



W-POXI BLOCK GFD 362 STRIPE COAT



PRODUCT DESCRIPTION

High-build two-component polyamine epoxy primer/finish with anticorrosive pigmentation for steel surfaces. Developed for dry, damp, and hydroblasted surfaces.

RECOMMENDED USE

Recommended for application as a stripe coat, aiming to reinforce edges, welds, bolts, sharp corners, and areas of difficult coverage, contributing to the uniformity and integrity of the coating system.

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

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| Component A | 3.6L Package containing 2.88L 20L Package containing 16L |
| Component B | 0.9L Package containing 0.72L 4L Package containing 4L |

CHARACTERISTICS

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| Color | Gray. |
| Gloss | Gloss |
| Volume Solids | 85 ± 2% (ISO 3233) |
| Shelf Life | 24 months |
| Dry Film Thickness | 160 µm - 500 µm |
| Dry Heat Resistance | Maximum temperature 120 °C. The product maintains its chemical properties up to a temperature of 120 °C, but from 60°C, color and gloss variations in the paint may occur. |
| Theoretical Coverage | 2,58 m ² /l without dilution at a dry film thickness of 330 µm. Loss factors during application are not considered. |

DRYING

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| Drying | <hr/> | | |
| | 10 °C | 25 °C | 35 °C |
| Touch | 14 hours | 3 hours | 2 hours |
| Manipulation | 30 hours | 9 hours | 5 hours |
| Final | 240 hours | 168 hours | 168 hours |
| Recoat Drying | <hr/> | | |
| | 10 °C | 25 °C | 35 °C |
| Minimum | 14 hours | 9 hours | 4 hours |
| Maximum | 48 hours | 48 hours | 24 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 40 and 70 micrometers.

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 soluble contaminant content on the blasted surface must meet ISO 8502-6 and ISO 8502-9 standards, not exceeding 20 mg/cm² (2 ¼g/cm²) in immersed, buried, or submerged areas.

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.

APPLICATION PREPARATION

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| 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: 4 A x 1 B. |
| Pot Life | 2 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 | No induction time required. In very hot locations, we recommend consulting WEG's Technical Department. |

APPLICATION METHODS

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| Airless Spray Gun | Airless: Use minimum pump 60:1 Fluid pressure: 2000 - 3000 psi Hose: 1/4" inner diameter Nozzle: 0.015" - 0.021". |
| 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.

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.

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

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

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.

For temperature conditions between 52 and 70°C: the best performance of this product occurs over abrasive blasting to Sa 2 ½ standard or hydroblasting to CWJ-2M standard. However, for equipment in this temperature range that, due to their use, cannot be prepared to the standards mentioned above, application over manual/mechanical treatment to St3 standard according to ISO 8501-1 may be accepted.

The epoxy coating can dry and cure under permanent immersion conditions after application on carbon steel surfaces (2 hours of ambient drying at 25 °C). However, the freshly painted surface, when in direct contact with water during the curing process, may present localized staining with color alteration (more visible in dark colors). Please consult WEG's Technical Department for further information.

It is suggested to maintain forced air circulation in tanks/reservoirs to avoid solvent saturation during curing.

Products for contact with potable water or food: wash with fresh water and neutral soap before operation.

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

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.

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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