



W-POXI BLOCK HPP 40 RL

**PRODUCT DESCRIPTION**

Two-component Novolac epoxy primer, high-build, high solids, aluminum-pigmented. Tolerant to manually or mechanically cleaned surfaces. High-adhesion anticorrosive coating on properly treated carbon steel or adherent aged paint. Excellent chemical resistance, very low solvent content (Low VOC), abrasion, and impact resistance. W-POXI BLOCK HPP 402 RL provides superior anticorrosive protection, surface hardness, and impermeability.

**RECOMMENDED USE**

Recommended for initial protection of carbon steel without mill scale and when corrosion makes abrasive blasting impractical. Particularly indicated for environments where anticorrosive and chemical resistance are essential requirements.

**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**

<b>Component A</b>	0.95 US gal Package containing 0.81 US gal
<b>Component B</b>	0.24 US gal Package containing 0.15 US gal

**CHARACTERISTICS**

<b>Color</b>	Aluminum.
<b>Gloss</b>	Semi-Gloss
<b>Volume Solids</b>	85 ± 3% (ISO 3233)
<b>Shelf Life</b>	24 months
<b>Dry Film Thickness</b>	4.7 mils - 5.1 mils
<b>Dry Heat Resistance</b>	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.
<b>Theoretical Coverage</b>	277.1 ft <sup>2</sup> /gal without dilution at a dry film thickness of 4.9 mils. Loss factors during application are not considered.

**DRYING**

	Drying		
	50 °F	77 °F	95 °F
<b>Touch</b>	10 hours	4 hours	2 hours
<b>Manipulation</b>	24 hours	10 hours	6 hours
<b>Final</b>	240 hours	166 hours	168 hours
<b>Pot life</b>	120 min	90 min	60 min
	Recoat Drying		
	50 °F	77 °F	95 °F
<b>Minimum</b>	10 hours	4 hours	2 hours
<b>Maximum</b>	30 hours	24 hours	20 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.

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

**Recommended Surface Profile**



It is recommended a roughness profile between 1.57 and 3.35 mils.

**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.

**Water Jetting**

Application of this product is allowed on hydroblasted surfaces showing moderate flash rust, WJ-2M, according to SSPC-VIS 4/NACE VIS 7 visual standard.

**Hand and Power Tool Cleaning**

Mechanically treat the surface until achieving at least St 2 grade according to ISO 8501-1 visual standard or SSPC-SP 2, using SSPC-VIS 3 visual standard as guidance.

**Maintenance and Repair**

When the aged coating shows good adhesion, perform light sanding to break gloss, followed by dust and residue cleaning to ensure better adhesion between coats.

**Over Aged Coating**

For aged paint with good adhesion, perform light sanding to break gloss and clean dust/residues, ensuring better adhesion between coats.

It is recommended to test the paint on a small area to check compatibility and ensure aged paint is well adhered. Loose or poorly adhered paints must be removed. Repainting should be done only on well-preserved surfaces.

It is acceptable to adopt less stringent preparation standards as long as contaminant absence is ensured via high-pressure fresh water cleaning (5,000-10,000 psi) according to SSPC-SP12/NACE No.5. In case of doubt, consult the technical area.

Remove all contaminants from the existing paint. Areas where the film is not adhered must be removed with light blasting grade Sa 1 (brush off) or according to SSPC-SP7, ISO 8501-1 visual standard. Corrosion points, worn, or damaged areas must be prepared by commercial abrasive blasting grade Sa 2, ISO 8501-1 standard or SSPC-SP6/NACE No.3, SSPC-VIS 1 standard. If not possible, use rotary-mechanical tools according to SSPC-SP 11.

**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.

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**APPLICATION PREPARATION**

<b>Mixing</b>	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. Avoid prolonged mixing, as frictional heat will significantly reduce the product's shelflife.
<b>Mixing Ratio</b>	By volume: 5.5 A x 1 B.
<b>Thinner</b>	EPOXY DILUENT 3005
<b>Dilution</b>	Depending on the application method, dilute to a maximum of 10%.
<b>Notes</b>	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.
<b>Pot Life</b>	1 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**

No induction time required.

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

**APPLICATION METHODS**

**Roller**

Not recommended for internal tank painting. Use wool or synthetic rollers.

**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**

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.  
 It is considered good practice to periodically wash the spraying equipment during the day. The cleaning frequency depends on the amount sprayed, temperature, and elapsed time, including all delays.

**APPLICATION PERFORMANCE**

The product should be stored between 68°C - 86°C to achieve appropriate application viscosity.

For coatings applied in coastal areas exposed to sea spray, it is recommended to wash with fresh water between coats to remove deposited impurities.

Light colors may require more than one coat to achieve uniform coverage.

Do not apply the product after the pot life has been exceeded.

Do not use excessive air pressure. Properly adjust fluid and nozzle pressure for better atomization.

For optimal application properties, the paint temperature must be between 69.8°F - 80.6°F before mixing and application.

Recommended preparation: Sa 2½ or SSPC SP10. Painting over manually/mechanically prepared surfaces at St 2 (SSPC-SP2) or St 3 (SSPC-SP3), ISO 8501-1 visual standard, is also recommended.

This product has low resistance to exposure to sunlight. When exposed to weathering, the applied film will show loss of color and gloss over time. The film is not impaired regarding anticorrosive protection.

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.

W-POXI BLOCK HPP 402 RL allows painting on recently hydroblasted surfaces with minor traces of light corrosion (Flash rust or "moderate" SSPC VIS4(I)/NACE No.7).

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.

It is not recommended to apply this product on surfaces with a water film, under direct rain impact, on freshly painted surfaces exposed to water during curing, in places with low temperatures, or in situations where parts are applied and left to dry outdoors, as localized staining with color change (more visible in dark 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.

**SYSTEM COMPATIBILITY AND MAINTENANCE REPAINTING**

Proper cleaning and degreasing of the surface is required for the application of the topcoat; for applying topcoats over W-POXI BLOCK HPP 402 RL, the repainting interval must be respected.

**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](http://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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