

3M™ Weld-Thru II
Part Number 05917/60-9801-0777-9

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

PURGE AFTER EACH USE

Directions for use:

1. Remove all paint, rust, oil, and grease from the area to be coated. Surface must be bare metal that is clean and dry.
2. Shake can of 3M™ Weld-Thru II 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™ Weld-Thru II 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™ Weld-Thru II to the weld areas after grinding. When dry, top coat the weld area with 3M™ Rust Fighter-I (PN 08892), a 3M™ Undercoating product, or primer and paint.