

W-POXI ENG 061

PRODUCT DESCRIPTION

Economical epoxy resin-based primer.

RECOMMENDED USE

Primer for protection of carbon steel on machinery, equipment, and metal structures exposed to normal environments.

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

Component A	20L Package containing 20L
Component B	20L Package containing 20L

CHARACTERISTICS

Color	Gray.
Gloss	Ultra-Matte
VOC content	539.28 g/l
Volume Solids	65 ± 10% (ISO 3233)
Shelf Life	12 months
Dry Film Thickness	100 µm - 120 µm
Dry Heat Resistance	Maximum temperature 60 °C. The product maintains its chemical properties up to a temperature of 60 °C, but from 60°C, color and gloss variations in the paint may occur.
Theoretical Coverage	5,91 m ² /l without dilution at a dry film thickness of 110 µm. Loss factors during application are not considered.

DRYING

Drying	
	25 °C
Touch	30 min
Manipulation	6 hours
Final	168 hours
Recoat Drying	
	25 °C
Minimum	6 hours
Maximum	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.

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.

Degreasing

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.

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.

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. Avoid prolonged mixing, as frictional heat will significantly reduce the product's shelflife.
Mixing Ratio	By volume: 1 A x 1 B.
Thinner	EPOXY DILUENT 3005
Dilution	Depending on the application method, dilute to a maximum of 15%.
Notes	Dilute according to recommendation. Only add the thinner after the A + B components are completely mixed. Excessive thinning of the paint may affect film formation, appearance, and make it difficult to achieve the specified thickness. 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.
Pot Life	3 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.
Roller	Use a short-haired, seamless wool or synthetic roller for epoxy paints. 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.
Brush	Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups). Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for touch-ups.
Cleaning of the equipments:	EPOXY DILUENT 3005
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.

Before application, ensure that the equipment and respective components are clean and in optimal condition.

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.

Do not leave material in hoses, guns, or equipment used for spraying. Thoroughly wash all used equipment.

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.

For optimal application properties, the paint temperature should be between 21°C and 27°C before mixing and application.

Painting is recommended only if surface temperature is at least 3°C above the dew point.

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

Due to the technical characteristics of the product, it does not always follow a reference standard and may present risks, shade variations, drying issues, blistering during topcoat repainting, and appearance differences between sequential batches.

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

Product not recommended for internal tank painting.

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.

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.

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