TECHNICAL DATA SHEET

WEGPOXI BLOCK N 2912 TYPE II ALUMINUM PETROBRAS 0170

PRODUCT DESCRIPTION

Three-component high solids, high-build novolac epoxy primer, pigmented with aluminum. Very low volatile organic compounds (Low VOC). Offers excellent chemical resistance and good impact resistance. WEGPOXI BLOCK N 2912 Type II provides unmatched anticorrosive protection, excellent surface hardness, and impermeability.

RECOMMENDED USE

Can also be indicated for exterior of tanks and pipelines, oil and natural gas exploration platforms, decks, and onboard machinery, as well as for industrial applications and metal structures where anticorrosive and chemical resistance is an essential requirement.

CERTIFICATIONS AND APPROVALS

Complies with Petrobras Standard N 2912 - Type II.

Complies with Petrobras Standard N 2913.

When supplied to comply with the ROHS Directive (Restriction of Certain Hazardous Substances), this product includes the letter R in its nomenclature description.

PACKAGING

Component A	3.6L Package containing 2.33L
Component B	0.9L Package containing 0.55L
Component C	0.9L Package containing 0.8kg

CHARACTERISTICS

Color	Aluminum.
VOC content	103.81 g/l
Flash Point	60 °C
Shelf Life	24 months
Dry Film Thickness	400 µm - 500 µm
Dry Heat Resistance	Maximum temperature 150 °C. The product maintains its chemical properties up to a temperature of 150 °C, but from 60°C, color and gloss variations in the paint may occur.
Theoretical Coverage	2,13 m2/l without dilution at a dry film thickness of 450 µm. Loss factors during application are not considered.

DRYING

Drying

	10 °C	25 °C	35 °C
Touch	14 hours	6 hours	4 hours
Manipulation	30 hours	16 hours	8 hours
Final	240 hours	168 hours	168 hours
Pot life	2 hours	90 min	60 min

Recoat Drying

	10 °C	25 °C	35 °C
Minimum	10 hours	6 hours	3 hours
Maximum	30 hours	24 hours	20 hours

SURFACE PREPARATION

Standard Surface Preparation

The performance of this product is related to the degree of surface preparation. In case of doubts, for more information, consult WEG's Technical Department.

The surface must be clean, dry, and free of contaminants. Completely remove oils, greases, and

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fats according to SSPC-SP1.

Remove accumulated dirt using a dry brush, clean dry cloth, compressed air blow, vacuum, or a combination of these. Remove soluble salts by washing with plenty of fresh water, preferably under low pressure (up to 5,000 psi), according to SSPC-SP12/NACE No. 5 standard.

Recommended Surface Profile
It is recommended a roughness profile between 50 and 100 micrometers.

Abrasive Blasting
Perform abrasive blasting to near-white metal, Sa 2½ grade, according to ISO 8501-1 visual standard (A Sa 2½, B Sa 2½, C Sa 2½, D Sa 2½), or according to SSPC-SP10/NACE No. 2, visual standard SSPC-VIS 1 (A SP10, B SP10, C SP10, D SP10, G1 SP10, G2 SP10, G3 SP10).

Inspect the freshly blasted surface, observing defects that may appear after treatment. Correct them by grinding, filling with welds and/or epoxy putty.

For areas near marine environments, wash with fresh water at low pressure (minimum 3,000 psi) before abrasive blasting. In some cases, repeat washing after blasting to remove soluble contaminants and perform a new abrasive blasting.

If oxidation occurs between the end of abrasive blasting and coating application, the surface must be blasted again until the specified visual standard is achieved.

The maximum soluble contaminant content on the blasted surface must meet ISO 8502-6 and ISO 8502-9 standards, not exceeding 20 mg/cm² (2 ¼g/cm²) inimmersed, buried, or submerged areas.

Water Jetting
Application of this product is allowed on hydroblasted surfaces showing moderate flash rust, WJ-2M, according to SSPC-VIS 4/NACE VIS 7 visual standard.

Perform hydroblasting (pressure e 10,000 psi) according to SSPC-SP 12/NACE No. 5, reaching WJ-2 grade (C WJ-2, D WJ-2, E WJ-2, F WJ-2, G WJ-2, and H WJ-2) of SSPC-VIS 4/NACE VIS 7 visual standard.

NOTE 1: Ultra-high-pressure hydroblasting can remove oils and greases from the surface; however, this does not replace prior degreasing.

Hand and Power Tool Cleaning
Perform manual mechanical cleaning for carbon steel surfaces with oxidation grades C or D, according to SSPC-VIS 3 visual standards. For previously painted surfaces with grades E, F, or G, follow SSPC-VIS 3.

The manual mechanical cleaning process is recommended only for small areas.

If manual mechanical cleaning is not possible, alternatively perform near-white metal abrasive blasting, Sa 2½ grade according to ISO 8501-1 visual standard (C Sa 2½ and D Sa 2½) or SSPC-SP 10/NACE No. 2, visual standard SSPC-VIS 1 (C SP 10, D SP 10).

This surface treatment is not recommended for internal tank maintenance.

Carbon Steel Surfaces
Hard surface layers (e.g., layers resulting from flame cutting) must be removed by grinding before starting abrasive blasting.

All welds must be inspected and, if necessary, repaired before completing abrasive blasting. Porosities, cavities, weld splatter, etc., must be repaired with proper mechanical treatment or welding repair. In other areas, round edges and sharp corners (r e 2 mm, ISO 8501-3).

Over Primer
For touch-ups, maintain the original painting system.

If an anticorrosive primer is needed, it must be approved by WEG technical department. The primer must be dry and free of contaminants.

Existing shop primer must be removed via abrasive blasting to near-white metal, grade Sa 2½, ISO 8501-1 standard or SSPC-SP 10/NACE No.2, unless the manufacturer ensures integrity and performance of the painting system over the primer.

Small worn or damaged areas should be prepared with abrasive blasting to near-white metal, grade Sa 2½, ISO 8501-1 standard or SSPC-SP10/NACE No.2. If not possible, use rotary-mechanical tools grade St 3 or SSPC-SP11, using SSPC-VIS3 visual standard as reference.

For exterior coatings with exceeded maximum recoat interval, open the anchor profile using manual or mechanical tools (60 or 80-grit sandpaper, rotary brush, etc.) or light abrasive blasting grade Sa 1, ISO 8501-1 standard or SSPC-SP 7/NACE No.4. For interior coatings, only light blasting grade Sa 1, ISO 8501-1 standard or SSPC-SP 7/NACE No.4 is acceptable.

Respect the primer recoat interval before applying the product. If exceeded, perform sanding according to the technical bulletin. Painting over primer with exceeded interval may have adhesion lower than specified by Petrobras N2913 and ASTM D4541.

APPLICATION PREPARATION

Mixing	Homogenize the content of component A using mechanical or pneumatic stirring. Ensure no sediment remains at the bottom of the container. Gradually add component A to component C. Homogenize slowly using manual or pneumatic stirring until a smooth, lump-free mixture is obtained. Then add component B. Repeat the homogenization process. The indicated mixing proportion for paint preparation must be respected. If necessary, filter through a 60-mesh screen.
Mixing Ratio	By volume: 3.3 A x 1 B x 0.7 C.
Dilution	Ready to use.
Notes	No dilution is required. Product ready to use. If necessary, consult the WEG Technical Department.
Pot Life	1 h 30 min The shelf life of the mixture is reduced as the ambient temperature increases. The pot-life test of the mixture is carried out according to ABNT NBR 15742; however, different volumes of paint prepared at once, combined with varying ambient and paint temperatures, will affect the mixture's shelf life, potentially resulting in outcomes different from those stated in this technical bulletin.
Induction Time	No induction time required. In very hot locations, we recommend consulting WEG's Technical Department.

APPLICATION METHODS

Airless Spray Gun	Airless: Use minimum pump 60:1 Fluid pressure: 3500 - 4500 psi Hose: 3/8" inner diameter Nozzle: 0.025" - 0.031" Note: The fluid hose diameter must not be less than 1/2" with 3/8" at the whip, and its length must not exceed 5 meters.
Roller	Use a short-haired, seamless wool or synthetic roller for epoxy paints. For application with brush and/or roller, it may be necessary to apply two or more coats to achieve a uniform layer and the recommended film thickness.
Brush	Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).
Cleaning of the equipments:	EPOXY DILUENT 3012
Notes	The data presented serves as a guide and similar equipment may be used. Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination. Do not allow catalyzed product to remain in contact with application equipment, as at temperatures above the indicated "pot life", the paint will show variation in flow and will harden, making cleaning difficult.

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

After mixing two-component products, if there are application stops and the pot life has been exceeded (paint shows variation in flow), it can no longer be re-thinned for later application.

In spray application, overlap each gun pass by 50%, finishing with a cross pass. This technique avoids uncovered or unprotected areas and ensures proper aesthetic finish.

Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.

Clean all equipment immediately after use.

It is considered good practice to periodically wash the spraying equipment during the day. The cleaning frequency depends on the amount sprayed, temperature, and elapsed time, including all delays.

SAFETY PRECAUTIONS

Product developed for industrial use intended for handling by qualified professionals. Carefully read all information contained in the SDS of this product, available at: www.weg.net.

Store in a covered and well-ventilated place. 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. Use protective gloves/protective clothing/eye protection/face protection.

Empty containers and materials with paint residues must be disposed of according to current legislation. Take care of the environment.

NOTE

The information contained in this technical bulletin is based on the experience and knowledge acquired in the field by WEG's technical team.

In the event of using the product without prior consultation with WEG regarding its suitability for the purpose for which the customer intends to use it, the customer acknowledges that the use will be at their own exclusive responsibility, and WEG is not liable for the behavior, safety, suitability, or durability of the product.

Some information mentioned in this bulletin is only an estimate and may vary due to factors beyond the manufacturer's control. Therefore, WEG does not guarantee and assumes no responsibility for performance, efficiency, or any material or personal damages resulting from the incorrect use of the products in question or from the information contained in this Technical Bulletin.

The information contained in this technical bulletin is subject to periodic modifications, without prior notice, due to our policy of continuous improvement and evolution of our products and services, providing quality solutions to meet the needs of our customers.

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