



W-POXI HSM 32

PRODUCT DESCRIPTION

High-solids, high-build two-component polyamide epoxy putty with anticorrosive properties. Low volatile organic compounds (Low VOC).

RECOMMENDED USE

Used to repair imperfections on horizontal and vertical areas on steel and concrete substrates, tank interiors, floors, and fibers. With low VOC content, it is suitable for confined area use.

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
Component B	0.24 US gal Package containing 0.19 US gal

CHARACTERISTICS

Color	White.
Gloss	Semi-Gloss
VOC content	0.94 lb/gal lb/gal
Volume Solids	93 ± 2% (ISO 3233)
Shelf Life	24 months
Dry Film Thickness	19.7 mils - 236.2 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	11.8 ft ² /gal without dilution at a dry film thickness of 128.0 mils. Loss factors during application are not considered.

DRYING

Drying			
	50 °F	77 °F	95 °F
Final	216 hours	168 hours	144 hours
Recoat Drying			
	50 °F	77 °F	95 °F
Minimum	24 hours	18 hours	16 hours
Maximum	78 hours	72 hours	70 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.

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.

For areas near marine environments, wash with fresh water at low pressure (minimum 3,000 psi) before abrasive blasting. In some cases, repeat washing after blasting to remove soluble contaminants and perform a new abrasive blasting.

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.

Carbon Steel Surfaces

Hard surface layers (e.g., layers resulting from flame cutting) must be removed by grinding before starting abrasive blasting.

All welds must be inspected and, if necessary, repaired before completing abrasive blasting. Porosities, cavities, weld splatter, etc., must be repaired with proper mechanical treatment or welding repair. In other areas, round edges and sharp corners ($r \leq 0.0787$ in, ISO 8501-3).

Concrete Surfaces

No coating or paint should be applied until the concrete (or cement-sand screed) is fully dry and cured for at least 28 days under normal climatic conditions.

Before painting, the concrete must have a maximum residual moisture of 6%.

Concrete execution plans should include prior waterproofing to prevent rising damp or groundwater capillary rise, which may cause blistering or coating delamination.

No coating or paint should be applied on concrete or cement-sand screed with curing accelerator unless representative tests indicate satisfactory adhesion of the paint system.

For more information, consult the Concrete Surface Preparation and Application Manual.

Coatings should not be applied over floors contaminated with oils or aggressive products. The floor must be effectively cleaned. Applying over residues of these contaminants may cause coating detachment and other failures.

Acid treatment: recommended for ground-level floors and walls if no infiltration risk exists, as acid attack on rebar may compromise mechanical strength and structural safety. Follow product technical bulletins or applicator instructions when using this method.

Scarification (milling) for moderate system: this method is an excellent option for repairing and restoring damaged surfaces, suitable for both light and heavy work. Recommended for cutting anti-slip grooves, removing contaminated surface layers like grease, oil, rubber, synthetic pavements, paints, traffic marking stripes, among other floor applications. The mill consists of a motor rotating a tool/disc drum with widea (tungsten carbide), which chisels and wears the floor surface. Depth depends on disc type and shape used on the mill shaft.

Respect the recoat interval between product coats for applying the subsequent coat. If the maximum recoat interval is exceeded, execute a light manual/mechanical sanding to break the gloss of the previous coat, followed by dust and residue cleaning, ensuring better adhesion between paint layers.

Surface preparation must be performed in accordance with SSPC SP-13/NACE No. 6, ICRI Technical Guidance No. 03732, and compared with the visual standard expressed as CSP 1 to 10.

Coating on old concrete only upon recommendation from WEG Technical Department.

Manual and rotary hammer grinders: these machines work with motors with 1 or 2 multi-purpose discs (3 stones or diamond inserts per disc). Depending on floor hardness, carborundum or widea (tungsten carbide) inserts can be used.

The performance of this product is associated with surface preparation. The surface must be clean, solid, free of any contaminants, fully dry, and have sufficient roughness to allow adhesion of the applied protection system.

Check for moisture in concrete according to ASTM D 4263.

Captive blast with centrifugal turbines: process with centrifugal blast/turbines, using steel shot in a

closed circuit.

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 component content with a spatula. Ensure no pigment remains at the bottom of the container. Add component B to component A respecting the mixing ratio. Mix thoroughly with the spatula.
Mixing Ratio	By volume: 4 A x 1 B.
Thinner	Not applicable.
Dilution	Ready to use.
Notes	No dilution is required. Product ready to use. If necessary, consult the WEG Technical Department.
Pot Life	1 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

Squeegee, Spatula and Trowel	Apply by spreading.
Cleaning of the equipments:	Not applicable.
Notes	The data presented serves as a guide and similar equipment may be used. 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. Clean all equipment immediately after use.

APPLICATION PERFORMANCE

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.

Before application, observe weather conditions: there must be no threat of rain or drizzle. Surface temperature must be at least 37,4°F above the dew point, and relative humidity should not exceed 85%. Adverse conditions may cause color variations and other characteristics. Consult WEG Technical Department.

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.

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

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.

Under adverse weather conditions in indoor and/or outdoor environments with high relative humidity, rain or drizzle, low or very low temperatures, and excessively high temperatures, variations in color and other product characteristics may occur. Please consult WEG's Technical Department for more information.

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.