



**LACKPOXI N 2680 EDGE RETENTION**

**PRODUCT DESCRIPTION**

High-build, solvent-free two-component polyamine epoxy primer formulated with non-toxic anticorrosive pigments for steel surfaces. Developed for application on surfaces where steel preparation is difficult, such as sharp edges, angles, weld beads, bolts, nuts and similar areas. Can be applied on surfaces prepared by dry abrasive blasting or hydroblasting.

**RECOMMENDED USE**

Ships, maritime structures, and offshore: ballast and fuel tanks, decks, oil and natural gas exploration platforms, onboard machinery, pipelines, etc.

Industrial applications: bridges, metal structures, and various machinery.

Pipes: can be applied inside and outside of pipelines.

**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 0.71 US gal 5.28 US gal Package containing 3.96 US gal
<b>Component B</b>	0.26 US gal packaging containing 0.24 US gal. 1.45 US gal packaging containing 1.32 US gal.

**CHARACTERISTICS**

<b>Color</b>	Gray. Red Oxide.
<b>Gloss</b>	Gloss
<b>VOC content</b>	0.1 - 1.0 (lb/gal). Note: The average of VOC on the line can vary depending on the color.
<b>Volume Solids</b>	SOLVENT-FREE
<b>Shelf Life</b>	24 months
<b>Dry Film Thickness</b>	5.9 mils - 7.9 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>	271.8 ft <sup>2</sup> /gal without dilution at a dry film thickness of 5.9 mils. Loss factors during application are not considered.

**DRYING**

Drying		59 °F	68 °F	77 °F	86 °F	104 °F
<b>Touch</b>		14 hours	9 hours	6 hours	5 hours	4 hours
<b>Manipulation</b>		30 hours	20 hours	16 hours	15 hours	12 hours
<b>Final</b>		240 hours	192 hours	168 hours	168 hours	168 hours
<b>Pot life</b>		2 hours	90 min	1 hour	30 min	15 min
Recoat Drying		59 °F	68 °F	77 °F	86 °F	104 °F
<b>Minimum</b>		16 hours	16 hours	10 hours	10 hours	10 hours
<b>Maximum</b>		120 hours	120 hours	120 hours	120 hours	120 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.

The maximum level of soluble impurities on the blasted surface, as per the test described in ISO 8502-6 and using distilled water, must not exceed a conductivity measured according to ISO 8502-9 corresponding to a maximum of 20 mg/cm² (2 ¼g/cm²) in immersed, buried, or submerged areas.

**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.

Perform hydroblasting (pressure e 10,000 psi) according to SSPC-SP 12/NACE No. 5, reaching WJ-2 grade (C WJ-2, D WJ-2, E WJ-2, F WJ-2, G WJ-2, and H WJ-2) of SSPC-VIS 4/NACE VIS 7 visual standard.

**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).

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.

**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 e 0.0787 in, ISO 8501-3).

**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 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: 3 A x 1 B.
<b>Thinner</b>	Not applicable.
<b>Dilution</b>	Same volume of Component A.
<b>Notes</b>	No dilution is required. Product ready to use. If necessary, consult the WEG Technical Department.
<b>Pot Life</b>	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.
<b>Induction Time</b>	No induction time required.  In very hot locations, we recommend consulting WEG's Technical Department.

**APPLICATION METHODS**

<b>Airless Spray Gun</b>	Airless: Use minimum pump 60:1 Fluid pressure: 3500 - 4500 psi Hose: 1/4" inner diameter Nozzle: 0.023" - 0.027". Filter: mesh 60.
<b>Roller</b>	Use a short-haired, seamless wool or synthetic roller for epoxy paints. 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>	Not applicable.
<b>Notes</b>	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. In spray application, overlap each gun pass by 50%, finishing with a cross pass. This technique avoids uncovered or unprotected areas and ensures proper aesthetic finish. Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas. 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**

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

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.

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.

The product allows painting on recently water-blasted surfaces with slight traces of flash rust (or relatively advanced degree of flash rusting, equivalent to the "moderate" degree described in SSPC VIS4(I) / NACE N°7).

Regardless of the preparation type, the product's moisture tolerance allows surface washing with fresh water immediately before painting, minimizing salt content.

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

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.

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 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.

For topcoat application over the product, the repainting interval must be respected; the surface must be dry and free of contaminants.

**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.  
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.

---