



WEGPOXI BLOCK N 2912 TYPE II

PRODUCT DESCRIPTION

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

RECOMMENDED USE

Developed for application on oil and formation water tanks. Also indicated for crude oil tanks, fuel oils, light products (fuels and solvents), ballast tanks, ships in general, and maritime structures. In offshore, can be used on decks, oil and natural gas exploration platforms, onboard machinery, pipelines, etc. Also indicated for industrial applications such as chemical and pulp industries, aerial or submerged metal structures (upon consultation), and various machinery. Indicated for internal and external application on various pipelines, immersed or buried. Particularly suitable for environments where anticorrosive and chemical resistance is an essential requirement.

Indicated for internal painting of spirit storage tanks.

Complies with requirements of resolutions No. 105/1999, RDC No. 42/2013, RDC No. 51/2010, RDC No. 52/2010, RDC No. 326/2019, Decree No. 55.871/1965, and SVS Ordinance No. 685 for food contact.

CERTIFICATIONS AND APPROVALS

Complies with Petrobras Standard N 2912 - Type II.

Complies with Petrobras Standard N 2913.

PACKAGING

Component A	0.95 US gal Package containing 0.81 US gal 5.28 US gal Package containing 4.47 US gal
Component B	0.24 US gal Package containing 0.15 US gal 1.06 US gal Package containing 0.81 US gal

CHARACTERISTICS

Color	White. Gray. Green.
VOC content	1.2 (lb/gal). Note: The average of VOC on the line can vary depending on the color.
Volume Solids	96 ± 1% (ISO 3233)
Shelf Life	24 months
Dry Film Thickness	15.7 mils - 19.7 mils
Dry Heat Resistance	Maximum temperature 392 °F. The product maintains its chemical properties up to a temperature of 392 °F, but from 140°F, color and gloss variations in the paint may occur.
Theoretical Coverage	86.8 ft ² /gal without dilution at a dry film thickness of 17.7 mils. Loss factors during application are not considered.

DRYING

Drying

	50 °F	77 °F	95 °F
Toque	14 hours	6 hours	4 hours
Manuseio	30 hours	16 hours	8 hours
Final	168 hours	120 hours	120 hours
Pot life	120 min	90 min	60 min

Recoat Drying

	50 °F	77 °F	95 °F
Minima	10 hours	6 hours	3 hours
Maxima	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.

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.

The surface must be clean, dry, and free of any contaminants. Remove oils, greases, and fats according to SSPC-SP1 standard.

Recommended Surface Profile

It is recommended a roughness profile between 1.97 and 3.94 mils.

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 level of soluble impurities on the blasted surface, as per the test described in ISO 8502-6 and using distilled water, must not exceed a conductivity measured according to ISO 8502-9 corresponding to a maximum of 20 mg/cm² (2 ¼g/cm²) in immersed, 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 0.0787 in, ISO 8501-3).

Concrete Surfaces

No coating or paint should be applied until the concrete (or cement-sand screed) is fully dry and cured for at least 28 days under normal climatic conditions.

For more information, consult the Concrete Surface Preparation and Application Manual.



This product must be applied over a recommended sealer or primer for concrete surfaces to compose an appropriate painting system. For correct application of the sealer/primer, consult its technical bulletin.

Coatings should not be applied over floors contaminated with oils or aggressive products. The floor must be effectively cleaned. Applying over residues of these contaminants may cause coating detachment and other failures.

Respect the recoat interval between sealer or primer coats for applying the product. If the recoat time is exceeded, sand as described in the sealer or primer technical bulletin.

For concrete surfaces, the application of W POXI Verniz HSS 301 as a sealing primer is required, ensuring proper preparation, anchorage, and performance of the coating system. This high-solids epoxy varnish provides superior penetration and adhesion on concrete, mortar, and industrial floors, ensuring proper surface uniformity prior to the application of the specified coatings.

Coating on old concrete only upon recommendation from WEG Technical Department.

Product application must follow guidance from our technical department to achieve the expected performance. Factors such as surface condition, roughness, contaminant level, and other specifics are essential for proper surface preparation.

The performance of this product is associated with surface preparation. The surface must be clean, solid, free of any contaminants, fully dry, and have sufficient roughness to allow adhesion of the applied protection system.

Over Primer

For touch-ups, maintain the original painting system.

The product must be applied over a specific primer. The primer must be clean, dry, and free of contaminants. The topcoat must be applied within the primer recoat interval. Consult the primer technical bulletin for correct application.

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 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.
Mixing Ratio	By volume: 5.5 A x 1 B.
Thinner	Not applicable.
Dilution	Ready to use.
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 70:1
 Fluid pressure: 3500 - 4500 psi
 Hose: The hose from the airless pump to the whip must be a maximum of 49 ft with 1/2#, 0.5 in inner diameter. The whip hose reaching the gun must be 5 ft with 3/8#, 0.4 in inner diameter.
 Nozzle: 0.025" - 0.031".

Roller

Recommended only for small areas or touch-ups. Use a low-pile seamless wool roller 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:

Not applicable.

Notes

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.
 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.

APPLICATION PERFORMANCE

The product should be stored between 68°C - 86°C to achieve appropriate application viscosity.

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

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

Do not use excessive air pressure. Properly adjust fluid and nozzle pressure for better atomization.

For optimal application properties, the paint temperature must be between 69.8°F - 80.6°F before mixing and application.

Before application, observe weather conditions: there must be no threat of rain or drizzle. Surface temperature must be at least 37,4°F above the dew point, and relative humidity should not exceed 85%. Adverse conditions may cause color variations and other characteristics. Consult WEG Technical Department.



Due to high viscosity and thixotropy, dispersed bubble entrapment will occur. Volume solids test according to ISO 3233 may show values below 80%; this should not be considered for yield calculations.

We recommend painting only if the measured surface temperature is at least 5.4°F above the dew point.

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

Epoxy systems may have longer curing times when exposed to low temperatures. For curing below 50°F, consult WEG Technical Department.

The product allows painting on recently water-blasted surfaces with slight traces of flash rust (or relatively advanced degree of flash rusting, equivalent to the "moderate" degree described in SSPC VIS4(I) / NACE N°7).

Due to the differentiated curing of LACKPOXI 76 Wet Surface Primer/Finish N 2680, the theoretical consumption calculation should be adjusted to 272 ft²/gal at a dry film thickness of 5.91 mils.

For aluminum-colored paint (0170), the theoretical coverage should be considered 228 ft²/gal at 5.91 mils dry film thickness.

These values are based on tests conducted in the WEG technical laboratory.

Loss factors from application conditions and methods should be considered to determine practical coverage for each project.

Tests according to item 5.2.3.6 of standard N 2912 can be performed after 120 hours of paint curing. For final drying times less than 288 hours, consult WEG Technical Department.

It is suggested to maintain forced air circulation in tanks/reservoirs to avoid solvent saturation during curing.

Products for contact with potable water or food: wash with fresh water and neutral soap before operation.

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

It is not recommended to apply this product on surfaces with a water film, under direct rain impact, on freshly painted surfaces exposed to water during curing, in places with low temperatures, or in situations where parts are applied and left to dry outdoors, as localized staining with color change (more visible in dark colors), curing delay, and compromised product performance may occur.

Technical quality complaints regarding the characteristics described above will be considered unfounded and without indemnity coverage.

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.

Under adverse weather conditions in indoor and/or outdoor environments with high relative humidity, rain or drizzle, low or very low temperatures, and excessively high temperatures, variations in color and other product characteristics may occur. Please consult WEG's Technical Department for more information.

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.
