



W-POXI FAST DRY 33

PRODUCT DESCRIPTION

High-solids epoxy primer formulated with anticorrosive pigments, two-component and fast-drying. High-performance coating for industrial and marine use, applicable above and below the waterline in one or two high-build coats

RECOMMENDED USE

Recommended for new constructions, maintenance, and repair of metal structures, external surfaces of tanks, piping, vessels, and various equipment. For aggressive environments or water immersion, the application of two coats is recommended.

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	0.95 US gal Package containing 0.63 US gal
Component B	0.40 US gal Package containing 0.32 US gal

CHARACTERISTICS

Color	White. Gray. Red Oxide.
Gloss	Semi-Gloss
Volume Solids	74 ± 2% (ISO 3233)
Dry Film Thickness	3.9 mils - 9.8 mils
Dry Heat Resistance	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	301.6 ft ² /gal without dilution at a dry film thickness of 3.9 mils. Loss factors during application are not considered.

DRYING

Drying	<hr/>		
	41 °F	77 °F	95 °F
Touch	90 min	30 min	15 min
Pressure	6 hours 30 min	2 hours	90 min
Final	336 hours	168 hours	168 hours
Recoat Drying	<hr/>		
	41 °F	77 °F	95 °F
Minimum	2 hours	1 hour	30 min
Maximum	28 days	28 days	15 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.

Accumulated dirt must be removed using a dry brush, and soluble salts must be removed by washing with fresh water under high pressure.

The performance of this product is directly related to the degree of surface preparation. Completely remove oils, grease, and other contaminants by applying a suitable degreasing product or according to the solvent cleaning method described in SSPC-SP1.

For new constructions, it is necessary to treat weld spatters and seams, damaged areas, edges, and sharp corners by abrasive blasting to Sa 2½ or SSPC-SP10 standard, according to the visual



reference ISO 8501-1.

Recommended Surface Profile

It is recommended a roughness profile between 1.57 and 3.35 mils.

Abrasive Blasting

For immersion services, it is recommended to paint on surfaces blasted to Sa 2½ grade or according to SSPC-SP10, visual standard ISO 8501-1.

For bottom, boot-top, and hull areas, it is recommended to paint on surfaces blasted to Sa 2½ or SSPC-SP10. Visual standard ISO 8501-1.

Evaluate the surface after blasting, observing revealed defects and adopt practices to minimize them, such as grinding or filling.

We recommend carrying out the painting on surfaces previously washed with fresh water under high pressure, with a minimum pressure of 3,000 psi. After washing, a light abrasive blasting should be performed to achieve surface cleanliness corresponding to standard Sa 2 (according to ISO 8501-1) or SSPC-SP6.

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

Respect the product's recoating interval for subsequent coat application. If exceeded, perform light manual/mechanical sanding to break the previous coat gloss, followed by dust and residue cleaning to ensure better adhesion between paint layers.

Only upon request.

Over Aged Coating

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

This product is also intended for application over aged coatings that are intact and firmly adhered. Loose or poorly adhered coatings must be removed down to a sound surface. It is recommended to dull the existing coating by sanding to improve intercoat adhesion, then clean the surface as described above and remove all sanding dust.

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: 3 A x 1 B.
Thinner	EPOXY DILUENT 3005
Alternative Thinners	EPOXY THINNER 3025 EXP
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	2 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

No induction time required.

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

APPLICATION METHODS

Conventional Spray Gun

Spray gun: JGA 502 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: 2400 psi
 Hose: 1/4" inner diameter
 Nozzle: 0.013" - 0.017".

Roller

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.
 Use wool or synthetic rollers.

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

Equipment cleaning with alternative thinner:
 DILUENT EPOXI 3025 EXP
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 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.
 Do not leave material in hoses, guns, or equipment used for spraying. Thoroughly wash all used equipment.

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.

Proper washing and degreasing of the surface are essential, as well as sanding of old paints whenever necessary to promote adhesion.

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

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



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

Surface preparation is recommended to Sa 2½ or SSPC SP10 (ISO 8501-1 visual standard). Less stringent standards are acceptable as long as there are no contaminants, supplemented with high-pressure water cleaning.

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.

When applying by brush or roller, two or more coats may be necessary to achieve a uniform layer and recommended film thickness.

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

On freshly painted surfaces in direct contact with water during the curing process, localized staining with color change (more visible in darker colors), curing delay, and compromised product performance may occur.

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.

COMPATIBILITY

Proper cleaning and degreasing of the surface are essential before applying the topcoat. When applying topcoats over W-POXI DRY FAST 334, the recommended recoat interval must be observed. If no topcoat is applied over W-POXI DRY FAST 334, the product may be applied in two coats, with an approximate dry film thickness of 150 micrometers per coat.

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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