



WEG TAR FREE PLUS

PRODUCT DESCRIPTION		Two-component amine epoxy primer, pigmented with aluminum, with excellent abrasion resistance. Provides excellent anticorrosive protection, minimizing corrosion from mechanical damage.		
RECOMMENDED USE		Indicated for painting new construction or maintenance and repair. Can be applied directly over shop primer that has undergone hydroblasting, manual or mechanical treatment. Can be used below or above the waterline and at low temperatures.		
CERTIFICATIONS AND APPROVALS		Pre-qualified according to NORSOK M-501, Edition 6, System 7. 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	0.95 US gal Package containing 0.69 US gal 5.28 US gal Package containing 3.30 US gal		
	Component B	0.40 US gal Package containing 0.26 US gal 1.32 US gal Package containing 1.32 US gal		
CHARACTERISTICS	Color	Aluminum. Bronze.		
	Gloss	Matte		
	VOC content	3.63 lb/gal		
	Volume Solids	60 ± 2% (ISO 3233)		
	Shelf Life	24 months		
	Dry Film Thickness	5.5 mils - 6.3 mils		
	Dry Heat Resistance	Maximum temperature 248 °F. The product maintains its chemical properties up to a temperature of 248 °F, but from 140°F, color and gloss variations in the paint may occur.		
DRYING				
	Drying			
		50 °F	77 °F	95 °F
	Touch	4 hours	3 hours	2 hours
	Manipulation	7 hours	6 hours	3 hours
	Final	336 hours	240 hours	168 hours
	Recoat Drying			
		50 °F	77 °F	95 °F
	Minimum	8 hours	7 hours	4 hours
	Maximum	6 meses	6 meses	6 meses
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 3.35 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.

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

It can be used on parts with oxidation grades C or D, according to ISO 8501-1 visual standards.

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.

Over Primer

Existing shop primer must be removed via abrasive blasting to near-white metal, grade Sa 2½, ISO 8501-1 standard or SSPC-SP 10/NACE No.2, unless the manufacturer ensures integrity and performance of the painting system over the primer.

Respect the product recoat interval. If exceeded, perform light manual/mechanical sanding to break gloss and clean dust/residues for better adhesion between coats.

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: 2.5 A x 1 B.
Thinner	EPOXY DILUENT 3005
Dilution	Depending on the application method, dilute to a maximum of 5%.
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	2 h 30 min 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.

Induction Time

Wait 15 minutes before application.

In very hot locations, we recommend consulting WEG's Technical Department.

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.

Airless Spray Gun

Airless: Use minimum pump 60:1
Fluid pressure: 2000 - 2500 psi
Hose: 1/4" inner diameter
Nozzle: 0.017" - 0.027".

Roller

Use a short-haired, seamless wool or synthetic roller for epoxy paints.
Recommended only for small areas or touch-ups. Use a low-pile seamless wool roller or synthetic roller for epoxy paints.
Not recommended for internal tank painting.
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).

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.
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.
Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.

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.

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.

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.

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

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.

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.