



WEG FENÓXI GFD 364

PRODUCT DESCRIPTION: Phenolic Epoxy Primer, with bicomponent glass flakes, LOW VOC and high thickness. Especially formulated with glass flakes which provide excellent protection by barrier besides great resistance to abrasion and impact. Items which comply with Directive Rohs have the description R in the product name.

INTENDED USES: Indicated for highly aggressive environments, providing excellent anticorrosive protection on steel. Developed for application in storage tanks of oil products, chemical products, fresh water, salt water at high temperatures, maritime, off shore structures. It can be used on decks, oil and natural gas exploration rigs, machinery on board, piping, etc. It is particularly indicated for environments where chemical resistance and to abrasion and impact are essential requirements.

PACKAGING:

Component A	WEG FENÓXI GFD 364 – Bucket (15.0 L)
Component B	WEG FENÓXI GFD 36 – 10003187 (5.0 L)

PRODUCT INFORMATION:

Colors	White, pastel green and gray N 6.5.		
Gloss/Aspect	Semi Gloss		
Volume Solids	78 ± 2% (ISO 3233:1998)		
VOC Content	205 g/L		
Shelf Life	12 months at 25°C		
Dry Film Thickness	150 - 200 micrometers dry		
Theoretical Coverage	4.45 m ² /L at 175 micrometers dry film thickness, not considering lost factors.		
Resistance to Dry Heat	Maximum temperature 120 °C. The product maintains its physical and chemical properties until the temperature of 120 °C, but, as of 60 °C, variances may occur in the color and gloss of the paint.		
Drying Information			
	10°C	25°C	35°C
Touch	9 hours	3 hours	2 hours
Handling	24 hours	8 hours	5 hours
Final	336 hours	168 hours	144 hours
Repainting Drying			
	10°C	25°C	35°C
Min.	24 hours	8 hours	5 hours
Max.	21 days	20 days	14 days

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SURFACE PREPARATION

The performance of this product is associated with the degree of surface preparation. Completely remove oil, grease and fat applying a degreasing product or as per cleaning method with solvent of standard SSPC SP1.

The accumulated dirt must be removed, using a dry brush and the soluble salts must be removed, washing with fresh water at high pressure.

For new work, it is necessary to grind weld beads and remove weld drops, damaged areas, sharp edges and corners through abrasive blasting grade Sa 2½ or SSPC-SP10, visual standard ISO 8501-1.

In cases where the practice mentioned above could not be executed, consult the Technical Department of WEG for the utilization of W-POXI EDGE RETENTION.

Preparation by Abrasive Blasting (New Work or internal maintenance of tanks)

We recommend painting on surfaces blasted to grade Sa 2½. Visual standard ISO 8501-1.

If oxidation occurs between the prior blasting and application of the painting, the surface must be blasted again to the visual standard specified.

Evaluate the surface after the blasting, observing the presence of surface defects revealed after the treatment, adopting appropriate practices to minimize the defects through grinding or filling.

A rugosity profile of 40 – 85 µm is recommended.

Manual/Mechanical Preparation (Only for small areas)

Not recommended for internal maintenance of tanks. The surface must be clean and free of contaminants.

Areas worn, damaged and others, can be prepared with mechanical treatment as per standard SSPC-SP3 to grade St 3 (Visual standard ISO 8501-1).

The areas which cannot be prepared by this method shall have localized abrasive blasting executed attaining grade Sa 2 or SSPC-SP6. Visual standard ISO 8501-1.

Surfaces with Factory Paint

Shop Primer

If there is shop primer on the surface to be applied, every shop primer shall be removed through abrasive blast to standard Sa 2 ½.

Epoxy primer

The product performance is directly linked to the surface preparation executed. For better performance, the surfaces shall be treated with abrasive blast as per visual standard Sa 2 ½.

When applied on firmly adhering epoxy paint, the results of adherence by traction are inferior when compared with the application on abrasive blasting to the aforesaid standard.

In applications on primer LACKPOXI N 2630, efficacious sanding on the surface or treatment by abrasive jet standard Sa 1 (known as slight blast or brush off), where the adherence to traction as per standard ASTM D 4541 (Pull off) is at least 10 MPa.

Note: If the maximum interval indicated for applying the subsequent coat is exceeded, it is necessary to proceed with manual / mechanical sanding using sandpaper to break the gloss. This procedure is necessary to obtain adherence between the layers.

For further information contact the Technical Department of WEG (tintas@weg.net).



APPLICATION

Mixing

Homogenize the contents of each one of the components by means of mechanical or pneumatic stirring (A and B). Ensure that no sediment is retained at the bottom of the packaging. Add component B to component A, in the proportions (volume) indicated, under stirring, until complete homogenization, respecting the mixture ratio.

Mix Ratio

3A : 1B in volume

Thinner

Recommended - **Epoxy Diluent 3012**

Thinning

Depending upon the application method, **dilute at most 5% in volume.**

Only add the Diluent after completing the mixture of components A + B.
Do not dilute with solvents which are not allowed by the local legislation or exceed the dilution percentage indicated.

Excessive dilution of the paint can affect the forming of the film the aspect and make it difficult to obtain the thickness specified.

Pot Life

2 hours at 25°C

Induction Time (25°C)

Induction is not required.

Note: In places of great heat, we recommend contacting the Technical Department of WEG.



APPLICATION METHODS

The data below is a guide, similar equipment being able to be used.

Changes in the pressures and sizes of the nozzles may be required to improve the spraying features.

Before application ensure that the equipment and respective components are clean and in the best condition.

Empty the compressed air line to avoid contamination of the paint.

After mixing the bicomponent products, if stoppages occur in application, and they exceed the useful life of the mixture (where the paint has variance in its fluidity), it can no longer be diluted again for later application.

Reinforce all the sharp edges, cracks and weld beads with the wide paintbrush, to avoid premature flaws in these areas. When applying by spraying, make an overlap of 50% of each spray gun application, to avoid having uncovered and unprotected areas, ending with a cross transfer.

Airless Spray Gun:

- Airless ratio.....60 : 1
- Fluid pressure.....3500 - 4500 psi
- Hose.....3/8" inside diameter
- Tip range.....0,025" to 0,033 "
- Filter.....Mesh 60
- Dilution.....Max. 5%

Conventional Air Spray Gun:

- Gun..... JGA 502/3 DeVilbiss
- Fluid tip..... EX
- Air cap.....704
- Atomization Pressure..... 60 to 65 psi
- Tank Pressure.....10 to 20 psi
- Dilution.....Max. 5%

Wide Paintbrush:

It is only recommended for finishing touches of small areas or "strip coat" (bolts, nuts, weld bead, sharp edges and finishing touches).

Roller:

It is only recommended for finishing touches of small areas. Use sheep wool or synthetic wool rollers for epoxy paint. The finishing aspect shall be controlled in the application.

Note: For application by wide paintbrush or roller, it may be necessary to apply in two or more strokes to obtain a uniform layer and in accordance with the film thickness recommended per coat.

Equipment Cleaning: Use Epoxy Diluent 3005.

Once the packagings of the paint components (A and B) are mixed, the contained with the mixture in it shall not return to being closed and, in cases of prolonged work interruptions, it is advisable to restart it with units mixed recently.

Clean all the equipment with Epoxy Diluent 3005 immediately after use.

We add that it is a good work practice to wash the spraying equipment periodically during the day. The cleaning frequency will depend upon the quantity sprayed, the temperature and the time elapsed, including all the delays.

All the excess materials and empty packaging must be discarded in accordance with the appropriate regional regulations/legislation.

Note: Do not let the catalyzed product remain in contact with the hoses, spray guns and equipment used in the spraying, as for temperatures above those described in the pot life table, the paint will have variance in its fluidity and will harden making cleaning difficult.

Wash all the equipment used completely.

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APPLICATION PERFORMANCE

For a better performance of this product, please follow the orientations below:

If brush or roller is used, it may be necessary more than one coating to achieve the recommended dry film thickness.

We recommend a surface preparation to grade Sa 2½ or SSPC SP10. Visual standard ISO 8501-1.

If application occurs in maritime areas, it is recommended to wash the coated surfaces with freshwater between each coating, to remove all loose powdery deposits and soluble salts.

The product must not be applied if working pot life is exceeded.

Surface temperature must always be a minimum of 3°C above dew point. Do not apply if temperature is below 0°C.

There may occur small variances of color, aspect and gloss of the parts applied in periods of high relative air humidity, rainy days, in places with low temperatures or in situations in which the parts are applied and placed to dry in external environments.

It shall not be applied in adverse conditions, as relative air humidity (RH) above 85% or condensed surfaces, as the gloss and color may undergo small alterations.

The temperature of the substratum and climatic and environmental conditions may interfere in the drying time of the product.

Epoxy systems can have a greater cure time when exposed to low temperatures. For cure at temperatures below 10°C, contact the Technical Department of WEG (WEG).

For a better application performance, both components must be between 21-27°C before mixing and painting.

The epoxy-based products are known for exhibiting excellent anticorrosive properties and low resistance to solar rays. In situations of exposure of the applied film to weather action, it will show a loss of gloss known as calcination and, as a consequence, changing its tonality. The film is not impaired as to its anticorrosive protection.

We remind you that even after undergoing this calcination, the film is not impaired regarding its anticorrosive protection.

In just-painted surfaces with direct contact with water during the process of cure, it may occur located staining with color change (more visible in dark colors), retard of cure and commitment in the development of the product.

The information about repainting is provided as an orientation and is subjected to regional variations, depending on the local climate conditions. For specific situations, consult WEG.

In painting varying the application method of paints in the same work, it may occur differences in gloss and final aspect of the painted pieces.

For further information contact the Technical Department of WEG (tintas@weg.net).

SYSTEM COMPATIBILITY AND MAINTENANCE RECOATING

The repainting interval of the primer for applying the finishing shall be respected. If the maximum interval indicated is exceeded, it is necessary to proceed with manual/mechanical sanding using sandpaper to break the gloss. The primer surface shall be dry and free of contaminants.

For further information contact the Technical Department of WEG (tintas@weg.net).



**SAFETY
PRECAUTIONS**

Before handling this product it is essential to read carefully all the information contained in the chemical product safety information sheet (MSDS), available at our site, at the electronic address indicated at the end of this technical bulletin.

The preparation of the surface, handling and use of paints during the painting and drying, as it concerns inflammable products, must be performed in ventilated places, far from flames, sparks or excessive heat, using appropriate personal protection equipment (PPE) for the stage to be executed.

Contact with the skin can cause irritation.
If swallowed, do not induce vomiting. In the case of contact with the eyes, wash them abundantly with water. In either case, seek medical aid immediately.

Do not smoke in the work area.

Ensure that the electrical installations are perfect and do not cause sparks.
Do not use diluent to clean the skin, hands and other parts of the body. To clean the hands use alcohol, and then wash with water and appropriate cleaning pastes.

If there is a fire, use CO2 or chemical powder extinguishers. It is not recommended to use water to extinguish the fire produced by burning paint.
Paints and diluents must be stored in ventilated places protected from bad weather. The temperature can oscillate between 10 and 40°C.

If symptoms of intoxication by inhaling chemical vapors occur, the intoxicated person must be removed immediately from the work place to ventilated places.
If fainting, call a doctor immediately.

Product intended for use and handling of professionals linked to the painting area.

This product shall be applied and used, in compliance with all the National Health, Safety and Environment standards and regulations.

If it is necessary to remove the paint already applied and hardened from the substratum, the operator and the people who are in the same environment shall use appropriate personal protection equipment (PPE), as indicated in the safety information sheet (MSDS).

In situations where it is necessary to execute processes of welding metallic parts painted with this product, powder and gases will be released (smoke) which will require the use of appropriate personal protection equipment (masks with activated charcoal filters and even remote air supply equipment) in accordance with each environment.

The applications in confined areas require suitable ventilation, besides specific methods and procedures. For these situations contact the safety area of your company.

For further information contact the Technical Department of WEG (tintas@weg.net).

NOTE

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

If using the product without prior 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 the behavior, safety, suitability or durability of the product.

Certain information contained in this bulletin is merely an estimate, 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 Bulletin.

The information contained in this technical bulletin 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.