

## WEG FENÓXI S

**PRODUCT DESCRIPTION:** Two-component, high build, phenolic epoxy primer with excellent chemical components with chemical resistance including several solvents, great anti-corrosion and abrasion resistance.

**RECOMMENDED USES:** Indicated for highly aggressive environments, providing excellent anticorrosive protection on steel surfaces. Highly recommended for internal and external painting of tanks and pipes where chemical resistance is the main requirement.

Indicated for electrostatic painting, with a resistivity of 400 to 800 kΩ.

**CERTIFICATIONS AND APPROVAL:** It is certified for contact with potable water and alcoholic foods in accordance with ANVISA's Resolution No. 105.

PACKAGING:	Component	Content	Package	Unit of measurement
	Component A	15 2,7	20 3,6	L
	Component B	0,5 0,9	0,5 0,9	L

**CHARACTERISTICS:**

**Color:** White, Gray, Red oxide, Blue

**Gloss:** Semigloss

**VOC content:** 230 g/l

**Volume solid:** 76 ± 2% (ISO 3233).

**Shelf-Life (25°C):** 12 months

**Thickness per coat (dry):** 80 µm –160 µm

**Theoretical coverage:** 6,10 m<sup>2</sup>/l without dilution in the thickness of 125 µm dry. Without considering loss factors in application.

**Resistance to dry heat:** Maximum temperature 120 °C . The product retains its physical and chemical properties up to the temperature of 120 °C however, variations in the coating color and gloss may occur from 60 °C (140°F).

**Drying:**

	10 °C	25 °C	35 °C
<b>Touch:</b>	9 hours	3 hours	2 hours
<b>Handling:</b>	24 hours	4 hours	5 hours
<b>Final:</b>	336 hours	168 hours	144 hours

**Overcoating  
Drying:**

	10 °C	25 °C	35 °C
Min	24 hours	5 hours	4 hours
Max	21 days	20 days	14 days

**SURFACE PREPARATION** The performance of this product is associated with the degree of surface preparation.

The surface must be clean and free of any contaminants. Completely remove oils, greases and fats, as described in the SSPC-SP 1 standard.

**Surface treatment through Abrasive Blasting process**

For immersion services, we recommend paint on surfaces that are blasted to Sa 2 ½ or SSPC-SP10. Visual Standard ISO 8501-1.

In case of oxidation on the substrate from the end of the abrasive blasting to the beginning of the coating application, the surface must be blasted again until reaching the specified visual standard.

Evaluate the surface after blasting, observing the presence of surface defects revealed after treatment, adopting appropriate practices to minimize defects through grinding or filling.

It is recommended a roughness profile between 40 and 85  $\mu\text{m}$  (1.58 - 3.35 mils).

For internal tank protection, it is recommended to perform a soluble salt test according to ISO 8502-6 on the surface before applying the paint. The content of soluble salts allowed is a maximum of 20mg/cm<sup>2</sup>, according to ISO 8502-9.

#### New buildings

For new buildings, it is necessary to treat welding spatters and weld seams, damaged areas, edges and sharp corners by abrasive blasting Sa 2 ½ degree or SSPC-SP10, visual standard ISO 8501-1.

#### Maintenance and repair

**NOTE:** Observe the product overcoating interval to apply the next coat. In case the maximum overcoating interval has been exceeded, it is necessary to manually/mechanically sand the surface to break the gloss of the previous coat and clean the sanding residues so as to provide better adhesion between the coats.

**For further information, consult WEG Technical Department.**

## PREPARATION FOR APPLICATION

### Mixture

Homogenize the contents of each component by means of mechanical or pneumatic stirring (A and B). Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

### Mixing ratio (Volume)

3 A X 1 B.

### Diluent Epoxi diluent 3024

Dilution is recommended only under special circumstances. Depending on the application method, dilute to the recommended application viscosity. Only add the diluent after complete mixing of components A + B.

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended dilution percentage.

Excessive dilution of the coating may affect the formation and aspect of the film and not allow to reach the specified thickness.

### Pot life of the mixture (25°C)

2 h

The pot life is reduced with a higher room temperature.

The pot-life test is performed according to the Brazilian standard ABNT NBR 15742; however, different volumes of coating prepared at once combined with different ambient and coating temperatures will influence the pot life, and different results than those mentioned in this data sheet may be found.

In hot areas, we recommend consulting WEG Technical Department.

## APPLICATION FORMS

**The data below is a guide, and similar equipment may be used.**

Changes in nozzle sizes and pressures may be necessary to improve spraying characteristics.

Before application, check if the equipment and its components are clean and in best condition.

Purge the compressed air line to prevent contamination of the coating.

After mixing two-component products, if there are stops in the application, and pot life is exceeded (the coating shows variation in fluidity) it can no longer be diluted for further application.

Recoat all sharp edges, cracks and weld beads with a brush to prevent premature failures in these areas.

### Conventional gun:

Gun:

JGA 502/3 Devilbiss or equivalent

Fluid nozzle:

EX

Air cap: 704  
Atomization pressure: 60 - 65 psi  
Pressure in the tank: 10 - 20 psi  
Dilution: 5%

**Airless Gun:**

Use Airless: Use at least pump 60: 1  
Fluid pressure: 2500 – 3500 psi  
Hose: ¼" internal diameter  
Nozzle: 0,019" - 0,023"  
Filter: Mesh 60

**Brush:**

Only recommended for touch up small areas or stripe coat (screws, nuts, weld and sharp edges). Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for touch up.

**Roller:**

Only recommended for small areas or retouching. Use a thin nap, seamless sheepskin or microfiber roller for epoxy coatings.

**Cleaning the equipment:**

Epoxi diluent 3024

**NOTE:**

For application with brush and/or roller, two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.

Do not leave catalyzed product in contact with the equipment used in the application, because the coating will vary in fluidity at temperatures above specified in the pot life and will cure faster, making the cleaning difficult.

Clean all equipment immediately after use.

**PERFORMANCE IN THE APPLICATION**

For a good performance of the product, we recommend following the directions below:

For application with brush and/or roller, two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.

We recommend surface preparation to Sa 2½ or SSPC SP10. ISO 8501-1 visual standard. It is acceptable to use less demanding surface preparation standards, as long as the absence of contaminants is guaranteed, and the blasting is complemented with high pressure water cleaning (the surface preparation alternatives suitable for each case must be evaluated).

In paintings carried out in front of the sea, if exposed to sea air, we recommend to wash with fresh water between coats eliminating settled impurities.

Do not apply the product after the pot life has expired.

We recommend coating only if the measured surface temperature is at least 3 °C (37,4°F) above the dew point temperature. Do not apply at steel temperatures below 10 °C (50°F).

The temperature of the substrate, the weather and environmental conditions during the application and during the curing of the product, and the thickness of the coat may interfere in the product drying time.

Epoxy systems may have longer curing time when exposed to low temperatures. For temperatures below 10 °C (50°F), consult WEG Technical Department.

For better application properties, the coating temperature should be between 21°C - 27 °C (69.8°F - 80.6 °F) prior to the mixing and application.

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

After the application, during the curing process, when the coated parts are subjected to low temperatures and/or high humidity, exudation may occur on the film, and it must be removed by washing with fresh water or cleaning with a cloth soaked in appropriate solvent. Such exudation does not affect the quality and corrosion resistance of the applied film; however, it should be removed as described above.

Epoxy-based products are known by having excellent anti-corrosion properties and low resistance to sunlight exposure. In situations of exposure of the film to the weather, over time it will present a loss of gloss known as chalking and its shade will change as a consequence. Remember that even undergoing such chalking, the film anti-corrosion protection is not impaired.

On newly painted surfaces in direct contact with water during the curing process, localized stains may occur with changes in their color (more visible in dark colors), delay in curing and compromised product performance.

WEG FENOXI S is generally applied in a total thickness of 160 micrometers (6.3 mils), 80 micrometers per coat (3.15 mils).



## SAFETY PRECAUTIONS

Overcoating information is provided for guidance and subject to regional variations depending on local climatic conditions. For specific situations, consult WEG.

For further information, consult WEG Technical Department.

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Product developed for industrial use intended for handling by qualified professionals.

Please read carefully all the information contained in the MSDS of this product, available at: [www.weg.net](http://www.weg.net).

Store in a covered, well-ventilated area. 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.

Wear protective gloves / protective clothing / eye protection / face protection.

Avoid release this product and its packaging, as well as materials used during handling and application in the environment.

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## NOTE:

The information contained in this technical datasheet is based upon the experience and knowledge acquired in the field by the technical team of WEG.

If using the product without previous inquiry to WEG Coating concerning its suitability for the customer's intended purpose, the customer is aware that the use shall be its exclusive responsibility, WEG not being responsible for behavior, safety, suitability or durability of the product.

Some information contained in this datasheet are estimated, and can undergo variances arising from factors outside the manufacturer's control. Thus, WEG does not guarantee and does not assume any responsibility regarding the yield, performance or any other material or personal damage resulting from the incorrect use of the products concerned or the information contained in this Technical datasheet.

The information contained in this technical datasheet is subject to periodic modification, without prior notice, due to the policy of evolution and continuous improvement of our products and services, providing solutions with quality to satisfy our customers' requirements.