and Limited Remedy**

This product will be free from defects in material and workmanship at the time of shipment. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If this product is defective, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to replace the product or refund the purchase price.

**LIMITATION OF LIABILITY: 3M and seller will not be liable for any loss or damage arising from this 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability .**

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### **For Additional Health and Safety Information**

3M Automotive After Markets  
3M Center, Building 223-6N-01  
Saint Paul, MN 55144-1000  
1-877-666-2277 (1-877-MMM-CARS)

Material Safety Data Sheets and Technical Data Sheets are also available by calling Fax on Demand 1-800-305-0419.  
Help Line 1-800-621-5455 (US) 1-650-596-4407 (International).

**3M Fax on Demand/MSDS Identification Number 05917**

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