

W-POXI CVE 355

PRODUCT DESCRIPTION: Low-thickness two-component aliphatic isocyanate epoxy shop primer. Adhesion primer for non-ferrous surfaces.

RECOMMENDED USES: Recommended as adhesion primer for electrolytically or hot-dip galvanized steel surfaces, copper, brass and non-ferrous substrates such as fiberglass. Widely used in tiles, pipes, structures and equipment, it can receive several types of optional topcoats, depending on the aggressiveness of the environment. It may also be used as a system converter.

CERTIFICATIONS AND APPROVAL: This product, when supplied to comply with the RoHs Directive (Restriction of Certain Hazardous Substances) has the letter R in its description.

PACKAGING:	Component	Content	Package	Unit of measurement
	Component A	3,5 19,45	3,6 20	L
	Component B	0,1 0,55	0,25 0,9	L

CHARACTERISTICS:

Color: Red oxide, Gray, Black, Yellow, White

Gloss: Ultra matte 0 – 15 UB

Volume solid: 19 ± 2% (ISO 3233).

Shelf-Life: 24 months at 25°C.

Thickness per coat (dry): 25 µm – 30 µm

Theoretical coverage: 7,6 m²/l without dilution in the thickness of 25 µm dry. Without considering loss factors in application.

Resistance to dry heat: Maximum temperature 100 °C . The product retains its physical and chemical properties up to the temperature of 100 °C however, variations in the coating color and gloss may occur from 60 °C.

Drying:

	10°C	25°C	35°C
Touch:	25 minutes	20 minutes	15 minutes
Handling:	2 hours	1 hour	40 minutes
Final:	192 hours	168 hours	144 hours

**Overcoating
Drying:**

	10°C	25°C	35°C
Min	8 hours	6 hours	4 hours
Max	72 hours	72 hours	72 hours

SURFACE PREPARATION The performance of this product depends on the degree of surface preparation.

The surface must be clean, dry and free of any contaminants. Completely remove oils, greases and fats, as described in the SSPC-SP 1 standard.

The accumulated dirt must be removed using a dry brush, clean and dry cloth, compressed air blow, vacuum cleaner and/or with the combination of such items, and the soluble salts must be removed through wash with a great quantity of fresh water, preferably with low pressure (up to 5,000 psi) according to SSPC-SP 12/NACE No. 5.

Surface treatment in Hot-Dip Galvanized parts

Wash the substrate with running water to remove the soluble salts from the galvanizing process before the blasting. Use non-woven synthetic fibers abrasive pad bonded with resin impregnated with abrasive

mineral in this process.

We recommend painting surfaces blast cleaned to Sa 1 (brush off) or according to SSPC-SP7, using grit mesh 20 to 40, controlling the operation to produce roughness only between 10 and 25 µm and surface matting. ISO 8501-1 visual standard.

Use non-metallic abrasives such as sintered bauxite, aluminum oxide, abrasive involved in sponge or other inert abrasive.

For the brush off process, the hot-dip galvanized carbon steel plates must have a minimum thickness of 3.0 mm and a minimum of 60 micrometers of galvanized layer.

For small areas, it is acceptable initially to remove the oil from the surface with clean cloths soaked in cleaning solvent according to SSPC SP1. Then execute a "light sanding" with sandpaper 100. Whenever possible, create criss-cross scratches (horizontal and vertical). Clean the surface again with cloths soaked in solvent and change them frequently. Whenever cleaning a surface with cloths, avoid the use of cotton waste or colored cloths.

Fiber Surface Treatment

Initially remove any dirt and oil from the surface with clean cloths soaked in cleaning solvent according to SSPC SP1. Whenever cleaning a surface with cloths, avoid the use of cotton waste or colored cloths.

Execute a "light sanding" with sandpaper 180 in order to promote roughness. Whenever possible, create criss-cross scratches (horizontal and vertical). Clean the surface again with cloths soaked in solvent and change them frequently.

Treatment of Steel Carbon Surfaces

Hard superficial layers (for example, layers resulting from flame cut) must be removed by grinding it before beginning the abrasive blasting.

All the welds must be inspected e, if necessary, be repaired before the ending of the abrasive blasting. Porosity, cavities, weld splashes, etc. must be repaired by means of proper mechanical treatment or weld repair; in the other areas, round the sharp edges ($r \geq 2$ mm, ISO 8501-3).

For further information, consult WEG Technical Department.

PREPARATION FOR APPLICATION

Mixture

Homogenize the contents of each component with mechanical or pneumatic stirring (A and B). Check there are no sediment settled at the bottom of the package. Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

Mixing ratio (Volume)

35 A X 1 B.

Diluent

Epoxy diluent 3005

Dilution

Depending on the application method, dilute at most. 5%

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended dilution percentage.

Only add the diluent after complete mixing of components A + B.

The quantity of diluent may vary depending on the type of equipment used and the ambient conditions during the application.

Excessive dilution of the coating may affect the formation and aspect of the film and not allow to reach the specified thickness.

Pot life of the mixture (25°C)

8 h

The pot life is reduced with a higher room temperature.

The pot-life test is performed according to the Brazilian standard ABNT NBR 15742; however, different volumes of coating prepared at once combined with different ambient and coating temperatures will influence the pot life, and different results than those mentioned in this data sheet may be found.

Induction time (25°C)

Wait 15 to 20 minutes before application.

In hot areas, we recommend consulting WEG Technical Department.

APPLICATION FORMS

The data below is a guide, and similar equipment may be used.

In the spray application, make a 50% overlap in each gun pass, concluding with a cross pass. This technique is used to avoid uncovered and unprotected areas and to obtain a suitable aesthetic finish.

Recoat all sharp edges, cracks and weld beads with a brush to prevent premature failures in these areas.

Changes in nozzle sizes and pressures may be necessary to improve spraying characteristics. Before application, check if the equipment and its components are clean and in best condition. Purge the compressed air line to prevent contamination of the coating.

After mixing two-component products, if there are stops in the application, and pot life is exceeded (the coating shows variation in fluidity) it can no longer be diluted for further application.

Conventional gun:

Gun:	JGA 502/3 Devilbiss or equivalent
Fluid nozzle:	EX
Air cap:	704
Atomization pressure:	50 - 70 psi
Pressure in the tank:	10 - 20 psi
Dilution:	5%

Airless Gun:

Use Airless:	Use at least pump 60: 1
Fluid pressure:	1500 - 2500 psi
Hose:	¼" internal diameter
Nozzle:	0,013" - 0,017"
Filter:	Mesh 60

Cleaning the equipment:

Epoxy diluent 3005
Clean all equipment immediately after use.

NOTE:

Do not leave catalyzed product in contact with the equipment used in the application, because the coating will vary in fluidity at temperatures above specified in the pot life and will cure faster, making the cleaning difficult.

Furthermore, it is a good working practice to periodically wash the spray equipment along the day. The cleaning frequency will depend on the amount sprayed, temperature and elapsed time, including all delays.

PERFORMANCE IN THE APPLICATION

For a good performance of the product, we recommend following the directions below:

Variations in color, aspect and gloss (more noticeable in dark colors) may occur, as well as delay in curing and low coating performance, when applied during periods of high air relative humidity, rainy days, low temperatures or drying the coating outdoor.

Epoxy-based products are known by having excellent anti-corrosion properties and low resistance to sunlight exposure. In situations of exposure of the film to the weather, over time it will present a loss of gloss known as chalking and its shade will change as a consequence. Remember that even undergoing such chalking, the film anti-corrosion protection is not impaired.

In paintings carried out in front of the sea, if exposed to sea air, we recommend to wash with fresh water between coats eliminating settled impurities.

The surface should be prepared as directed in the Surface Preparation field and according to the type of substrate.

It should not be applied in adverse conditions, such as air relative humidity above 85% or on condensed surfaces. Small variations in color, appearance and gloss of the coated parts may occur in periods of high air relative humidity, rainy days, at low temperatures or in situations where the coated parts are placed to dry outdoors.

Component B must be protected from ambient humidity. We recommend that, once opened, the product is completely used or as soon as possible.

The performance of the product depends on the reaching of the specified film thickness. Dry film

thickness above recommendation may result in adhesion failure.

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

We recommend coating only if the surface temperature is at least 3 °C above the dew point temperature.

Do not apply the product after the pot life has expired.

For better application properties, the coating temperature should be between 21 - 27 °C prior to the mixing and application.

In coatings with variation in application method in the same job, the final aspect and gloss of the painted surfaces may show differences.

The temperature of the substrate, the weather and environmental conditions during the application and during the curing of the product, and the thickness of the coat may interfere in the product drying time.

As this product is a Primer, there may be color variation between batches of this material.

NOTE: Suitable for application on aged epoxy and polyurethane systems that have excellent adhesion to the substrate.

For further information, consult WEG Technical Department.

COMPATIBILITY OF SYSTEMS AND MAINTENANCE REFINISHING

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.

To apply topcoat over the product, the overcoating interval should be observed. The surface must be dry and free of any contaminants.

For further information, consult WEG Technical Department.

SAFETY PRECAUTIONS

Product developed for industrial use intended for handling by qualified professionals.

Please read carefully all the information contained in the MSDS of this product, available at: www.weg.net.

Store in a covered, well-ventilated area. 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.

Wear protective gloves / protective clothing / eye protection / face protection.

Avoid release this product and its packaging, as well as materials used during handling and application in the environment.

NOTE:

The information contained in this technical datasheet is based upon the experience and knowledge acquired in the field by the technical team of WEG.

If using the product without previous inquiry to WEG Coating concerning its suitability for the customer's intended purpose, the customer is aware that the use shall be its exclusive responsibility, WEG not being responsible for behavior, safety, suitability or durability of the product.

Some information contained in this datasheet are estimated, and can undergo variances arising from factors outside the manufacturer's control. Thus, WEG does not guarantee and does not assume any responsibility regarding the yield, performance or any other material or personal damage resulting from the incorrect use of the products concerned or the information contained in this Technical datasheet.

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