PAINT ADHESION TO BACKSIDE OF WELDS

Application

This procedure is used to measure the paint adhesion at the backside of MIG/GMAW welds.

Materials Required

Adhesion Tape
No. 898 (Minnesota, Mining and Manufacturing Co. - 3M) 24 mm wide.

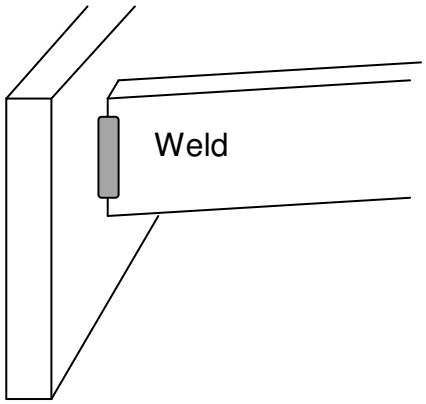
-or-

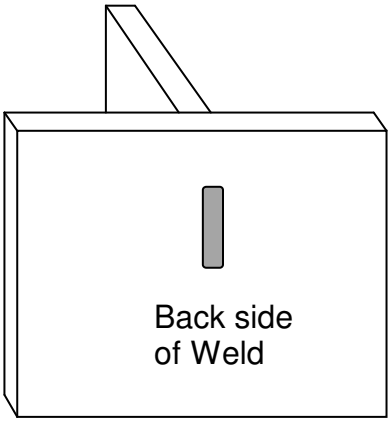
An Equivalent 24 mm wide tape can be used if agreed upon by Ford Materials Engineering as long as the peel strength is greater than 0.6 N/mm per ASTM D3330, Method A.

The shelf life of these tapes is 12 months when stored in the original package in a dry, dark location.

Procedure

1. Locate the backside side of a MIG weld.





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2017 05 03	Released	N. Hortsch & A. Wedepohl (NA)	

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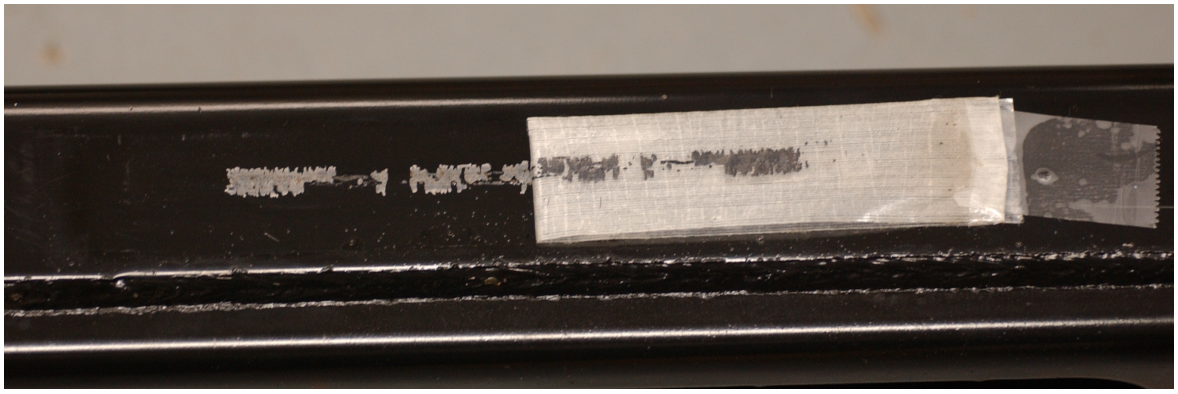
2. Apply the tape by firmly pressing it onto the surface over the area containing the back side of the weld. Remove the tape within 90 +/- 30 seconds of application by pulling it off rapidly (not jerked) back upon itself at as close to an angle of 180° to the sample as possible.

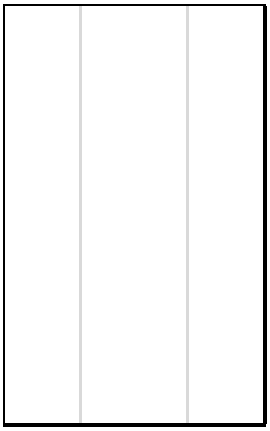
Evaluation

3. Report the percentage of adhesion loss using the Adhesion Loss Table as a visual reference.

Photo of paint adhesion loss on the back side of a weld



Note: The reference images in the Adhesion Loss table are based on a 10 mm wide weld area (light grey lines) a weld length of 40 mm and a tape width of 24 mm. The percent loss is calculated from the weld width and length and not the tape width and length.

Adhesion Loss Table	
Classification	**Tape Appearance**
0% loss	

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