

W-POXI STD 32

PRODUCT DESCRIPTION

Two-component polyamine epoxy primer/finish with high solids content and high-build. Tolerant to surfaces: applicable on steel substrates treated by dry, wet, hydroblasting, and manual or mechanical treatment. Can be used as system converter. Excellent anticorrosive protection in aggressive environments.

RECOMMENDED USE

Ships, maritime structures, and offshore: new constructions: external painting of tanks, decks, oil exploration platforms, onboard machinery. Maintenance: internal painting of ballast and fuel tanks. Industrial applications: pulp and paper, chemical and petrochemical, bridges, metal structures, and various machinery, 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

Component A	20L Package containing 17.15L
Component B	3.6L Package containing 2.85L

CHARACTERISTICS

Color	Red Oxide.
Gloss	Semi-Matte Satin
VOC content	440.27 g/l
Volume Solids	83 ± 2% (ISO 3233)
Shelf Life	24 months
Dry Film Thickness	150 µm - 300 µm
Dry Heat Resistance	Maximum temperature 120 °C. The product maintains its chemical properties up to a temperature of 120 °C, but from 60°C, color and gloss variations in the paint may occur.
Theoretical Coverage	3,69 m ² /l without dilution at a dry film thickness of 225 µm. Loss factors during application are not considered.

DRYING

Drying

	10 °C	25 °C	35 °C
Touch	6 hours	3 hours	2 hours
Manipulation	24 hours	18 hours	6 hours
Final	240 hours	168 hours	144 hours

Recoat Drying

	10 °C	25 °C	35 °C
Minimum	24 hours	8 hours	6 hours
Maximum	35 days	30 days	10 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 50 and 75 micrometers.

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.

Water Jetting

It is recommended to paint on hydroblasted surfaces to CWJ-2 grade according to SSPC-VIS 4. The product can be applied on surfaces with light flash rust, grade CWJ-2L.

Hand and Power Tool Cleaning

It can be used on parts with oxidation grades C or D, according to ISO 8501-1 visual standards.

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).

Over Aged Coating

For aged paint with good adhesion, perform light sanding to break gloss and clean dust/residues, ensuring better adhesion between coats.

It is acceptable to adopt less stringent preparation standards as long as contaminant absence is ensured via high-pressure fresh water cleaning (5,000-10,000 psi) according to SSPC-SP12/NACE No.5. In case of doubt, consult the technical area.

Intact Zinc Silicate Shop Primers must be prepared with light blasting. Epoxy Iron Oxide Shop Primers must be clean and dry before application.

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

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: 6 A x 1 B.
Thinner	EPOXY DILUENT 3005
Dilution	Depending on the application method, dilute to a maximum of 10%.
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. Only add the diluent after completely mixing components



	A and B.
Pot Life	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.
Induction Time	Wait 15 to 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: 60 - 65 psi Tank pressure: 10 - 20 psi.
Airless Spray Gun	Airless: Use minimum pump 60:1 Fluid pressure: 2500 - 3500 psi Hose: 1/4" inner diameter Nozzle: 0.017" - 0.025".
Roller	Use a short-haired, seamless wool or synthetic roller for epoxy paints. Recommended only for small areas or touch-ups. Use a low-pile seamless wool roller or synthetic roller for epoxy paints. Not recommended for internal tank painting. 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. 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.

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.



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 should be between 21°C and 27°C before mixing and application.

During curing, if the applied parts are exposed to low temperatures and/or high humidity, exudation may occur on the film, which should be removed with fresh water or cloth moistened with appropriate Diluent. This does not affect the quality or corrosion resistance of the film.

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.

Must not be applied under adverse conditions, such as relative humidity (RH) above 85%, as color and appearance changes may occur.

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.

SYSTEM COMPATIBILITY AND MAINTENANCE REPAINTING

The product WEGPOXI STD 323 can be applied over aged coatings or other paint systems. However, it is advisable to test the compatibility of WEGPOXI STD 323 with the previous coating on a small test area. A light sanding to remove gloss is recommended to ensure better product performance. It must be ensured that the original material is well adhered. All loose paint must be removed. Areas with corrosion or aged coatings should be treated according to technical instructions.

When applying topcoats over WEGPOXI STD 323, the overcoating interval must be respected. The surface must be dry and free from contaminants.

If no topcoat is to be applied over WEGPOXI STD 323, two coats of this product may be applied to the appropriate film thickness.

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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