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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 Dulux Protective Coatings' 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. 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. For more details, refer to the repair section of the respective product application guide.
4. Topcoat as required.

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 Dulux Protective Coatings to ensure you have the latest version.

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