



WEG TIE COAT

PRODUCT DESCRIPTION

Two-component polyamide epoxy intermediate, coal-tar-free. High-performance anticorrosive coating for above and below the waterline. Applicable in one or two high-build coats.

RECOMMENDED USE

Intermediate sealer paint, indicated to ensure adhesion between primer and antifouling or topcoats. Additionally, provides a complementary coat that increases anticorrosive protection. Can be used in new constructions, maintenance, and repair. In aggressive environments or immersion in water, two coats are recommended.

PACKAGING

Component A	0.95 US gal Package containing 0.76 US gal 5.28 US gal Package containing 4.23 US gal
Component B	0.24 US gal Package containing 0.19 US gal 1.06 US gal Package containing 1.06 US gal

CHARACTERISTICS

Color	Gray. Green.
Gloss	Matte
Volume Solids	58 ± 2% (ISO 3233)
Shelf Life	12 months
Dry Film Thickness	2.6 mils - 3.9 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	286.5 ft²/gal without dilution at a dry film thickness of 3.3 mils. Loss factors during application are not considered.

DRYING

Drying

	41 °F	77 °F	95 °F
Touch	12 hours	6 hours	4 hours
Manipulation	24 hours	16 hours	12 hours
Final	7 days	7 days	7 days

Recoat Drying

	41 °F	77 °F	95 °F
Minimum	36 hours	8 hours	5 hours
Maximum	42 days	28 days	14 days

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.

The product must always be applied over the anticorrosive system recommended by WEG. The surface must be clean, dry, and free of contaminants. Completely remove oils, greases, soluble salts, and other contaminants according to SSPC-SP1 and wash with high-pressure fresh water.

Over 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: 4 A x 1 B.
Thinner	EPOXY DILUENT 3005
Dilution	Depending on the application method, dilute to a maximum of 5%.
Notes	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	5 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.
Induction Time	No induction time required. 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: 2500 - 3500 psi Hose: 1/4" inner diameter Nozzle: 0.017" - 0.027".
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).
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. 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.
Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.
Clean all equipment immediately after use.

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.

Epoxy systems may have longer curing times when exposed to low temperatures.
For curing below 50°F, consult WEG Technical Department.

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.

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providing quality solutions to meet the needs of our customers.
