

W-TERM CVD 823

PRODUCT DESCRIPTION

Two-component finish primer formulated with modified epoxy hybrid technology, providing excellent corrosion protection under insulation (CUI - Corrosion Under Insulation) when applied to cryogenic equipment operating at temperatures ranging from -196°C to 650°C. Contains high-performance anticorrosive pigments, contributing to the durability and integrity of the coating system under severe service conditions.

RECOMMENDED USE

Indicated to prevent corrosion of carbon steel under thermal insulation, can be applied on surfaces heated up to 260°C. Used on exterior of pipelines operating from -196°C to 650°C.

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.

Complies with Petrobras Standard N-2943 - Annex E.

PACKAGING

Component A	20L Package containing 18.4L
Component B	1.5L Package containing 1.5L

CHARACTERISTICS

Color	Gray.
Gloss	Semi-Matte
VOC content	992.78 g/l
Volume Solids	54 ± 2% (ISO 3233)
Shelf Life	12 months
Dry Film Thickness	125 µm - 150 µm
Theoretical Coverage	4,32 m ² /l without dilution at a dry film thickness of 125 µm. Loss factors during application are not considered.

DRYING

Drying

	10 °C	25 °C	35 °C
Touch	30 min	20 min	15 min
Manipulation	90 min	60 min	40 min
For operation	24 hours	24 hours	24 hours

Recoat Drying

	10 °C	25 °C	35 °C
Minimum	3 hours	2 hours	1 hour
Maximum	-	-	-

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.

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.

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.

Hand and Power Tool Cleaning

Perform manual mechanical cleaning for carbon steel surfaces with oxidation grades C or D, according to SSPC-VIS 3 visual standards. For previously painted surfaces with grades E, F, or G, follow SSPC-VIS 3.

If manual mechanical cleaning is not possible, alternatively perform commercial abrasive blasting, Sa 2 grade according to ISO 8501-1 visual standard (C Sa 2 and D Sa 2) or SSPC-SP 6/NACE No. 3, visual standard SSPC-VIS 1 (C SP 6, D SP 6).

The manual mechanical cleaning process is recommended only for small areas.

Mechanically treat the surface until achieving at least SSPC-SP 11 grade, using SSPC-VIS 3 visual standard as guidance.

Stainless Steel Surfaces

Can be applied on stainless steel; however, abrasive blasting is required, grade Sa 2 1/2 of the ISO 8501-1 visual standard (A Sa 2 1/2, B Sa 2 1/2, C Sa 2 1/2, D Sa 2 1/2) or according to SSPC-SP 10/NACE No. 2, visual standard SSPC-VIS 1 (A SP 10, B SP 10, C SP 10, D SP 10, G1 SP 10, G2 SP 10, G3 SP 10).

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: 11 A x 1 B.
Thinner	EPOXY DILUENT 3005
Dilution	Ready to use.
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.
Pot Life	3 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.

APPLICATION METHODS

Conventional Spray Gun	Spray gun: JGA 502/3 Devilbiss or equivalent Fluid nozzle: EX Air cap: 704 Atomization pressure: 60 - 65 psi Tank pressure: 10 - 20 psi.
Airless Spray Gun	Airless: Use minimum pump 60:1 Hose: 3/8" inner diameter Nozzle: 0.017" - 0.025".



Roller	Use a short-haired, seamless wool or synthetic roller for epoxy paints. The finish appearance must be controlled during application. 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:	EPOXY DILUENT 3005
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. Before application, ensure that the equipment and respective components are clean and in optimal condition. 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.

It is recommended to paint only if the measured surface temperature is at least 3°C above the dew point temperature. Do not apply at steel temperatures below 10°C.

For optimal application properties, the paint temperature should be between 21°C and 27°C before mixing and application.

Substrate temperature, climatic and environmental conditions during application and curing, as well as applied film thickness, may affect drying time.

Do not apply under adverse conditions, such as RH above 85%, as gloss and color may slightly change. Do not apply on condensed surfaces.

Product designed for single-coat application, but it can be used in two coats if specified or in complex structures where applying in a single coat is difficult.

Information on repainting is provided as guidance and is subject to regional variations depending on local climatic conditions. For specific situations, consult WEG.

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.

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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