



CLEAR W-POXI CVD 323 EXP

PRODUCT DESCRIPTION

Two-component polyamide epoxy primer/finish with high solids and zinc phosphate anticorrosive pigmentation. Offers fast drying and good applicability. Excellent adhesion to carbon steel prepared by abrasive blasting. Applicable in a single high-build coat, simplifying the painting process.

RECOMMENDED USE

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

Tintometric system versions are not recommended for use in immersion conditions.

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.

This product complies with Ministry of Health Ordinance GM/MS No. 888, dated May 4, 2021.

Complies with Ministry of Health Ordinance No. 2914 regarding drinking water.

Certified in category C3H according to ISO 12944:2018 - When applied at 4.7 mils.

Certified in category C4H according to ISO 12944:2018 - When applied at 7.1 mils and combined with WEGTHANE HPA 501 at 2.4 mils.

Certified in category C5M of ISO 12944:2018 - When applied at 7.09 mils and combined with the WEGTHANE HPA 501 at 2.4 mils.

PACKAGING

Component A 0.95 US gal Package containing 0.95 US gal
5.28 US gal Package containing 5.28 US gal

Component B 0.95 US gal Package containing 0.95 US gal
5.28 US gal Package containing 5.28 US gal

Note Note: Winter Catalyst - Polyamine.
For drying and repainting under winter conditions, when the primer and CVD 323 paint are used with the winter catalyst, the subsequent application using the same catalyst is not recommended.

CHARACTERISTICS

Color	Aluminum. Colors upon request.
Gloss	Satin
VOC content	1.85 lb/gal
Volume Solids	80 ± 2% (ISO 3233)
Shelf Life	24 months
Dry Film Thickness	5.9 mils - 11.8 mils
Dry Heat Resistance	Maximum temperature 212 °F. The product maintains its chemical properties up to a temperature of 212 °F, but from 140°F, color and gloss variations in the paint may occur.
Theoretical Coverage	145.1 ft ² /gal without dilution at a dry film thickness of 8.9 mils. Loss factors during application are not considered.

DRYING

Drying			
	50 °F	77 °F	95 °F
Touch	2 hours	1 hour	30 min
Manipulation	10 hours	4 hours	3 hours
Final	240 hours	168 hours	120 hours



Recoat Drying

	50 °F	77 °F	95 °F
Minimum	10 hours	4 hours	3 hours
Maximum	6 meses	6 meses	6 meses

Drying with Winter Component B

	50 °F	77 °F	95 °F
Touch	2 hours	1 hour	30 min
Manipulation	6 hours	2 hours	2 hours
Final	240 hours	168 hours	120 hours

Recoat Drying with Winter Component B

	50 °F	77 °F	95 °F
Minimum	6 hours	2 hours	2 hours
Maximum	48 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.

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

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.

Recommended Surface Profile

It is recommended a roughness profile between 1.57 and 2.76 mils.

Abrasive Blasting

Perform abrasive blasting to near-white metal, Sa 2½ grade, according to ISO 8501-1 visual standard (A Sa 2½, B Sa 2½, C Sa 2½, D Sa 2½), or according to SSPC-SP10/NACE No. 2, visual standard SSPC-VIS 1 (A SP10, B SP10, C SP10, D SP10, G1 SP10, G2 SP10, G3 SP10).

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

For areas near marine environments, wash with fresh water at low pressure (minimum 3,000 psi) before abrasive blasting. In some cases, repeat washing after blasting to remove soluble contaminants and perform a new abrasive blasting.

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.

Hand and Power Tool Cleaning

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.

Carbon Steel Surfaces

Hard surface layers (e.g., layers resulting from flame cutting) must be removed by grinding before starting abrasive blasting.

All welds must be inspected and, if necessary, repaired before completing abrasive blasting. Porosities, cavities, weld splatter, etc., must be repaired with proper mechanical treatment or welding repair. In other areas, round edges and sharp corners (r e 0.0787 in, ISO 8501-3).



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: 1 A x 1 B.
Thinner	EPOXY DILUENT 3013
Dilution	Depending on the application method, dilute to a maximum of 15%.
Notes	<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>
Pot Life	<p>3 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>
Induction Time	<p>Wait 20 minutes before application.</p> <p>In very hot locations, we recommend consulting WEG's Technical Department.</p>

APPLICATION METHODS

Conventional Spray Gun	<p>Spray gun: JGA 502/3 Devilbiss or equivalent</p> <p>Fluid nozzle: EX</p> <p>Air cap: 704</p> <p>Atomization pressure: 50 - 70 psi</p> <p>Tank pressure: 10 - 20 psi.</p>
Airless Spray Gun	<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> <p>Filter: mesh 60.</p>
Roller	<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>
Brush	<p>Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).</p>
Cleaning of the equipments:	EPOXY DILUENT 3013
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.

In spray application, overlap each gun pass by 50%, 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

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

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

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.

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.

It is suggested to maintain forced air circulation in tanks/reservoirs to avoid solvent saturation during curing.

Products for contact with potable water or food: wash with fresh water and neutral soap before operation.

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

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.

COMPATIBILITY

The product may be applied over aged paints or other coating systems; however, it is advisable to test the product's contact with the previous paint on a small test area. We recommend dulling the surface with sanding for better performance; it must be ensured that the original material is well adhered. All non-adhered paint must be removed; areas with corrosion or applications over aged paints must be treated according to technical guidance.

For topcoat application over the product, the repainting interval must be respected; the surface must be dry and free of contaminants.

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.
