



W-POXI WZP 31

PRODUCT DESCRIPTION

Two-component zinc-rich polyamide epoxy primer. Provides anticorrosive protection to carbon steel. Fast-drying, increasing productivity.

RECOMMENDED USE

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

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 0.76 US gal
Component B	0.24 US gal Package containing 0.19 US gal

CHARACTERISTICS

Color	Gray.
Gloss	Matte
VOC content	8.33 lb/gal
Volume Solids	70 ± 2% (ISO 3233)
Shelf Life	12 months
Dry Film Thickness	2.0 mils - 3.0 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	456.4 ft²/gal without dilution at a dry film thickness of 2.5 mils. Loss factors during application are not considered.

DRYING

Drying	<hr/>		
	50 °F	77 °F	95 °F
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	Touch	3 hours	1 hour
Manipulation	12 hours	5 hours	2 hours
	Final	240 hours	168 hours
Recoat Drying	<hr/>		
	50 °F	77 °F	95 °F
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	Minimum	6 hours	3 hours
Maximum	30 days	30 days	30 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.

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.

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.

APPLICATION PREPARATION

Mixing	<p>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.</p> <p>Application must only be carried out with equipment that provides mechanical agitation during the entire application.</p> <p>Then pass the mixture through an 80-100 mesh sieve.</p>
Mixing Ratio	By volume: 4 A x 1 B.
Thinner	EPOXY DILUENT 3005
Dilution	Depending on the application method, dilute to a maximum of 10%.
Notes	<p>Dilute according to recommendation.</p> <p>Only add the thinner after the A + B components are completely mixed.</p> <p>Excessive thinning of the paint may affect film formation, appearance, and make it difficult to achieve the specified thickness.</p> <p>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.</p>
Pot Life	<p>4 h</p> <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>

APPLICATION METHODS

Conventional Spray Gun	<p>Spray gun: JGA 502/3 Devilbiss or equivalent</p> <p>Fluid nozzle: EX</p> <p>Air cap: 704</p> <p>Atomization pressure: 60 - 65 psi</p> <p>Tank pressure: 10 - 20 psi.</p>
Airless Spray Gun	<p>Airless: Use minimum pump 60:1</p> <p>Fluid pressure: 2700 - 3000 psi</p> <p>Hose: 1/4" inner diameter</p> <p>Nozzle: 0.019" - 0.023".</p> <p>Filter: mesh 60.</p>
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.
 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.
 Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.

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.

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.

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.

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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