



W-POXI DRD 33

PRODUCT DESCRIPTION

Two-component polyamide epoxy primer/finish with high solids content and anticorrosive pigmentation, fast-drying. Excellent adhesion to carbon steel treated by abrasive blasting or mechanical cleaning. Can be applied over aged but firmly adhered coatings. High-build single-coat application, simplifying machinery and equipment painting.

RECOMMENDED USE

Indicated for painting metal structures, cargo holds, decks, deck accessories, hulls, boottops, exterior of tanks, pipelines, silos, and various equipment in industries. Recommended for new constructions, maintenance, and repair. For aggressive environments or immersion in water, two coats are recommended.

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	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	RAL, Munsell, or according to the customer's standard.
Gloss	Semi-Gloss
Volume Solids	80 ± 2% (ISO 3233)
Shelf Life	12 months
Dry Film Thickness	4.5 mils - 4.9 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.
Theoretical Coverage	271.8 ft ² /gal without dilution at a dry film thickness of 4.7 mils. Loss factors during application are not considered.

DRYING

Drying	<hr/>		
	50 °F	77 °F	95 °F
Touch	4 hours	2 hours	90 min
Manipulation	12 hours	8 hours	6 hours
Final	240 hours	168 hours	120 hours
Recoat Drying	<hr/>		
	50 °F	77 °F	95 °F
Minimum	12 hours	10 hours	8 hours
Maximum	-	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.

Accumulated dirt must be removed using a dry brush, and soluble salts must be removed by washing with fresh water under high pressure.



Abrasive Blasting

For other applications, it is recommended to paint on surfaces blasted to Sa 2½ or Sa 3 grade, according to SSPC-SP10 or SSPC-SP5, respectively. Visual standard ISO 8501-1.

Evaluate the surface after blasting, observing revealed defects and adopt practices to minimize them, such as grinding or filling.

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.

Maintenance and Repair

Can be used for parts with oxidation grades C or D, according to ISO 8501-1 visual standards. The surface must be clean, dry, and free of contaminants. Mechanically treat to St 3 or SSPC-SP3 grade. Areas that cannot be prepared by this method must receive localized abrasive blasting to Sa 2 or SSPC-SP6 grade. For internal tank painting or below the waterline, mechanical preparation should only be applied to small areas.

Over Aged Coating

The product can also be applied over intact, well-adhered aged paints. Loose or poorly adhered paints must be removed down to a firm layer. Perform gloss break by sanding and dust removal. Small worn or damaged areas should be prepared with abrasive blasting grade Sa 2½ (SSPC-SP10) or mechanical treatment grade St3/SSPC-SP3, ISO 8501-1 standard.

Respect the repainting interval for the subsequent coat. If exceeded, perform manual/mechanical sanding to break gloss and remove dust/residues for better intercoat adhesion.

New Constructions

For new construction, treat overspray, weld beads, damaged areas, edges, and sharp corners by abrasive blasting grade Sa 2½ or SSPC-SP10, visual standard ISO 8501-1. If not possible, consult WEG Technical Department.

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 15%.
Notes	No dilution is required. Product ready to use. If necessary, consult the WEG Technical Department.
Pot Life	4 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	Wait 15 to 20 minutes before application. In very hot locations, we recommend consulting WEG's Technical Department.

APPLICATION METHODS

Conventional Spray Gun	Spray gun: JGA 502 Devilbiss or equivalent Fluid nozzle: EX Air cap: 704 Atomization pressure: 60 - 65 psi Tank pressure: 10 - 20 psi.
Roller	Use wool or synthetic rollers.



Brush	<p>Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).</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>
Cleaning of the equipments:	EPOXY DILUENT 3005
Notes	<p>Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination.</p> <p>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.</p> <p>Before application, ensure that the equipment and respective components are clean and in optimal condition.</p> <p>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.</p> <p>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.</p> <p>Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.</p>

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.

Proper washing and degreasing of the surface are essential, as well as sanding of old paints whenever necessary to promote adhesion.

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.

Surface preparation is recommended to Sa 2½ or SSPC SP10 (ISO 8501-1 visual standard). Less stringent standards are acceptable as long as there are no contaminants, supplemented with high-pressure water cleaning.

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.

Suitable for application over aged epoxy and polyurethane systems that show excellent adhesion to the substrate.

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

Epoxy-based products are well known for their excellent corrosion-resistant properties, although they have limited resistance to sunlight. When the applied coating is exposed to weathering, it may gradually lose its gloss, a phenomenon known as chalking, which can also cause a slight change in color. It is important to note that this chalking does not compromise the coating's corrosion protection.

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.

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.

SYSTEM COMPATIBILITY AND MAINTENANCE REPAINTING

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.

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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