

**W-POXI CVE 35**

**PRODUCT DESCRIPTION**

Low-build, two-component aliphatic isocyanate epoxy shop primer. Adhesion primer for non-ferrous substrates.

**RECOMMENDED USE**

Indicated as an adhesion primer for electrolytic or hot-dip galvanized steel, copper, brass, and non-ferrous substrates such as fiberglass. Widely used on roofing, pipelines, structures, and equipment, can receive various optional topcoats depending on environment aggressiveness. Can also be used as a system converter.

**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 3.5L 20L Package containing 19.45L
<b>Component B</b>	0.25L Package containing 0.1L 0.9L Package containing 0.55L

**CHARACTERISTICS**

<b>Color</b>	Yellow. White. Gray. Black. Red Oxide.
<b>Gloss</b>	Ultra-Matte
<b>VOC content</b>	882.38 g/l
<b>Volume Solids</b>	19 ± 2% (ISO 3233)
<b>Shelf Life</b>	24 months
<b>Dry Film Thickness</b>	25 µm - 30 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>	6,91 m <sup>2</sup> /l without dilution at a dry film thickness of 28 µm. Loss factors during application are not considered.

**DRYING**

<b>Drying</b>				
	<b>10 °C</b>	<b>25 °C</b>	<b>35 °C</b>	
<b>Touch</b>	25 min	20 min	15 min	
<b>Manipulation</b>	2 hours	1 hour	40 min	
<b>Final</b>	192 hours	168 hours	144 hours	
<b>Recoat Drying</b>				
	<b>10 °C</b>	<b>25 °C</b>	<b>35 °C</b>	
<b>Minimum</b>	8 hours	6 hours	4 hours	
<b>Maximum</b>	72 hours	72 hours	72 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



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.

**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).

**Hot-Dip Galvanized Surfaces**

Wash the substrate with running water to remove soluble salts resulting from the galvanizing process prior to abrasive blasting. Use a non-woven abrasive pad made of synthetic fibers bonded with resin impregnated with abrasive mineral.

It is recommended to apply the coating over surfaces blasted to Sa 1 (brush-off) according to ISO 8501-1 or SSPC-SP7 standards, using 20-40 mesh steel grit, ensuring the operation only produces a surface roughness between 10 and 25 micrometers and a uniform matte appearance (visual standard ISO 8501-1).

For light abrasive blasting (brush-off), hot-dip galvanized carbon steel plates should have a minimum thickness of 3.0 mm and a zinc coating of at least 60 micrometres.

For small areas, it is acceptable to first remove surface oil and grease with clean cloths soaked in Cleaning Thinner in accordance with SSPC-SP1.

Perform a "light sanding" using 100-grit sandpaper, preferably creating cross-hatch (horizontal and vertical) scratches. Clean the surface again with thinner-soaked cloths, changing them frequently. When cleaning with cloths, avoid using rags or colored fabrics.

**Fiber Surfaces**

Remove all dirt and grease from the surface using clean cloths soaked in Cleaning Solvent according to SSPC SP1. Avoid using rags or colored cloths. Proceed with a "light sanding" using 180-grit sandpaper to promote roughness. Whenever possible, make cross-hatch scratches (horizontal and vertical). Clean the surface again with cloths soaked in solvent, changing them frequently.

**APPLICATION PREPARATION**

<b>Mixing</b>	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.
<b>Mixing Ratio</b>	By volume: 35 A x 1 B.
<b>Thinner</b>	EPOXY DILUENT 3005
<b>Dilution</b>	Depending on the application method, dilute to a maximum of 5%.
<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.
<b>Pot Life</b>	8 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.

**APPLICATION METHODS**

<b>Conventional Spray Gun</b>	Spray gun: JGA 502/3 Devilbiss or equivalent
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	Fluid nozzle: EX Air cap: 704 Atomization pressure: 50 - 70 psi Tank pressure: 10 - 20 psi.
<b>Airless Spray Gun</b>	Airless: Use minimum pump 60:1 Fluid pressure: 1500 - 2500 psi Hose: 1/4" inner diameter Nozzle: 0.013" - 0.017". Filter: mesh 60.
<b>Cleaning of the equipments:</b>	EPOXY DILUENT 3005

**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.

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**

Component B must be protected from ambient moisture. Once opened, it is recommended to use it in its entirety or as quickly as possible.

Product performance depends on achieving the specified film thickness. Dry film thicknesses above the recommended may result in adhesion failures.

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

Surface preparation must follow the guidance in the "Surface Preparation" field and according to the type of substrate.

As this is a primer, color variation between batches of this material may occur.

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

Before application, observe weather conditions: there must be no threat of rain or drizzle. Surface temperature must be at least 3°C above the dew point, and relative humidity should not exceed 85%. Adverse conditions may cause color variations and other characteristics. Consult WEG Technical Department.

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.

Suitable for application over aged epoxy and polyurethane systems that show excellent adhesion to the substrate.

Epoxy systems may have longer curing times when exposed to low temperatures. For curing at temperatures below 10°C, consult the WEG Technical Department.



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

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.

**SYSTEM COMPATIBILITY AND MAINTENANCE REPAINTING**

The product accepts a wide range of topcoats, mainly epoxies and polyurethanes; in highly aggressive environments, we recommend using intermediate coatings before the specific topcoat.

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

**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.

**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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