

## W-POXI HYDRO TFP 33

### PRODUCT DESCRIPTION

Two-component water-soluble polyamine epoxy primer/finish with anticorrosive pigmentation and fast drying. Excellent adhesion on carbon steel.

### RECOMMENDED USE

Recommended for painting metal structures, exterior of tanks, pipelines, electrical equipment, silos, and various equipment, whether new or maintenance, in pulp and paper, sugar ethanol, chemical and petrochemical industries, among others.

### 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 0.76 US gal |
| <b>Component B</b> | 0.24 US gal Package containing 0.19 US gal |

### CHARACTERISTICS

|                             |                                                                                                                                                                                |
|-----------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Color</b>                | According to customer standard.<br>RAL and Munsell chart.                                                                                                                      |
| <b>Gloss</b>                | Matte                                                                                                                                                                          |
| <b>VOC content</b>          | 0.76 lb/gal                                                                                                                                                                    |
| <b>Volume Solids</b>        | 53 ± 2% (ISO 3233)                                                                                                                                                             |
| <b>Shelf Life</b>           | 6 months                                                                                                                                                                       |
| <b>Dry Film Thickness</b>   | 3.9 mils - 5.9 mils                                                                                                                                                            |
| <b>Dry Heat Resistance</b>  | Maximum temperature 176 °F.<br>The product maintains its chemical properties up to a temperature of 176 °F, but from 140°F, color and gloss variations in the paint may occur. |
| <b>Theoretical Coverage</b> | 172.8 ft <sup>2</sup> /gal without dilution at a dry film thickness of 4.9 mils. Loss factors during application are not considered.                                           |

### DRYING

#### Drying

|                     | 50 °F     | 77 °F     | 95 °F     |
|---------------------|-----------|-----------|-----------|
| <b>Touch</b>        | 3 hours   | 1 hour    | 1 hour    |
| <b>Manipulation</b> | 6 hours   | 4 hours   | 3 hours   |
| <b>Final</b>        | 240 hours | 240 hours | 168 hours |

#### Recoat Drying

|                | 50 °F    | 77 °F    | 95 °F    |
|----------------|----------|----------|----------|
| <b>Minimum</b> | 6 hours  | 4 hours  | 3 hours  |
| <b>Maximum</b> | 24 hours | 24 hours | 24 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.

Completely remove oils and greases by applying a degreasing product or according to the solvent cleaning method. Whenever cleaning surfaces with cloths, replace them to avoid saturation. Do not use cotton waste or colored cloths.

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

### 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.

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

### 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: 4 A x 1 B.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |
| <b>Thinner</b>        | WATER                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |
| <b>Dilution</b>       | Depending on the application method, dilute to a maximum of 20%.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |
| <b>Notes</b>          | <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> |
| <b>Pot Life</b>       | <p>2 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</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> |
| <b>Airless Spray Gun</b>      | <p>Airless: Use minimum pump 60:1</p> <p>Fluid pressure: 2000 - 3000 psi</p> <p>Hose: 1/4" inner diameter</p> <p>Nozzle: 0.015" - 0.021".</p>                               |



|                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |
|------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Roller</b>                      | <p>Use a short-haired, seamless wool or synthetic roller for epoxy paints.</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>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> <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> | WATER                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |
| <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>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>Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.</p> <p>Clean all equipment immediately after use.</p> |

## APPLICATION PERFORMANCE

Light colors may require more than one coat to achieve uniform coverage.

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

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.

Do not apply under adverse conditions, such as RH above 70% or on condensed surfaces. Small variations in color, appearance, and gloss may occur during high humidity, rainy days, cold locations, or when parts dry outdoors.

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

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.

## 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.