WEG FENOXI

PRODUCT DESCRIPTION
Novolac epoxy Finishing Primer of high thickness, in two components with excellent chemical resistance including several solvents, excellent anticorrosive resistance and to abrasion. It has certification for contact with drinking water and alcoholic food. 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. Highly recommended for the internal and external painting of tanks and piping where the chemical resistance is the main requirement.

PACKAGING

<table>
<thead>
<tr>
<th>Component A</th>
<th>Component B</th>
</tr>
</thead>
<tbody>
<tr>
<td>WEG FENOXI – Bucket (15.0 L)</td>
<td>WEG FENOXI COMPONENT B– 10003187 (5.0 L)</td>
</tr>
<tr>
<td>WEG FENOXI – Gallon (2.7 L)</td>
<td>WEG FENOXI COMPONENT B– 10003186 (0.9 L)</td>
</tr>
</tbody>
</table>

PRODUCT INFORMATION

<table>
<thead>
<tr>
<th>Colors</th>
<th>White, Gray, Red Oxide and Blue.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gloss/Aspect</td>
<td>Semi Gloss</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>76 ± 2% (ISO 3233)</td>
</tr>
<tr>
<td>VOC Content</td>
<td>230 g/L</td>
</tr>
<tr>
<td>Shelf Life</td>
<td>12 months at 25°C</td>
</tr>
<tr>
<td>Dry Film Thickness</td>
<td>100 - 150 micrometers dry</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>6.10 m²/L at 125 micrometers dry film thickness, not considering lost factors.</td>
</tr>
<tr>
<td>Resistance to Dry Heat</td>
<td>Maximum temperature 120 ºC. The product maintains its physical and chemical properties until the temperature of 120 ºC, but, as of 60 ºC, variances may occur in the color and gloss of the paint.</td>
</tr>
<tr>
<td>Drying Information</td>
<td></td>
</tr>
<tr>
<td>Touch dry</td>
<td>10ºC</td>
</tr>
<tr>
<td>Hard dry</td>
<td>9 hours</td>
</tr>
<tr>
<td>Final</td>
<td>24 hours</td>
</tr>
<tr>
<td>Overcoating Drying</td>
<td></td>
</tr>
<tr>
<td>Min.</td>
<td>10ºC</td>
</tr>
<tr>
<td>Max.</td>
<td>24 hours</td>
</tr>
<tr>
<td></td>
<td>336 hours</td>
</tr>
</tbody>
</table>
### 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.

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


If oxidation has occurred between blasting and application of this product, the surface should be blasted again to the specified visual standard.

Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

A surface profile of 40 – 85 μm is recommended.

For the internal protection of tanks, it is recommended to test the soluble salts according to ISO 8502-6 on the blasted surface before applying the coating. The permitted soluble salts shall not exceed a conductivity measured in accordance with ISO 8502-9 corresponding to a NaCl content of 20 mg/m².

**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 adhesion between the coats.

For further information contact the Technical Department of WEG ([tintas@weg.net](mailto: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 pigment settling 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 for tank coating
Epoxy Diluent 3005 for general coating

Dilution
It is advisable to dilute only in special circumstances. Depending on the application method, the maximum thinning should be 5% by 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
3 hours at 25°C
The pot life of the mixture is reduced with the increase of the ambient temperature.

Induction Time (25°C)
Induction is not required.

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

The pot life is performed according to ABN NBR 15742 where the volume of the mixture is standardized. Larger volumes of catalyzed coating, added to different environment temperatures will influence the pot life of the mixture and different times than those mentioned in this technical datasheet can be obtained.
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 coating.

After mixing the bicomponent products, if stoppages occur in application, and they exceed the useful life of the mixture (where the coating 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: 3000 psi
- Hose: 1/4” inside diameter
- Tip range: 0.018” to 0.023”
- Filter: Mesh 60
- Dilution: -

**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 coating.

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

**Equipment Cleaning:** Use Epoxy Diluent 3005.

**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 coating will have variance in its fluidity and will harden making cleaning difficult.

All used equipment shall be thoroughly flushed with the proper thinner.
### APPLICATION PERFORMANCE

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

**For application by wide paintbrush, it may be necessary to employ in two or more strokes in order to obtain a uniform coat in accordance with the film thickness recommended per coat.**

It is recommend painting on surfaces blasted 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.

The temperature of the surface 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.

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

It shall not be applied in adverse conditions, as relative air humidity (RH) above 85% or condensed surfaces. Color, aspect and gloss changes can be noticed in the film when application occurs in high relative humidity periods, rainy or low temperature days or when the film is exterior exposed before curing.

After the application procedure, during the cure process, when the parts applied undergo conditions of low temperatures and/or high humidity, there may occur the forming of exudation and/or blush in the film during they cure process, which shall be removed by washing with fresh water or cleaning with fabrics soaked in appropriate diluent. This feature does not affect the anticorrosive resistance of the film applied.

Epoxy products are known for exhibiting excellent anticorrosive properties and low resistance to sunlight. 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. We remind you that even after undergoing this calcination, the film maintains its anticorrosive protection.

In recent coated surfaces with direct contact with water during the process of cure, it may occur stained with color change (more visible in dark colors), retard of cure and compromising the product performance.

The product shall have color alteration when exposed to the exterior and temperatures above 120°C, not affecting the anticorrosive performance.

In painting varying the application method of coatings in the same work, it may occur differences in gloss and final aspect of the coated surfaces.

**WEG Fenoxi is usually applied in a total thickness of 250 micrometers, being 125 micrometers per coat.**

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

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

### SYSTEM COMPATIBILITY AND MAINTENANCE OVERCOATING

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 datasheet.

The preparation of the surface, handling and use of coatings 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 coating.

Coatings 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 coating 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 coated 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](mailto:tintas@weg.net)).

## 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 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 datasheet 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 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.