



**W-POXI 122 ITAIPU**

**PRODUCT DESCRIPTION**

Zinc-rich two-component polyamide epoxy primer. Provides anticorrosive protection to carbon steel via galvanic action of zinc metallic pigment. Excellent adhesion to abrasive-blasted carbon steel.

**RECOMMENDED USE**

Indicated as an anticorrosive primer for structures and equipment subjected to highly aggressive environments.

**CERTIFICATIONS AND APPROVALS**

Complies with Petrobras Standard N 1277.

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 0.79 US gal

**Component B** 0.24 US gal Package containing 0.16 US gal

**CHARACTERISTICS**

|                             |  |
|-----------------------------|--|
| <b>Color</b>                | Gray.  |
| <b>Gloss</b>                | Matte  |
| <b>VOC content</b>          | 9.81 lb/gal  |
| <b>Volume Solids</b>        | 61 ± 2% (ISO 3233)   |
| <b>Shelf Life</b>           | 12 months  |
| <b>Dry Film Thickness</b>   | 2.4 mils - 2.8 mils  |
| <b>Dry Heat Resistance</b>  | Maximum temperature 248 °F.<br>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. |
| <b>Theoretical Coverage</b> | 382.2 ft <sup>2</sup> /gal without dilution at a dry film thickness of 2.6 mils. Loss factors during application are not considered.   |

**DRYING**

**Drying**

|                     | 50 °F     | 77 °F     | 95 °F     |
|---------------------|-----------|-----------|-----------|
| <b>Touch</b>        | 1 hour    | 30 min    | 15 min    |
| <b>Manipulation</b> | 8 hours   | 5 hours   | 3 hours   |
| <b>Final</b>        | 168 hours | 120 hours | 120 hours |

**Recoat Drying**

|                | 50 °F    | 77 °F    | 95 °F    |
|----------------|----------|----------|----------|
| <b>Minimum</b> | 8 hours  | 5 hours  | 3 hours  |
| <b>Maximum</b> | 36 hours | 24 hours | 18 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.



**Degreasing**

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

**Maintenance and Repair**

NOTE: Respect the 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.

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**APPLICATION PREPARATION**

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| <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: 5 A x 1 B.  |
| <b>Thinner</b>              | DILUENT SL 30  |
| <b>Alternative Thinners</b> | Diluent SL 42 - For temperatures below 77°F.<br>Diluent SL 30 - For temperatures above 95°F.<br>Epoxy Thinner 3005 - For temperatures between 77-95°F.   |
| <b>Dilution</b>             | Depending on the application method, dilute to a maximum of 10%.   |
| <b>Notes</b>                | 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. |
| <b>Pot Life</b>             | 2 h<br><br>The shelf life of the mixture is reduced as the ambient temperature increases.<br><br>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.      |
| <b>Induction Time</b>       | Wait 15 to 20 minutes before application.<br><br>In very hot locations, we recommend consulting WEG's Technical Department.  |

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**APPLICATION METHODS**

|                               |  |
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| <b>Conventional Spray Gun</b> | Spray gun: JGA 502/3 Devilbiss or equivalent<br>Fluid nozzle: EX<br>Air cap: 704<br>Atomization pressure: 50 - 70 psi<br>Tank pressure: 10 - 20 psi.                             |
| <b>Airless Spray Gun</b>      | Airless: Use minimum pump 60:1<br>Fluid pressure: 2000 - 3000 psi<br>Hose: 1/4" inner diameter<br>Nozzle: 0.015" - 0.021".   |
| <b>Flooding</b>               | Application viscosity varies according to ambient temperature and equipment height.  |
| <b>Roller</b>                 | Use a short-haired, seamless wool or synthetic roller for epoxy paints.<br>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.  |
| <b>Brush</b>                       | Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).<br>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.  |
| <b>Cleaning of the equipments:</b> | DILUENT SL 30  |
| <b>Notes</b>                       | The data presented serves as a guide and similar equipment may be used.<br>Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination.<br>Before application, ensure that the equipment and respective components are clean and in optimal condition.<br>Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.<br>Clean all equipment immediately after use.<br>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.

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.

During the initial curing (first 24 hours), humidity must not exceed 70%, otherwise the visual appearance may be compromised.

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

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.

Epoxy systems may have longer curing times when exposed to low temperatures.  
For curing below 50°F, consult WEG Technical Department.

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.

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.

**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.

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**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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