



W-POXI HPP 34 EXP

**PRODUCT DESCRIPTION**

Polyamide-amine epoxy primer, formulated with anticorrosive pigments, two-component, fast-drying, and tar-free. High-performance coating for industrial and marine use, applicable above and below the waterline, in one or two thick coats.

**RECOMMENDED USE**

Recommended for maintenance and repair of vessels and painting of metal structures and pipelines. For aggressive environments or immersion in water, the use 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**

<b>Component A</b>	0.95 US gal Package containing 0.95 US gal 5.28 US gal Package containing 5.28 US gal
<b>Component B</b>	0.95 US gal Package containing 0.95 US gal 5.28 US gal Package containing 5.28 US gal

**CHARACTERISTICS**

<b>Color</b>	White. Gray. Red Oxide.
<b>Gloss</b>	Ultra-Matte
<b>Volume Solids</b>	80 ± 2% (ISO 3233)
<b>Shelf Life</b>	24 months
<b>Dry Film Thickness</b>	3.9 mils - 7.9 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.
<b>Theoretical Coverage</b>	217.2 ft <sup>2</sup> /gal without dilution at a dry film thickness of 5.9 mils. Loss factors during application are not considered.

**DRYING**

<b>Drying</b>			
	<b>41 °F</b>	<b>77 °F</b>	<b>95 °F</b>
<b>Touch</b>	4 hours	3 hours	90 min
<b>Pressure</b>	40 hours	6 hours	4 hours
<b>Final</b>	336 hours	168 hours	168 hours
<b>Recoat Drying</b>			
	<b>41 °F</b>	<b>77 °F</b>	<b>95 °F</b>
<b>Minimum</b>	18 hours	6 hours	4 hours
<b>Maximum</b>	90 days	90 days	90 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.

The surface must be clean, dry, and free of any contaminants. Remove oils, greases, and fats



according to SSPC-SP1 standard.

**Recommended Surface Profile**

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

**Abrasive Blasting**

Perform surface preparation with 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.

Inspect the freshly blasted surface, observing defects that may appear after treatment. Correct them by grinding, filling with welds and/or epoxy putty.

**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**

The surface treatment in question must not be used in applications subject to continuous or intermittent immersion.

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, use manual or mechanical cleaning to St 2 grade according to SSPC-SP2, ISO 8501-1 visual standard.

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.

**Over Aged Coating**

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

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**

<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: 1 A x 1 B.
<b>Thinner</b>	EPOXY DILUENT 3005
<b>Dilution</b>	Depending on the application method, dilute to a



	maximum of 5%.
<b>Notes</b>	<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> <p>Only add the diluent after completely mixing components A and B.</p>
<b>Pot Life</b>	<p>5 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>
<b>Induction Time</b>	<p>No induction time required.</p> <p>In very hot locations, we recommend consulting WEG's Technical Department.</p>

**APPLICATION METHODS**

<b>Conventional Spray Gun</b>	<p>Spray gun: JGA 502/3 Devilbiss or equivalent                  Fluid nozzle: EX                  Air cap: 704                  Atomization pressure: 60 - 65 psi                  Tank pressure: 10 - 20 psi.</p>
<b>Airless Spray Gun</b>	<p>Use minimum pump 60:1                  Fluid pressure: 2400 psi                  Hose: 1/4" inner diameter                  Nozzle: 0.021" - 0.027".</p>
<b>Roller</b>	<p>Recommended only for small areas or touch-ups. Use a low-pile seamless wool roller or synthetic roller for epoxy paints.</p> <p>Not recommended for internal tank painting.</p> <p>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).</p> <p>Use a brush 3.0 to 3.94 inches wide for larger surfaces and 0.98 to 1.5 inches for touch-ups.</p>
<b>Cleaning of the equipments:</b>	EPOXY DILUENT 3005
<b>Notes</b>	<p>The data presented serves as a guide and similar equipment may be used.</p> <p>Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination.</p> <p>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.</p> <p>Before application, ensure that the equipment and respective components are clean and in optimal condition.</p> <p>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.</p> <p>In spray application, overlap each gun pass by 50%,</p>



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.

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.

**APPLICATION PERFORMANCE**

The product must be applied within the recoat interval specified in the technical data sheet.

For coatings applied in coastal areas exposed to sea spray, it is recommended to wash with fresh water between coats to remove deposited impurities.

As this is a primer, color variation between batches of this material may occur.

Before application, observe weather conditions: there must be no threat of rain or drizzle. Surface temperature must be at least 37,4°F above the dew point, and relative humidity should not exceed 85%. Adverse conditions may cause color variations and other characteristics. Consult WEG Technical Department.

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-based products are well known for their excellent corrosion-resistant properties, although they have limited resistance to sunlight. When the applied coating is exposed to weathering, it may gradually lose its gloss, a phenomenon known as chalking, which can also cause a slight change in color. It is important to note that this chalking does not compromise the coating's corrosion protection.

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

Under adverse weather conditions in indoor and/or outdoor environments with high relative humidity, rain or drizzle, low or very low temperatures, and excessively high temperatures, variations in color and other product characteristics may occur. Please consult WEG's Technical Department for more information.

**SYSTEM COMPATIBILITY AND MAINTENANCE REPAINTING**

The primer repainting interval must be respected for the application of the topcoat. If the maximum interval indicated is exceeded, manual/mechanical sanding with sandpaper to remove gloss is necessary. The primer surface must be dry and free of contaminants.

If no topcoat is applied over the product, two coats of this product may be applied at the appropriate 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](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.

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