

**W-POXI ENG 043**

**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**

<b>Component A</b>	3.6L Package containing 3.6L 20L Package containing 20L
<b>Component B</b>	3.6L Package containing 3.6L 20L Package containing 20L

**CHARACTERISTICS**

<b>Color</b>	According to customer standard. RAL and Munsell chart.
<b>Gloss</b>	Semi-Gloss Semi-Matte
<b>Volume Solids</b>	85 ± 3% (ISO 3233)
<b>Dry Film Thickness</b>	100 µm - 200 µm
<b>Dry Heat Resistance</b>	Maximum temperature 100 °C. The product maintains its chemical properties up to a temperature of 100 °C, but from 60°C, color and gloss variations in the paint may occur.
<b>Theoretical Coverage</b>	5,67 m <sup>2</sup> /l without dilution at a dry film thickness of 150 µm. Loss factors during application are not considered.

**DRYING**

	<b>25 °C</b>
<b>Touch Dry:</b>	1 h
<b>Handle Dry:</b>	4 h
<b>Full Cure:</b>	7 days
<b>Minimum recoat drying time:</b>	4 h
<b>Maximum recoat drying time:</b>	6 months

**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.

Completely remove oils and greases by applying a degreasing product or according to the solvent cleaning method. Whenever cleaning surfaces with cloths, replace them to avoid saturation. Do not use cotton waste or colored cloths.

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

**Recommended Surface Profile**

It is recommended a roughness profile between 50 and 75 micrometers.



**Abrasive Blasting**

For other applications, it is recommended to paint on surfaces blasted to Sa 2½ or Sa 3 grade, according to SSPC-SP10 or SSPC-SP5, respectively. Visual standard ISO 8501-1.

Evaluate the surface after blasting, observing revealed defects and adopt practices to minimize them, such as grinding or filling.

**New Constructions**

For new construction, treat overspray, weld beads, damaged areas, edges, and sharp corners by abrasive blasting grade Sa 2½ or SSPC-SP10, visual standard ISO 8501-1. If not possible, consult WEG Technical Department.

**APPLICATION PREPARATION**

<b>Mixing</b>	Homogenize the contents of each component by mechanical or pneumatic agitation (A and B). Add component B to component A according to the indicated mixing ratio, under agitation, until fully homogenized.
<b>Mixing Ratio</b>	By volume: 1 A x 1 B.
<b>Thinner</b>	EPOXY DILUENT 3005
<b>Dilution</b>	Depending on the application method, dilute to a maximum of 10%.
<b>Notes</b>	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. Only add the diluent after completely mixing components A and B.
<b>Pot Life</b>	4 h  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.
<b>Induction Time</b>	Wait 20 minutes before application.  In very hot locations, we recommend consulting WEG's Technical Department.

**APPLICATION METHODS**

<b>Conventional Spray Gun</b>	Spray gun: JGA 5023-67 Devilbiss or equivalent Fluid nozzle: EX or FX Air cap: 704 Atomization pressure: 50 - 70 psi Tank pressure: 10 - 30 psi.
<b>Airless Spray Gun</b>	Airless: Use minimum pump 60:1 Fluid pressure: 2000 - 2500 psi Hose: 1/4" inner diameter Nozzle: 0.015" - 0.021".
<b>Roller</b>	Use wool or synthetic rollers.
<b>Brush</b>	Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups). 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.

**Cleaning of the equipments:**

EPOXY DILUENT 3005

**Notes**

Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination. 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. Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas. Clean all equipment immediately after use. Do not leave material in hoses, guns, or equipment used for spraying. Thoroughly wash all used equipment.

**APPLICATION PERFORMANCE**

For coatings applied in coastal areas exposed to sea spray, it is recommended to wash with fresh water between coats to remove deposited impurities.

Proper washing and degreasing of the surface are essential, as well as sanding of old paints whenever necessary to promote adhesion.

Do not apply the product after the pot life has been exceeded.

For optimal application properties, the paint temperature should be between 21°C and 27°C before mixing and application.

Surface preparation is recommended to Sa 2½ or SSPC SP10 (ISO 8501-1 visual standard). Less stringent standards are acceptable as long as there are no contaminants, supplemented with high-pressure water cleaning.

Painting is recommended only if surface temperature is at least 3°C above the dew point.

Substrate temperature, climatic and environmental conditions during application and curing, as well as applied film thickness, may affect drying time.

Do not apply under adverse conditions, such as RH above 70% or on condensed surfaces. Small variations in color, appearance, and gloss may occur during high humidity, rainy days, cold locations, or when parts dry outdoors.

When applying by brush or roller, two or more coats may be necessary to achieve a uniform layer and recommended film thickness.

Paintings performed with varying application methods on the same project may result in differences in gloss and final appearance.

On freshly painted surfaces in direct contact with water during the curing process, localized staining with color change (more visible in darker colors), curing delay, and compromised product performance may occur.

Product not recommended for internal tank painting.

Small variations in color, appearance, and gloss (more noticeable in dark colors), as well as delayed curing and performance compromise, may occur during high humidity, rainy days, cold locations, or when parts dry outdoors.

Epoxy-based products are known for their excellent anticorrosive properties and low resistance to sun exposure. When the applied film is exposed to weathering, over time it will lose gloss, a phenomenon known as chalking, which consequently alters its color. It is important to note that, despite this chalking, the film's anticorrosive protection is not compromised.

**SYSTEM COMPATIBILITY AND MAINTENANCE REPAINTING**

The product may be applied over aged paints or other coating systems; however, it is advisable to test the product's contact with the previous paint on a small test area. We recommend dulling the surface with sanding for better performance; it must be ensured that the original material is well adhered. All non-adhered paint must be removed; areas with corrosion or applications over aged paints must be treated according to technical guidance.

For topcoat application over the product, the repainting interval must be respected; the surface must be dry and free of contaminants.

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## 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](http://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.

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## 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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