TECHNICAL DATA SHEET

W-FENÓXI HBD 361

PRODUCT DESCRIPTION:

Novolac two-component, amine-cured, LOW VOC, high-thickness modified epoxy primer providing excellent edge protection when compared to conventional epoxies.

RECOMMENDED USES:

Indicated for highly aggressive environments, providing great anticorrosive protection on steel. Developed for application in storage tanks for petroleum products, chemical products, fresh water, salt water, maritime structures, off shore. It can also be used on decks, oil and natural gas exploration platforms, onboard machinery, piping, etc. It is particularly suitable for environments where chemical, abrasion and impact resistance are indispensable requirements.

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.

This product complies with regulation GM/MS No. 888 of the Ministry of Health, dated May 4, 2021.

PACKAGING:

Component	Content	Package	Unit of measurement
Component A	2,88	3,6	L
Component B	0,72	0,9	L

CHARACTERISTICS:

Color: White

Gloss: Gloss

VOC content: 100 g/l

Volume solid: 98 ± 2% (ISO 3233).

Shelf-Life: 12 months at 25°C. (77°F)

Thickness per coat (dry): 450 µm –550 µm

Theoretical coverage: 1,96 m2/l without dilution in the thickness of 500 µm dry. Without considering loss factors in application.

Resistance to dry heat: Maximum temperature 120 °C . The product retains its physical and chemical properties up to the temperature of 120 °C however, variations in the coating color and gloss may occur from 60 ºC (140°F).

Drying:

	10ºC (50°F)	25ºC (77°F)	35ºC (95°F)
Touch:	12 hours	5 hours	3 hours
Handling:	48 hours	14 hours	8 hours
Final:	10 days	4 days	24 hours

Overcoating Drying:

	10ºC (50°F)	25ºC (77°F)	35ºC (95°F)
Min	48 hours	14 hours	8 hours
Max	21 days	12 days	10 days

SURFACE PREPARATION

The performance of this product is associated with 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.

Accumulated dirt must be removed using a dry brush and soluble salts must be removed by washing with high pressure fresh water.

Surface treatment through Abrasive Blasting process

We recommend painting on surfaces blasted to Sa 2½ or according to SSPC SP10. ISO 8501-1 visual standard.

In case of oxidation on the substrate from the end of the abrasive blasting to the beginning of the coating application, the surface must be blasted again until reaching the specified visual standard.

It is recommended a roughness profile between 40 and 85 µm.

Application over primer
If there is a shop primer on the surface to be applied, this surface must be prepared by cleaning with a standard abrasive jet Sa 2 ½.
Epoxy primer

The product's performance is directly associated with the surface preparation performed. For a better performance, the surfaces should be treated with abrasive blasting according to visual standard Sa 2 ½.

When applied on firmly adhered epoxy paints, the results of traction adhesion are inferior when compared to the application on abrasive blasting to the pattern mentioned above.

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)
4 A X 1 B.

Diluent
Not applicable

Pot life of the mixture (25°C) (77°F)
1 h 30 min

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.

Changes in nozzle sizes and pressures may be necessary to improve spraying characteristics.
Before application, check if the equipment and its components are clean and in best condition.
Purge the compressed air line to prevent contamination of the coating.

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.

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

Airless Gun:

Use Airless:	Use at least pump 68:1
Fluid pressure:	5500 - 6000 psi
Hose:	⅜” internal diameter
Nozzle:	0,017“ - 0,025“
Note:	The diameter of the fluid hose should not be smaller than ½" with ⅜" in the harness, and its length should not exceed 5 meters.

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:

Use a thin nap, seamless sheepskin or microfiber roller for epoxy coatings.

Cleaning the equipment:
Not applicable

NOTE:
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.

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.
Once the packages of the components (A and B) are mixed, the recipient containing the mixture must not be closed again and, in cases of prolonged work interruptions, it is advisable to restart it with freshly mixed units.
Clean all equipment with Epoxy 3012 Thinner immediately after use.
We would add that it is good work practice to wash the spray equipment periodically during the day. The cleaning frequency will depend on the amount sprayed, the temperature, and the elapsed time, including all delays.
All left-over materials and empty packages must be disposed of in accordance with the appropriate regional regulations/legislation.

Clean all equipment immediately after use.

PERFORMANCE IN THE APPLICATION

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

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.
We recommend surface preparation to Sa 2½ or SSPC SP10. ISO 8501-1 visual standard. It is acceptable to use less demanding surface preparation standards, as long as the absence of contaminants is guaranteed, and the blasting is complemented with high pressure water cleaning (the surface preparation alternatives suitable for each case must be evaluated).

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.

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

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

Variations in color, aspect and gloss (more noticeable in dark colors) may occur, as well as delay in curing and low coating performance, when applied during periods of high air relative humidity, rainy days, low temperatures or drying the coating outdoor.

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.

Epoxy systems may have longer curing time when exposed to low temperatures. For temperatures below 10 °C, consult WEG Technical Department.

For better application properties, the coating temperature should be between 21 - 27 °C prior to the mixing and application.

It should not be applied under adverse conditions, such as air relative humidity (RH) above 85%, as changes in color and appearance may occur.

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.

Remember that even with this calcination, the film is not affected in terms of its protection. On newly painted surfaces in direct contact with water during the curing process, localized stains may occur with changes in their color (more visible in dark colors), delay in curing and compromised product performance.

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Overcoating information is provided for guidance and subject to regional variations depending on local climatic conditions. For specific situations, consult WEG.

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

	For further information, consult WEG Technical Department.
COMPATIBILITY OF SYSTEMS AND MAINTENANCE REFINISHING	The primer overcoating interval should be respected before applying the topcoat. If the maximum recommended overcoating interval is exceeded, manual/mechanical sanding is necessary to break the gloss. The primer surface must be dry and 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.