



WEG FENOXI S

PRODUCT DESCRIPTION

High-build phenolic epoxy primer/finish, two-component, with excellent chemical resistance, including various solvents, and excellent corrosion and abrasion resistance.

RECOMMENDED USE

Indicated for electrostatic painting, with resistivity from 400 to 800 kΩ.

Indicated for highly aggressive environments, providing excellent anticorrosive protection on steel. Highly recommended for internal and external painting of tanks and pipelines, where chemical resistance is a key requirement.

CERTIFICATIONS AND APPROVALS

Meets the requirements of ANVISA Resolution No. 105 for contact with aqueous and alcoholic foods.

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 0.71 US gal 5.28 US gal Package containing 3.96 US gal
Component B	0.13 US gal Package containing 0.13 US gal 0.24 US gal Package containing 0.24 US gal

CHARACTERISTICS

Color	Blue. White. Gray. Red Oxide.
Gloss	Semi-Gloss
VOC content	3.0 - 4.2 (lb/gal). Note: The average of VOC on the line can vary depending on the color.
Volume Solids	76 ± 2% (ISO 3233)
Shelf Life	12 months
Dry Film Thickness	3.1 mils - 6.3 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	257.9 ft ² /gal without dilution at a dry film thickness of 4.7 mils. Loss factors during application are not considered.

DRYING

Drying	<table border="0" style="width: 100%; text-align: center;"> <tr> <td>50 °F</td> <td>77 °F</td> <td>95 °F</td> </tr> </table>			50 °F	77 °F	95 °F
50 °F	77 °F	95 °F				
Touch	9 hours	3 hours	2 hours			
Manipulation	24 hours	4 hours	5 hours			
Final	336 hours	168 hours	144 hours			
Recoat Drying	<table border="0" style="width: 100%; text-align: center;"> <tr> <td>50 °F</td> <td>77 °F</td> <td>95 °F</td> </tr> </table>			50 °F	77 °F	95 °F
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Minimum	24 hours	5 hours	4 hours			
Maximum	21 days	20 days	14 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.

The surface must be clean, dry, and free of contaminants. Completely remove oils, greases, and fats according to SSPC-SP1.

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 internal tank protection, it is recommended to perform the soluble salts test according to ISO 8502-6 on the surface before painting.

The permitted level of soluble salts is a maximum of 20 mg/cm² (1.29 x 10⁻⁴ oz/in²), according to ISO 8502-9.

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

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.

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.

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

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	EPOXI DILUENT 3024
Dilution	Depending on the application method, dilute to a maximum of 5%.
Notes	Dilution is recommended only under special circumstances, depending on the application method. 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.

APPLICATION METHODS

Conventional Spray Gun	Spray gun: JGA 502/3 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: 2500 - 3500 psi Hose: 1/4" inner diameter Nozzle: 0.019" - 0.023". Filter: mesh 60.
Roller	Use a short-haired, seamless wool or synthetic roller for epoxy paints. Recommended only for small areas or touch-ups. Use a low-pile seamless wool roller or synthetic roller for epoxy paints.
Brush	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.
Cleaning of the equipments:	EPOXI DILUENT 3024
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. 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. Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas. Clean all equipment immediately after use.

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.

We recommend painting only if the measured surface temperature is at least 5.4°F above the dew point.
 Do not apply at steel temperatures below 50°F.

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.

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.

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.

Information on repainting is provided as guidance and is subject to regional variations depending on local climatic conditions. For specific situations, consult WEG.

WEG FENÓXI S is generally applied at a total thickness of 6.30 mils, 3.15 mils per coat.

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

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.

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.

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.
