



**W-POXI LFD 33**

**PRODUCT DESCRIPTION**

Two-component polyamine epoxy primer/finish, low friction coefficient, high solids, high-build, and anticorrosive pigmentation. Tolerant to wet surfaces and mechanical treatment; can be used as system converter. Excellent anticorrosive protection and leveling, significantly reducing friction on freshwater vessels.

**RECOMMENDED USE**

Recommended for below-waterline painting on various vessels such as tugboats, barges, flatboats, ferries, pushers, and boats in general. It is especially indicated for reducing fuel consumption and increasing speed.

Can be indicated for silos and storage tanks of granular or fine powder materials, facilitating flow and minimizing surface impregnation.

**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>	5.28 US gal Package containing 4.23 US gal
<b>Component B</b>	1.06 US gal Package containing 1.06 US gal

**CHARACTERISTICS**

<b>Color</b>	According to customer standard. RAL and Munsell chart.
<b>Gloss</b>	Gloss
<b>VOC content</b>	2.88 lb/gal
<b>Volume Solids</b>	83 ± 2% (ISO 3233)
<b>Shelf Life</b>	24 months
<b>Dry Film Thickness</b>	11.8 mils - 19.7 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>	84.8 ft <sup>2</sup> /gal without dilution at a dry film thickness of 15.7 mils. Loss factors during application are not considered.

**DRYING**

Drying	Temperature			
	41 °F	50 °F	77 °F	95 °F
<b>Touch</b>	9 hours	6 hours	3 hours	2 hours
<b>Manipulation</b>	36 hours	24 hours	8 hours	2 hours
<b>Final</b>	336 hours	240 hours	168 hours	144 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 1.97 and 2.95 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.

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.

**Water Jetting**

It is recommended to paint on hydroblasted surfaces to CWJ-2 grade according to SSPC-VIS 4. The product can be applied on surfaces with light flash rust, grade CWJ-2L.

**Hand and Power Tool Cleaning**

It can be used on parts with oxidation grades C or D, according to ISO 8501-1 visual standards.

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).

Mechanically treat the surface until achieving at least St 3 grade according to ISO 8501-1 visual standard or SSPC-SP 11, using SSPC-VIS 3 visual standard as guidance.

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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.
<b>Mixing Ratio</b>	By volume: 4 A x 1 B.
<b>Thinner</b>	EPOXY DILUENT 3005
<b>Dilution</b>	Depending on the application method, dilute to a maximum of 5%.
<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. Only add the diluent after completely mixing components A and B.
<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.
<b>Induction Time</b>	No induction time required.  In very hot locations, we recommend consulting WEG's Technical Department.

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**APPLICATION METHODS**

<b>Conventional Spray Gun</b>	Spray gun: JGA 502/3 Devilbiss or equivalent Fluid nozzle: EX
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	Air cap: 704 Atomization pressure: 60 - 65 psi Tank pressure: 10 - 20 psi.
<b>Airless Spray Gun</b>	Airless: Use minimum pump 60:1 Fluid pressure: 2000 - 3000 psi Hose: 1/4" inner diameter Nozzle: 0.017" - 0.025". Filter: mesh 60.
<b>Roller</b>	Recommended only for small areas or touch-ups. Use a low-pile seamless wool roller 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.
<b>Brush</b>	Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).
<b>Cleaning of the equipments:</b>	EPOXY DILUENT 3005
<b>Notes</b>	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.

During curing, if the applied parts are exposed to low temperatures and/or high humidity, exudation may occur on the film, which should be removed with fresh water or cloth moistened with appropriate Diluent. This does not affect the quality or corrosion resistance of the film.

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.

Do not apply under adverse conditions, such as RH above 70% or on condensed surfaces. Small variations in color, appearance, and gloss may occur during high humidity, rainy days, cold locations, or when parts dry outdoors.

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.

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.

**SYSTEM COMPATIBILITY AND MAINTENANCE REPAINTING**

The primer repainting interval must be respected for the application of the topcoat. If the maximum interval indicated is exceeded, manual/mechanical sanding with sandpaper to remove gloss is necessary. The primer surface must be dry and free of contaminants.

The product may be applied over aged paints or other coating systems; however, it is advisable to test the product's contact with the previous paint on a small test area. We recommend dulling the surface with sanding for better performance; it must be ensured that the original material is well adhered. All non-adhered paint must be removed; areas with corrosion or applications over aged paints must be treated according to technical guidance.

**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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