

## W-THERM CVD 823 R CINZA

|                                     |   |
|-------------------------------------|---|
| <b>PRODUCT DESCRIPTION:</b>         | Primer Two component finish providing excellent protection under thermal insulation when used in cryogenic equipment with temperatures up to -196°C up to 500°C, formulated with a multipolymer matrix. |
| <b>RECOMMENDED USES:</b>            | Indicated to prevent corrosion of carbon steel under thermal insulation, it can be applied on surfaces heated up to 260°C. Using outside pipes that operate from -196 to 500°C.                         |
| <b>CERTIFICATIONS AND APPROVAL:</b> | This product, when supplied to comply with the RoHs Directive (Restriction of Certain Hazardous Substances) has the letter R in its description.  |

| PACKAGING: | Component   | Content | Package | Unit of measurement |
|------------|-------------|---------|---------|---------------------|
|            | Component A | 18,4    | 20      | L                   |
|            | Component B | 1,6     | 1,5     | L                   |

|                         |                                  |   |
|-------------------------|----------------------------------|---|
| <b>CHARACTERISTICS:</b> | <b>Color:</b>                    | Gray  |
|                         | <b>Gloss:</b>                    | Semi matte  |
|                         | <b>VOC content:</b>              | 375 g/l   |
|                         | <b>Volume solid:</b>             | 54 ± 2% (ISO 3233).   |
|                         | <b>Shelf-Life:</b>               | 12 months at 25°C. (77°F)   |
|                         | <b>Thickness per coat (dry):</b> | 125 µm –150 µm  |
|                         | <b>Theoretical coverage:</b>     | 4,3 m <sup>2</sup> /l without dilution in the thickness of 125 µm dry. Without considering loss factors in application. |

### Drying:

|                       | 10°C (50°F) | 25°C (77°F) | 35°C (95°F) |
|-----------------------|-------------|-------------|-------------|
| <b>Touch:</b>         | 30 minutes  | 20 minutes  | 15 minutes  |
| <b>Handling:</b>      | 90 minutes  | 60 minutes  | 40 minutes  |
| <b>For operation:</b> | 24 hours    | 24 hours    | 24 hours    |

### Overcoating Drying:

|     | 10°C (50°F) | 25°C (77°F) | 35°C (95°F) |
|-----|-------------|-------------|-------------|
| Min | 3 hours     | 2 hours     | 1 hour      |
| Max | -           | -           | -           |

### SURFACE PREPARATION

The performance of this product depends on the degree of surface preparation.

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

The accumulated dirt must be removed using a dry brush, clean and dry cloth, compressed air blow, vacuum cleaner and/or with the combination of such items, and the soluble salts must be removed through wash with a great quantity of fresh water, preferably with low pressure (up to 5,000 psi) according to SSPC-SP 12/NACE No. 5.

For new works, it is necessary to treat spatter and weld seams, damaged areas, sharp edges and corners using abrasive blasting grade Sa2½ or SSPC-SP10, visual standard ISO 8501-1. In cases where the above practice is not possible, consult the Technical Department of Weg Tintas for the use of Wegpoxi Edge Retention.

#### Surface treatment through Abrasive Blasting process

Execute the abrasive blasting to near white metal, Sa 2 ½ grade of the ISO 8501-1 visual standard (A Sa 2 ½, B Sa 2 ½, C Sa 2 ½ and D Sa 2 ½) or according to SSPC-SP 10/NACE No. 2, SSPC-VIS 1 visual standard (A SP 10, B SP 10, C SP 10, D SP 10, G1 SP 10, G2 SP 10, G3 SP 10).

Inspect the newly blasted surface observing the presence of surface flaws that could become apparent after this stage, adopting appropriate actions to mitigate such defects through grinding, weld filling and/or

epoxy putty.

In case of oxidation on the substrate from the end of the abrasive blasting to the beginning of the coating application, the surface must be blasted again until reaching the specified visual standard.

### Surface treatment through the manual mechanical cleaning process

**NOTE:** If it is not possible to execute the manual mechanical cleaning process, as an alternative the surface can be prepared with commercial abrasive blasting, grade Sa 2 of the ISO 8501-1 visual standard (C Sa 2 and D Sa 2) or according to SSPC-SP 6/NACE No. 3, SSPC-VIS 1 visual standard (C SP 6, D SP 6).

### Stainless Steel Surface Treatment

It can be applied on stainless steel, but abrasive blasting is required, grade Sa 2 1/2 of visual standard ISO 8501-1 (A Sa 2 1/2, B Sa 2 1/2, C Sa 2 1/2 and D Sa 2 1/2) or according to SSPC-SP 10/NACE No. 2, visual standard SSPC-VIS 1 (A SP 10, B SP 10, C SP 10, D SP 10, G1 SP 10, G2 SP 10, G3 SP 10).

For further information, consult WEG Technical Department.

## PREPARATION FOR APPLICATION

### Mixture

Homogenize the contents of each component with mechanical or pneumatic stirring (A and B). Check there are no sediment settled at the bottom of the package. Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

### Mixing ratio (Volume)

11 A X 1 B.

### Diluent Epoxy diluent 3005

### Dilution

It is recommended to dilute in special circumstances only. Depending on the application method, dilute at most 5% in volume.

Ready for use

Only add the diluent after complete mixing of components A + B.

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended dilution percentage.

Excessive dilution of the coating may affect the formation and aspect of the film and not allow to reach the specified thickness.

### Pot life of the mixture (25°C) (77°F)

3 h

In hot areas, we recommend consulting WEG Technical Department.

## APPLICATION FORMS

The data below is a guide, and similar equipment may be used.

Changes in nozzle sizes and pressures may be necessary to improve spraying characteristics. Before application, check if the equipment and its components are clean and in best condition. Purge the compressed air line to prevent contamination of the coating.

After mixing two-component products, if there are stops in the application, and pot life is exceeded (the coating shows variation in fluidity) it can no longer be diluted for further application.

Recoat all sharp edges, cracks and weld beads with a brush to prevent premature failures in these areas.

### Conventional gun:

|                       |                                   |
|-----------------------|-----------------------------------|
| Gun:                  | JGA 502/3 Devilbiss or equivalent |
| Fluid nozzle:         | EX                                |
| Air cap:              | 704                               |
| Atomization pressure: | 60 - 65 psi                       |

# TECHNICAL DATA SHEET



Pressure in the tank: 10 - 20 psi  
Dilution: Ready for use

**Airless Gun:**

Use Airless: Use at least pump 60: 1  
Hose: 3/8" internal diameter

Nozzle: 0,017" - 0,025"

**Brush:**

Only recommended for touch up small areas or stripe coat (screws, nuts, weld and sharp edges). Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for touch up.

**Roller:**

Use a thin nap, seamless sheepskin or microfiber roller for epoxy coatings.

The appearance of the finish should be controlled in the application.

For application with brush and/or roller, two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.

**Cleaning the equipment:**

Epoxy diluent 3005  
Clean all equipment immediately after use.

**NOTE:**

**PERFORMANCE IN THE APPLICATION**

For a good performance of the product, we recommend following the directions below:

Product not recommended for painting the interior of tanks

In paintings carried out in front of the sea, if exposed to sea air, we recommend to wash with fresh water between coats eliminating settled impurities.

We recommend coating only if the measured surface temperature is at least 3 °C (37,4°F) above the dew point temperature. Do not apply at steel temperatures below 10 °C (50°F).

Variations in color, aspect and gloss (more noticeable in dark colors) may occur, as well as delay in curing and low coating performance, when applied during periods of high air relative humidity, rainy days, low temperatures or drying the coating outdoor.

The temperature of the substrate, the weather and environmental conditions during the application and during the curing of the product, and the thickness of the coat may interfere in the product drying time.

For better application properties, the coating temperature should be between 21 - 27 °C prior to the mixing and application.

It should not be applied under adverse conditions, such as air relative humidity (RH) above 85%, as changes in color and appearance may occur.

Product designed for application in a single coat but can be applied in two coats if so specified or on complex structures where it is difficult to apply in a single coat

In coatings with variation in application method in the same job, the final aspect and gloss of the painted surfaces may show differences.

On newly painted surfaces in direct contact with water during the curing process, localized stains may occur with changes in their color (more visible in dark colors), delay in curing and compromised product performance.

Overcoating information is provided for guidance and subject to regional variations depending on local climatic conditions. For specific situations, consult WEG.

For further information, consult WEG Technical Department.

**SAFETY PRECAUTIONS**

Product developed for industrial use intended for handling by qualified professionals.

Please read carefully all the information contained in the MSDS of this product, available at: [www.weg.net](http://www.weg.net).

Store in a covered, well-ventilated area. 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.

Wear protective gloves / protective clothing / eye protection / face protection.



Avoid release this product and its packaging, as well as materials used during handling and application in the environment.

**NOTE:**

The information contained in this technical datasheet is based upon the experience and knowledge acquired in the field by the technical team of WEG.

If using the product without previous inquiry to WEG Coating concerning its suitability for the customer's intended purpose, the customer is aware that the use shall be its exclusive responsibility, WEG not being responsible for behavior, safety, suitability or durability of the product.

Some information contained in this datasheet are estimated, and can undergo variances arising from factors outside the manufacturer's control. Thus, WEG does not guarantee and does not assume any responsibility regarding the yield, performance or any other material or personal damage resulting from the incorrect use of the products concerned or the information contained in this Technical datasheet.

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