TECHNICAL DATA SHEET

W-POXI BTD 332

PRODUCT DESCRIPTION: High-solids two-component polyamine epoxy direct to metal with zinc anti-corrosion phosphate-based pigments. It provides fast drying and good applicability. It has excellent adhesion to carbon steel treated with abrasive blasting. Coating applicable in a single high-build coat, simplifying the coating process.

RECOMMENDED USES: Recommended for coating metal structures, exterior of tanks, pipes, silos and various equipment, whether new coatings or maintenance jobs, in the pulp and paper, sugar and alcohol, chemical and petrochemical industries, among others.

CERTIFICATIONS AND APPROVAL: This product, when supplied to comply with the RoHs Directive (Restriction of Certain Hazardous Substances) has the letter R in its description.

PACKAGING:

Component	Content	Package	Unit of measurement
Component A	3.08 17.15	3.6 20	L
Component B	0.52 2.85	0.9 3.6	L

CHARACTERISTICS:

Color: Ral, Munsell or as per customer standard.

Gloss: Semigloss

Volume solid: 80 ± 2% (ISO 3233).

Shelf-Life: 24 months at 25°C

Thickness per coat (dry): 100 µm –200 µm

Theoretical coverage: 5,3 m2/l without dilution in the thickness of 150 µm dry. Without considering loss factors in application.

Resistance to dry heat: Maximum temperature 100 °C . The product retains its physical and chemical properties up to the temperature of 100 °C however, variations in the coating color and gloss may occur from 60 ºC (140°F).

Drying:

	-10 °C	5 °C	25 °C	35 °C
Touch:	-	6 hours	3 hours	1 hour
Handling:	15 hours	10 hours	8 hours	3 hours
Final:	-	240 hours	168 hours	120 hours

Overcoating Drying:

	-10 °C	5 °C	25 °C	35 °C
Min	-	10 hours	4 hours	3 hours
Max	-	120 hours	72 hours	24 hours

SURFACE PREPARATION

The performance of this product depends on the degree of surface preparation.

The surface must be clean and free of any contaminants. Completely remove oils, greases and fats, as described in the SSPC-SP 1 standard.

The accumulated dirt must be removed using a dry brush, clean and dry cloth, compressed air blow, vacuum cleaner and/or with the combination of such items, and the soluble salts must be removed through wash with a great quantity of fresh water, preferably with low pressure (up to 5,000 psi) according to SSPC-SP 12/NACE No. 5.

Surface treatment through Abrasive Blasting process

Execute the abrasive blasting to near white metal, Sa 2 ½ grade of the ISO 8501-1 visual standard (A Sa 2 ½, B Sa 2 ½, C Sa 2 ½ and D Sa 2 ½) or according to SSPC-SP 10/NACE No. 2, SSPC-VIS 1 visual standard (A SP 10, B SP 10, C SP 10, D SP 10, G1 SP 10, G2 SP 10, G3 SP 10).

Inspect the newly blasted surface observing the presence of surface flaws that could become apparent after this stage, adopting appropriate actions to mitigate such defects through grinding, weld filling and/or epoxy putty.

It is recommended a roughness profile between 40 and 70 µm (1,58 - 2,76 mils).

Surface treatment through the manual mechanical cleaning process

It can be used for situations of parts that have the degrees of oxidation C or D, according to the visual standards ISO 8501-1.

Treat the surface mechanically until obtaining at least grade St 3 of the ISO 8501-1 visual standard or according to SSPC-SP 11; the SSPC-VIS 3 visual standard can be used as an aid.

New buildings
For new buildings, it is necessary to treat welding spatters and weld seams, damaged areas, edges and sharp corners by abrasive blasting Sa 2 ½ degree or SSPC-SP10, visual standard ISO 8501-1.

Refinishing of surfaces with aged coating in good conservation conditions

We recommend the user of this coating to seek ways to make sure the original aged painting is still well bond to the substrate before executing this refinish. Loose aged coatings or not well bonded must be completely removed. We emphasize that the refinishing must only be made on surfaces in good conservation conditions.

In cases where the aged coating has good adhesion to the substrate, we recommend superficial sanding to break the gloss, followed by the cleaning of the dust and residues of the sanding in order to provide better adhesion between the coats.

It is acceptable to use less demanding surface preparation standards, provided that the absence of contaminants is guaranteed by cleaning with fresh water at high pressure (between 5,000 psi and 10,000 psi) according to SSPC-SP 12/NACE In. 5. If any further explanation is necessary, contact our technical area to determine alternatives for the proper surface preparation on a case by case basis.

Maintenance and repair

Corrosion spots, worn and damaged areas or the like should be treated with rotary power tools to grade St 3 of ISO 8501-1 visual standard or according to SSPC-SP 11, and the SSPC- VIS 3 visual standard can be used as an aid. If it is not possible to execute the manual mechanical cleaning process, as an alternative the surface can be prepared with commercial abrasive blasting to grade Sa 2 of ISO 8501-1 visual standard or according to SSPC-SP 6/NACE No. 3, SSPC-VIS 1 visual standard.

NOTE: Observe the product overcoating interval to apply the next coat. In case the maximum overcoating interval has been exceeded, it is necessary to manually/mechanically sand the surface to break the gloss of the previous coat and clean the sanding residues so as to provide better adhesion between the coats.

For further information, consult WEG Technical Department.

PREPARATION FOR APPLICATION

Mixture

Homogenize the contents of each component with mechanical or pneumatic stirring (A and B). Check there are no sediment settled at the bottom of the package. Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

Mixing ratio (Volume)

6 A x 1 B.

Diluent
Epoxy diluent 3005

Dilution
Depending on the application method, dilute at most. 10%

Only add the diluent after complete mixing of components A + B.

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended

dilution percentage.

The quantity of diluent may vary depending on the type of equipment used and the ambient conditions during the application.

Excessive dilution of the coating may affect the formation and aspect of the film and not allow to reach the specified thickness.

Pot life of the mixture (25°C)
4 h

Induction time (25°C)
No induction time required.

In hot areas, we recommend consulting WEG Technical Department.

APPLICATION FORMS

The data below is a guide, and similar equipment may be used.

In the spray application, make a 50% overlap in each gun pass, concluding with a cross pass. This technique is used to avoid uncovered and unprotected areas and to obtain a suitable aesthetic finish.

Changes in nozzle sizes and pressures may be necessary to improve spraying characteristics.

Purge the compressed air line to prevent contamination of the coating.

Recoat all sharp edges, cracks and weld beads with a brush to prevent premature failures in these areas.

After mixing two-component products, if there are stops in the application, and pot life is exceeded (the coating shows variation in fluidity) it can no longer be diluted for further application.

Before application, check if the equipment and its components are clean and in best condition.

Conventional gun:

Gun:	JGA 502/3 Devilbiss or equivalent
Fluid nozzle:	EX
Air cap:	704
Atomization pressure:	50 - 70 psi
Pressure in the tank:	10 - 20 psi
Dilution:	10%

Airless Gun:

Use Airless:	Use at least pump 60: 1
Fluid pressure:	2000 - 2500 psi
Hose:	¼" internal diameter
Nozzle:	0,015“ - 0,021“

Brush:
Only recommended for touch up small areas or stripe coat (screws, nuts, weld and sharp edges). Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for touch up.

Roller:
Only recommended for small areas or retouching. Use a thin nap, seamless sheepskin or microfiber roller for epoxy coatings.

For application with brush and/or roller, two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.

Cleaning the equipment:
Epoxy diluent 3005

NOTE:
Furthermore, it is a good working practice to periodically wash the spray equipment along the day. The cleaning frequency will depend on the amount sprayed, temperature and elapsed time, including all delays.

Clean all equipment immediately after use.

Do not leave catalyzed product in contact with the equipment used in the application, because the coating will vary in fluidity at temperatures above specificated in the pot life and will cure faster, making the cleaning difficult.

PERFORMANCE IN THE APPLICATION

For a good performance of the product, we recommend following the directions below:

Product not recommended for painting the interior of tanks

Do not apply the product after the pot life has expired.

In paintings carried out in front of the sea, if exposed to sea air, we recommend to wash with fresh water between coats eliminating settled impurities.

We recommend coating only if the surface temperature is at least 3°C (37,4°F) above the dew point temperature.

In coatings with variation in application method in the same job, the final aspect and gloss of the painted surfaces may show differences.

The temperature of the substrate, the weather and environmental conditions during the application and during the curing of the product, and the thickness of the coat may interfere in the product drying time.

The product should be applied within the overcoating interval as specified in the data sheet.

Before application, the weather conditions must be observed: There should be no threat of rain or drizzle. The surface temperature must be at least 3°C (37.4°F) above the dew point and the relative humidity must not exceed 85%.

Under adverse weather conditions indoors and/or outdoors with high relative humidity, rain, or drizzle, low or low temperatures and excessively high temperatures, variations in color and other product characteristics may occur. Consult the WEG Technical Department for more information.
Epoxy-based products are known by having excellent anti-corrosion properties and low resistance to sunlight exposure. In situations of exposure of the film to the weather, over time it will present a loss of gloss known as chalking and its shade will change as a consequence. Remember that even undergoing such chalking, the film anti-corrosion protection is not impaired.

For further information, consult WEG Technical Department.

COMPATIBILITY OF SYSTEMS AND MAINTENANCE REFINISHING

The product can be directly applied to aged coatings or other coating systems. It is, however, advisable to test the contact of the product with the previous coating in a small test area. We recommend sanding to break the gloss for a better performance of the product. Make sure the original material is well bonded. All loose coating must be removed. Points with corrosion or application over aged coatings should be treated according to technical guidance.

To apply topcoat over the product, the overcoating interval should be observed. The surface must be free of any contaminants.

For further information, consult WEG Technical Department.

SAFETY PRECAUTIONS

Product developed for industrial use intended for handling by qualified professionals.

Please read carefully all the information contained in the MSDS of this product, available at: www.weg.net.

Store in a covered, well-ventilated area. Keep the container tightly closed and away from sources of heat or ignition.

Use only in well-ventilated areas avoiding the accumulation of flammable vapors. Keep the product away from heat and sources of ignition.

Do not inhale mists / vapors / aerosols generated during handling and / or application.

Wear protective gloves / protective clothing / eye protection / face protection.

Avoid release this product and its packaging, as well as materials used during handling and application in the environment.

NOTE:

The information contained in this technical datasheet is based upon the experience and knowledge acquired in the field by the technical team of WEG.

If using the product without previous inquiry to WEG Coating concerning its suitability for the customer's intended purpose, the customer is aware that the use shall be its exclusive responsibility, WEG not being responsible for behavior, safety, suitability or durability of the product.

Some information contained in this datasheet are estimated, and can undergo variances arising from factors outside the manufacturer's control. Thus, WEG does not guarantee and does not assume any responsibility regarding the yield, performance or any other material or personal damage resulting from the incorrect use of the products concerned or the information contained in this Technical datasheet.

The information contained in this technical datasheet is subject to periodic modification, without prior notice, due to the policy of evolution and continuous improvement of our products and services, providing

solutions with quality to satisfy our customers' requirements.