APPLICATION METHOD A-105
APPLICATION METHOD FOR POROSITY SEALING

This method pertains to the application of SAF-T-LOK products for the sealing of existing weld porosities and castings.

PROCEDURE

1. IMPORTANT: TAKE PROPER SAFETY PRECAUTIONS IF WORKING WITH FLAMMABLE LIQUID TANKS. AVOID USE WITH COMPRESSED GASES.

2. Wire brush to remove paint, rust, etc. from repair area.

3. Clean repair area with SAF-T-LOK Cleaner & Degreaser.

4. Apply localized heat to bring repair area to approximately 200°F.

5. Allow repair area to cool to approximately 120°F.

6. Brush or spray sealant on repair area.
   Note: *Steel /Aluminum/ Stainless – Use SAF-T-LOK S90 Threadlocker @ 120°F.
   Note: *Not recommended for “blowholes”.
   *Maximum porosity sealed - .005”.

7. Allow to cure for 30 minutes (High pressure above 150 psi – 1Hour).

8. Clean with SAF-T-LOK Cleaner & Degreaser to remove excess sealant. Do not grind.

9. Paint as required.
   Note: Casting repair uses same procedure.

SEALING NEW WELDS – PREVENTATIVE MAINTENANCE

1. Remove all slag and scale while hot.
2. Apply sealant when weld is 120°F and falling.
3. Follow the procedure above.