



W-TAR FREE CVD 324

PRODUCT DESCRIPTION: High-build two-component phenolic novalac epoxy direct to metal. It provides excellent chemical resistance, including several solvents, excellent corrosion and abrasion resistance.

RECOMMENDED USES: Suitable for highly aggressive environments, providing excellent corrosion protection over carbon steel. Used inside and outside water storage tanks and piping, it can be applied in a high-build single coat.

Versions produced through tintometric systems are not recommended for applications under immersion conditions.

CERTIFICATIONS AND APPROVAL: It complies with standard AWWA C210-15 - Liquid Epoxy Coatings and Linings for Steel Water Pipe and Fittings.

It complies with the Ministry of Health Directive No. 2914 regarding water for human consumption.

This product complies with regulation GM/MS No. 888 of the Ministry of Health, dated May 4, 2021. 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	20 3.6	20 3.6	L
	Component B	20 3.6	20 3.6	L

CHARACTERISTICS:

Color: Ral, Munsell or as per customer standard.

Gloss: Matte

Shelf-Life (25°C): 24 months

Theoretical coverage: 1,35 m²/l without dilution in the thickness of 600 µm dry. Without considering loss factors in application.

Resistance to dry heat: Maximum temperature 120 °C . The product retains its physical and chemical properties up to the temperature of 120 °C however, variations in the coating color and gloss may occur from 60 °C (140°F).

Drying:

	10 °C	25 °C	35 °C
Touch:	7 hours	3 hours	2 hours
Handling:	18 hours	10 hours	6 hours
Final:	240 hours	168 hours	168 hours

Overcoating Drying:

	10 °C	25 °C	35 °C
Min	18 hours	10 hours	6 hours
Max	5 days	2 days	2 days

SURFACE PREPARATION

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

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.



Surface treatment through Abrasive Blasting process

Bottom, Boottop and Side we recommend painting on blast cleaned surfaces to grade Sa 2½ or SSPC-SP10. Visual Standard ISO 8501-1.

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.

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.

Surface treatment through the manual mechanical cleaning process

Treat the surface mechanically until obtaining at least grade St 3 of the ISO 8501-1 visual standard or according to SSPC-SP 11; the SSPC-VIS 3 visual standard can be used as an aid.

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)

A X B. X C

Diluent

Dilution

Depending on the application method, dilute at most.

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.

In hot areas, we recommend consulting WEG Technical Department.

APPLICATION FORMS

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

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

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.

Conventional gun:

Gun:	JGA 502/3 Devilbiss or equivalent
Fluid nozzle:	EX
Air cap:	704
Atomization pressure:	60 - 65 psi
Pressure in the tank:	10 - 20 psi

Airless Gun:

TECHNICAL DATA SHEET



Use Airless: Use at least pump 60: 1
Fluid pressure: 4000 psi
Hose: ¼" internal diameter
Nozzle: 0,021" - 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. 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:

Clean all equipment immediately after use.

NOTE:

Do not leave catalyzed product in contact with the equipment used in the application, because the coating will vary in fluidity at temperatures above specified in the pot life and will cure faster, making the cleaning difficult.

PERFORMANCE IN THE APPLICATION

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

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.

Do not apply the product after the pot life has expired.

We recommend coating only if the surface temperature is at least 3°C (37,4°F) above the dew point temperature.

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.

For better application properties, the coating temperature should be between 21°C - 27 °C (69.8°F - 80.6 °F) 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.

Epoxy-based products are known by having excellent anti-corrosion properties and low resistance to sunlight exposure. In situations of exposure of the film to the weather, over time it will present a loss of gloss known as chalking and its shade will change as a consequence. Remember that even undergoing such chalking, the film anti-corrosion protection is not impaired.

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

It is recommended to maintain forced air circulation inside tanks/reservoirs to prevent solvent saturation during curing.

For products intended for contact with drinking water or food, it is necessary to perform a freshwater and neutral soap wash prior to commissioning.

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.

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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