



W-POXI END 31

PRODUCT DESCRIPTION

Two-component polyamide epoxy primer/finish with high solids content and zinc phosphate-based anticorrosive pigmentation. Provides fast drying and good applicability. Excellent adhesion to carbon steel treated by abrasive blasting and St 3 mechanical treatment.

RECOMMENDED USE

Recommended for painting metal structures, exterior of tanks, pipelines, silos, and various equipment, whether new or maintenance. Recommended for low aggressiveness environments.

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.

Complies with ET-053 PEMEX standard, Systems 2 and 3.

Modified RA-26

Modified RP-6

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

CHARACTERISTICS

Color	According to customer standard. RAL and Munsell chart.
Gloss	Semi-Matte
VOC content	3.0 (lb/gal). Note: The average of VOC on the line can vary depending on the color.
Volume Solids	71 ± 2% (ISO 3233)
Shelf Life	24 months
Dry Film Thickness	3.1 mils - 6.3 mils
Dry Heat Resistance	Maximum temperature 212 °F. The product maintains its chemical properties up to a temperature of 212 °F, but from 140°F, color and gloss variations in the paint may occur.
Theoretical Coverage	241.2 ft ² /gal without dilution at a dry film thickness of 4.7 mils. Loss factors during application are not considered.

DRYING

Drying	50 °F 77 °F 95 °F		
Touch	2 hours	1 hour	30 min
Manipulation	10 hours	4 hours	3 hours
Final	240 hours	168 hours	120 hours
Recoat Drying	50 °F 77 °F 95 °F		
Minimum	10 hours	4 hours	3 hours
Maximum	7 days	7 days	7 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.

Recommended Surface Profile

It is recommended a roughness profile between 1.97 and 2.95 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.

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).

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).

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: 1 A x 1 B.
Thinner	EPOXY DILUENT 3005
Dilution	Depending on the application method, dilute to a maximum of 20%.
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	3 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.

Induction Time

Wait 20 minutes before application.

In very hot locations, we recommend consulting WEG's Technical Department.

APPLICATION METHODS

Conventional Spray Gun

Spray gun: JGA 502/3 Devilbiss or equivalent
 Fluid nozzle: EX
 Air cap: 704
 Atomization pressure: 50 - 70 psi
 Tank pressure: 10 - 30 psi.

Airless Spray Gun

Airless: Use minimum pump 60:1
 Fluid pressure: 2000 - 2500 psi
 Hose: 1/4" inner diameter
 Nozzle: 0.015" - 0.021".
 Filter: mesh 60.

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 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.
 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.

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.

Light colors may require more than one coat to achieve uniform coverage.

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

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

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.

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.

Applying the product at relative humidity above 50% may accelerate drying and reduce mixture pot-life.

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

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.

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 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.

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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