



**LACKPOXI 76 WET SURFACE FINIS N2680**

**PRODUCT DESCRIPTION**

High-build, solvent-free polyamide epoxy primer, intermediate and finish, formulated with non-toxic anticorrosive pigments for carbon steel surfaces. Product developed for application on surfaces prepared by abrasive blasting and hydroblasting. This material can be applied on wet surfaces.

**RECOMMENDED USE**

Suitable for immersion work in salt water at temperatures up to 140°F.

Ships, maritime structures, and offshore: ballast and fuel tanks, decks, oil and natural gas exploration platforms, onboard machinery, pipelines, etc.

Industrial applications: bridges, metal structures, and various machinery.

Pipes: can be applied inside and outside of pipelines.

**CERTIFICATIONS AND APPROVALS**

Pre-qualified according to Norsok M-501, Edition 5, System 7.

Pre-qualified according to Norsok M-501, Edition 5, System 1.

Complies with Petrobras Standard N 2680.

Certified in category C3H of ISO 12944:2018 when applied at 4.72 mil and combined with LACKPOXI N2677 at 2.36 mil.

Meets the requirements of ANVISA Resolution No. 105 for contact with non-acidic aqueous foods, alcoholic foods, fatty foods, and dry foods.

Complies with IMO Resolution MSC.215 (82) for ballast tank coatings, in accordance with certifications by DNV and RMRS.

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>	0.95 US gal Package containing 0.71 US gal 5.28 US gal Package containing 3.96 US gal
<b>Component B</b>	0.24 US gal Package containing 0.24 US gal 1.32 US gal Package containing 1.32 US gal
<b>Component B II</b>	0.24 US gal Package containing 0.24 US gal 1.32 US gal Package containing 1.32 US gal

**CHARACTERISTICS**

<b>Color</b>	Gray. Red Oxide. According to customer standard. RAL and Munsell chart.
<b>Gloss</b>	Gloss
<b>VOC content</b>	0.1 - 1.0 (lb/gal). Note: The average of VOC on the line can vary depending on the color.
<b>Volume Solids</b>	SOLVENT-FREE
<b>Flash Point</b>	60 °C
<b>Shelf Life</b>	24 months
<b>Dry Film Thickness</b>	3.9 mils - 5.9 mils
<b>Dry Heat Resistance</b>	Maximum temperature 248 °F. The product maintains its chemical properties up to a temperature of 248 °F, but from 140°F, color and gloss



variations in the paint may occur.

**Theoretical Coverage** 271.8 ft<sup>2</sup>/gal without dilution at a dry film thickness of 5.9 mils. Loss factors during application are not considered.

**Specific Gravity** Min: 1.25 Max: 1.35 g/cm<sup>3</sup>

**DRYING**

**Drying**

	59 °F	68 °F	77 °F	86 °F	104 °F
<b>Toque</b>	14 hours	9 hours	6 hours	5 hours	4 hours
<b>Manuseio</b>	30 hours	20 hours	16 hours	15 hours	12 hours
<b>Final</b>	10 days	8 days	7 days	7 days	7 days
<b>Pot life</b>	5 hours	4 hours	3 hours	2 hours	90 min

**Drying with Winter Component B**

	41 °F	50 °F	59 °F	68 °F	77 °F	86 °F	104 °F
<b>Toque</b>	24 hours	12 hours	8 hours	4 hours	2 hours	90 min	45 min
<b>Manuseio</b>	48 hours	30 hours	14 hours	9 hours	6 hours	5 hours	4 hours
<b>Final</b>	15 days	12 days	10 days	7 days	7 days	7 days	7 days
<b>Pot life</b>	3 hours	2 hours	90 min	1 hour	40 min		15 min

**Recoat Drying with Winter Component B**

	41 °F	50 °F	59 °F	68 °F	77 °F	86 °F	104 °F
<b>Minima</b>	48 hours	30 hours	14 hours	8 hours	4 hours	4 hours	3 hours
<b>Maxima</b>	8 days	7 days	4 days	3 days	3 days	3 days	2 days

**Topcoat Recoat Drying**

	50 °F	77 °F	95 °F
<b>Minima</b>	6 hours	4 hours	3 hours
<b>Maxima</b>	20 hours	16 hours	12 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.

**Recommended Surface Profile**

It is recommended a roughness profile between 1.57 and 3.35 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/cm<sup>2</sup> (2 ¼g/cm<sup>2</sup>) 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.

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).

Mechanically treat the surface until achieving at least St 3 grade according to ISO 8501-1 visual standard or SSPC-SP 11, using SSPC-VIS 3 visual standard as guidance.

**Maintenance and Repair**

Corrosion spots, worn, or damaged areas must be prepared by commercial abrasive blasting, Sa 2 grade of ISO 8501-1 visual standard or according to SSPC-SP 6/NACE No. 3, visual standard SSPC-VIS 1. If not possible, rotary mechanical tools can be used according to SSPC-SP 11.

**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).

**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 recommended to test the paint on a small area to check compatibility and ensure aged paint is well adhered. Loose or poorly adhered paints must be removed. Repainting should be done only on well-preserved surfaces.

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.

Remove all contaminants from the existing paint. Areas where the film is not adhered must be removed with light blasting grade Sa 1 (brush off) or according to SSPC-SP7, ISO 8501-1 visual standard. Corrosion points, worn, or damaged areas must be prepared by commercial abrasive blasting grade Sa 2, ISO 8501-1 standard or SSPC-SP6/NACE No.3, SSPC-VIS 1 standard. If not possible, use rotary-mechanical tools according to SSPC-SP 11.

For intact and well-preserved Inorganic Zinc Silicate Shop Primers, prepare only with a nylon brush or low-pressure fresh water washing (up to 5,000 psi), according to SSPC-SP12/NACE No.5.

**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: 3 A x 1 B.
<b>Thinner</b>	Not applicable.
<b>Dilution</b>	Ready to use.
<b>Notes</b>	In very hot locations, we recommend consulting the WEG Technical Department.



<b>Pot Life</b>	3 h
	<p>The shelf life of the mixture is reduced as the ambient temperature increases.</p> <p>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.</p>
<b>Induction Time</b>	No induction time required.
	In very hot locations, we recommend consulting WEG's Technical Department.

**APPLICATION METHODS**

<b>Airless Spray Gun</b>	<p>Airless: Use minimum pump 60:1                  Fluid pressure: 2700 - 3000 psi                  Hose: 3/8" inner diameter                  Nozzle: 0.017" - 0.025".</p>
<b>Roller</b>	<p>Use a short-haired, seamless wool 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.</p>
<b>Brush</b>	<p>Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).                  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.</p>
<b>Cleaning of the equipments:</b>	Not applicable.
<b>Notes</b>	<p>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.                  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.</p>

**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.



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

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

We recommend painting only if the measured surface temperature is at least 5.4°F above the dew point and maximum temperature of 125.6°F.

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).

Regardless of the preparation type, the product's moisture tolerance allows surface washing with fresh water immediately before painting, minimizing salt content.

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.

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 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](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.

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.

