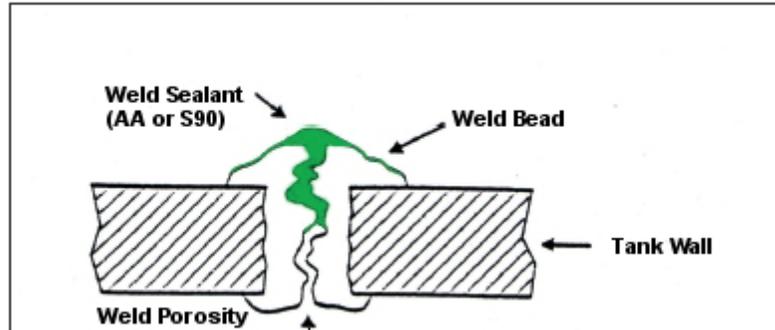


**APPLICATION METHOD A-105
APPLICATION METHOD FOR POROSITY SEALING**

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.**