



CLEAR W-POXI CVD 322

PRODUCT DESCRIPTION

Two-component polyamide epoxy primer/finish with high solids and zinc phosphate anticorrosive pigmentation. Offers fast drying and good applicability. Excellent adhesion to carbon steel prepared by abrasive blasting. Applicable in a single high-build coat, simplifying the painting process.

RECOMMENDED USE

Recommended for painting metal structures, exterior of tanks, pipelines, silos, and various equipment, whether new or maintenance, in pulp and paper, sugar ethanol, chemical and petrochemical industries, among others.

CERTIFICATIONS AND APPROVALS

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	0.95 US gal Package containing 0.95 US gal 5.28 US gal Package containing 5.28 US gal
Component B	0.95 US gal Package containing 0.95 US gal 5.28 US gal Package containing 5.28 US gal
Component B II	0.95 US gal Package containing 0.95 US gal 5.28 US gal Package containing 5.28 US gal

CHARACTERISTICS

Color	According to customer standard. RAL and Munsell chart.
Gloss	Satin
VOC content	2.30 lb/gal
Volume Solids	80 ± 2% (ISO 3233)
Flash Point	49 °C
Shelf Life	24 months
Specific Gravity	Min: 1.31 Max: 1.51 g/cm³

DRYING

77 °F

Touch Dry:	1 h
Handle Dry:	4 h
Full Cure:	7 days
Minimum recoat drying time:	4 h
Maximum recoat drying time:	30 days

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 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.

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.

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.

If manual mechanical cleaning is not possible, alternatively perform commercial abrasive blasting, Sa 2 grade according to ISO 8501-1 visual standard (C Sa 2 and D Sa 2) or SSPC-SP 6/NACE No. 3, visual standard SSPC-VIS 1 (C SP 6, D SP 6).

Mechanically treat the surface until achieving at least St 3 grade according to ISO 8501-1 visual standard or SSPC-SP 11, using SSPC-VIS 3 visual standard as guidance.

Maintenance and Repair

When the aged coating shows good adhesion, perform light sanding to break gloss, followed by dust and residue cleaning to ensure better adhesion between coats.

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 0.0787 in, ISO 8501-3).

Over Primer

Respect the product recoat interval. If exceeded, perform light manual/mechanical sanding to break gloss and clean dust/residues for better adhesion between coats.

Over Aged Coating

For aged paint with good adhesion, perform light sanding to break gloss and clean dust/residues, ensuring better adhesion between coats.

It is recommended to test the paint on a small area to check compatibility and ensure aged paint is well adhered. Loose or poorly adhered paints must be removed. Repainting should be done only on well-preserved surfaces.

It is acceptable to adopt less stringent preparation standards as long as contaminant absence is ensured via high-pressure fresh water cleaning (5,000-10,000 psi) according to SSPC-SP12/NACE No.5. In case of doubt, consult the technical area.

Remove all contaminants from the existing paint. Areas where the film is not adhered must be removed with light blasting grade Sa 1 (brush off) or according to SSPC-SP7, ISO 8501-1 visual standard. Corrosion points, worn, or damaged areas must be prepared by commercial abrasive blasting grade Sa 2, ISO 8501-1 standard or SSPC-SP6/NACE No.3, SSPC-VIS 1 standard. If not possible, use rotary-mechanical tools according to SSPC-SP 11.

APPLICATION PREPARATION

Mixing	Homogenize the content of each component using mechanical or pneumatic stirring (A and B). Ensure no sediment remains at the bottom of the container. Add component B to component A in the indicated mixing ratio under stirring until completely homogenized, respecting the mixing ratio.
Thinner	EPOXY DILUENT 3013
Dilution	Depending on the application method, dilute to a maximum of 15%.



Notes	The amount of Diluent may vary depending on the type of equipment used and environmental conditions during application. Only add Diluent after complete mixing of the other components. Do not dilute with solvents not allowed by local legislation, and do not exceed the indicated dilution percentage. Excessive dilution may affect film formation, appearance, and make it difficult to achieve the specified thickness.
Pot Life	<p>3 h</p> <p>The shelf life of the mixture is reduced as the ambient temperature increases.</p> <p>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.</p>
Induction Time	<p>Wait 20 minutes before application.</p> <p>In very hot locations, we recommend consulting WEG's Technical Department.</p>

APPLICATION METHODS

Conventional Spray Gun	<p>Spray gun: JGA 502/3 Devilbiss or equivalent Fluid nozzle: EX Air cap: 704 Atomization pressure: 50 - 70 psi Tank pressure: 10 - 30 psi.</p>
Airless Spray Gun	<p>Airless: Use minimum pump 60:1 Fluid pressure: 2000 - 3000 psi Hose: 1/4" inner diameter Nozzle: 0.015" - 0.021". Filter: mesh 60.</p>
Roller	<p>Use a short-haired, seamless wool or synthetic roller for epoxy paints.</p> <p>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.</p>
Brush	<p>Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).</p>
Cleaning of the equipments:	EPOXY DILUENT 3013
Notes	<p>The data presented serves as a guide and similar equipment may be used.</p> <p>Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination.</p> <p>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.</p> <p>Before application, ensure that the equipment and respective components are clean and in optimal condition.</p> <p>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.</p> <p>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.</p> <p>Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.</p> <p>Clean all equipment immediately after use.</p> <p>It is considered good practice to periodically wash the</p>



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.

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