TECHNICAL DATA SHEET

W-POXI PR 108

PRODUCT DESCRIPTION

Two-component polyamide epoxy primer with iron oxide and anticorrosive pigmentation, fast-drying and good applicability. Excellent adhesion on carbon steel treated by abrasive blasting.

RECOMMENDED USE

Recommended for painting metal structures, exterior of tanks, pipelines, silos, and various equipment, whether new or maintenance, in pulp and paper, sugar ethanol, chemical and petrochemical industries, among others. Recommended for low to medium aggressiveness environments.

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	5.28 US gal Package containing 4.53 US gal
Component B	0.95 US gal Package containing 0.75 US gal

CHARACTERISTICS

Color	Colors upon request. Red.
Gloss	Matte
VOC content	6.07 lb/gal
Volume Solids	49 ± 2% (ISO 3233)
Flash Point	28 °C
Shelf Life	12 months
Dry Film Thickness	2.8 mils - 3.1 mils
Dry Heat Resistance	Maximum temperature 302 °F. The product maintains its chemical properties up to a temperature of 302 °F, but from 140°F, color and gloss variations in the paint may occur.
Theoretical Coverage	266.1 ft²/gal without dilution at a dry film thickness of 3.0 mils. Loss factors during application are not considered.
Specific Gravity	Min: 1.4 Max: 1.5 g/cm³

DRYING

Drying

	50 °F	77 °F	95 °F
Touch	6 hours	3 hours	1 min
Manipulation	18 hours	8 hours	6 hours
Final	240 hours	168 hours	168 hours

Recoat Drying

	50 °F	77 °F	95 °F
Minimum	18 hours	8 hours	6 hours
Maximum	96 hours	72 hours	64 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.

Reviewed on January 16th, 2026

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 1.97 and 2.36 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.

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: 6 A x 1 B.
Thinner	DILUENT SL 30
Dilution	Depending on the application method, dilute to a maximum of 10%.
Notes	Dilute according to recommendation. Only add the thinner after the A + B components are completely mixed. Excessive thinning of the paint may affect film formation, appearance, and make it difficult to achieve the specified thickness. 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	6 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 20 minutes before application. 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: 50 - 65 psi Tank pressure: 10 - 30 psi.
Airless Spray Gun	Use minimum pump 60:1 Fluid pressure: 2100 - 2400 psi Hose: 1/4" inner diameter

	Nozzle: 0.015" - 0.019".
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:	DILUENT SL 30
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.

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.

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

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.

When applying by brush or roller, two or more coats may be necessary to achieve a uniform layer and recommended film thickness.

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.

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.

COMPATIBILITY

The product STARFLEX PR 108 can be applied over aged coatings or other paint systems. However, it is recommended to test the compatibility of STARFLEX PR 108 with the previous coating on a small test area.

For applying topcoats over STARFLEX PR 108, the recoat interval must be respected.

It must be ensured that the original material is well adhered. All non-adherent paint must be removed.

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.

Reviewed on January 16th, 2026