

# TECHNICAL DATA SHEET



## W-POXI HPP 344 EXP

**PRODUCT DESCRIPTION:** Two-component polyamide epoxy primer direct to metal. Formulated with anti-corrosion and tar-free pigments. High-performance anti-corrosion coating for use above and below the waterline. Applicable in one or two high-build coats.

**RECOMMENDED USES:** Recommended for maintenance and repair of vessels and coating of metal structures and piping. Two coats are recommended for aggressive environments or immersion in water.

**CERTIFICATIONS AND APPROVAL:** This product, when supplied to comply with the RoHs Directive (Restriction of Certain Hazardous Substances) has the letter R in its description.

PACKAGING:	Component	Content	Package	Unit of measurement
	Component A	20 3.6	20 3.6	L
	Component B	20 3.6	20 3.6	L

CHARACTERISTICS:					
<b>Color:</b>		Gray, Red oxide			
<b>Gloss:</b>		Ultra matte			
<b>Volume solid:</b>		80 ± 2% (ISO 3233).			
<b>Shelf-Life:</b>		12 months at 25°C			
<b>Thickness per coat (dry):</b>		100 µm –200 µm			
<b>Theoretical coverage:</b>		5,3 m <sup>2</sup> /l without dilution in the thickness of 150 µm dry. Without considering loss factors in application.			
<b>Resistance to dry heat:</b>		Maximum temperature 120 °C . The product retains its physical and chemical properties up to the temperature of 120 °C however, variations in the coating color and gloss may occur from 60 °C (140°F).			
<b>Drying:</b>					
		<b>-10 °C</b>	<b>5 °C</b>	<b>25 °C</b>	<b>35 °C</b>
<b>Touch:</b>		-	4 hours	3 hours	90 minutes
<b>Pressure:</b>		15 hours	40 hours	6 hours	4 hours
<b>Final:</b>		-	336 hours	168 hours	168 hours
<b>Overcoating Drying:</b>					
		<b>-10 °C</b>	<b>5 °C</b>	<b>25 °C</b>	<b>35 °C</b>
<b>Min</b>		-	18 hours	6 hours	4 hours
<b>Max</b>		-	28 days	28 days	15 days

### SURFACE PREPARATION

The performance of this product depends on the degree of surface preparation.

The surface must be clean and free of any contaminants. Completely remove oils, greases and fats, as described in the SSPC-SP 1 standard.

The accumulated dirt must be removed using a dry brush, clean and dry cloth, compressed air blow, vacuum cleaner and/or with the combination of such items, and the soluble salts must be removed through wash with a great quantity of fresh water, preferably with low pressure (up to 5,000 psi) according to SSPC-SP 12/NACE No. 5.



## Surface treatment through the hydroblasting process

We recommend to paint on surfaces hydroblasted to the degree CWJ-2 according to standard SSPC-VIS 4. Allowed application on degree of flash rust light according to CWJ-2L.

## Surface treatment through Abrasive Blasting process

For immersion services, we recommend paint on surfaces that are blasted to Sa 2 ½ or SSPC-SP10. Visual Standard ISO 8501-1.

Bottom, Boottop and Side we recommend painting on blast cleaned surfaces to grade Sa 2½ or SSPC-SP10. Visual Standard ISO 8501-1.

Inspect the newly blasted surface observing the presence of surface flaws that could become apparent after this stage, adopting appropriate actions to mitigate such defects through grinding, weld filling and/or epoxy putty.

It is recommended a roughness profile between 40 and 85 µm (1.58 - 3.35 mils).

Execute the abrasive blasting to near white metal, Sa 2 ½ grade of the ISO 8501-1 visual standard (A Sa 2 ½, B Sa 2 ½, C Sa 2 ½ and D Sa 2 ½) or according to SSPC-SP 10/NACE No. 2, SSPC-VIS 1 visual standard (A SP 10, B SP 10, C SP 10, D SP 10, G1 SP 10, G2 SP 10, G3 SP 10).

## New buildings

For new buildings, it is necessary to treat welding spatters and weld seams, damaged areas, edges and sharp corners by abrasive blasting Sa 2 ½ degree or SSPC-SP10, visual standard ISO 8501-1.

## Refinishing of surfaces with aged coating in good conservation conditions

In cases where the aged coating has good adhesion to the substrate, we recommend superficial sanding to break the gloss, followed by the cleaning of the dust and residues of the sanding in order to provide better adhesion between the coats.

Application on intact Zinc Silicate Shop Primers should be prepared with fast blasting. For application on Shop Primers Epoxy Iron Oxide, ensure that the intact primer is clean and dry.

## Maintenance and repair

**NOTE:** Observe the product overcoating interval to apply the next coat. In case the maximum overcoating interval has been exceeded, it is necessary to manually/mechanically sand the surface to break the gloss of the previous coat and clean the sanding residues so as to provide better adhesion between the coats.

## Small repairs

Corrosion spots, worn or damaged areas and the like shall be prepared by commercial abrasive blasting to grade Sa of ISO 8501-1 visual standard or according to SSPC-SP 6 / NACE No. 3, SSPC-VIS 1 visual standard. If it is not possible to execute the abrasive blasting, as an alternative the surface can be prepared with manual or mechanical cleaning to grade St 2 according to standard SSPC SP2, ISO 8501-01 visual standard.

## For further information, consult WEG Technical Department.

### PREPARATION FOR APPLICATION

#### Mixture

Homogenize the contents of each component with mechanical or pneumatic stirring (A and B). Check there are no sediment settled at the bottom of the package. Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

#### Mixing ratio (Volume)

1 A X 1 B.

#### Diluent Epoxy diluent 3005

#### Dilution

Depending on the application method, dilute at most. 5%

Only add the diluent after complete mixing of components A + B.

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended dilution percentage.

The quantity of diluent may vary depending on the type of equipment used and the ambient conditions

during the application.

Excessive dilution of the coating may affect the formation and aspect of the film and not allow to reach the specified thickness.

**Pot life of the mixture (25°C)**

5 h

**Induction time (25°C)**

No induction time required.

In hot areas, we recommend consulting WEG Technical Department.

**APPLICATION FORMS**

**The data below is a guide, and similar equipment may be used.**

The data below is a guide, and similar equipment may be used. In the spray application, make a 50% overlap in each gun pass, concluding with a cross pass. This technique is used to avoid uncovered and unprotected areas and to obtain a suitable aesthetic finish.

Changes in nozzle sizes and pressures may be necessary to improve spraying characteristics.

Purge the compressed air line to prevent contamination of the coating.

Recoat all sharp edges, cracks and weld beads with a brush to prevent premature failures in these areas.

After mixing two-component products, if there are stops in the application, and pot life is exceeded (the coating shows variation in fluidity) it can no longer be diluted for further application.

Before application, check if the equipment and its components are clean and in best condition.

**Conventional gun:**

Gun:	JGA 502/3 Devilbiss or equivalent
Fluid nozzle:	EX
Air cap:	704
Atomization pressure:	60 - 65 psi
Pressure in the tank:	10 - 20 psi
Dilution:	5%

**Airless Gun:**

Use Airless:	Use at least pump 60: 1
Fluid pressure:	2400 psi
Hose:	¼" internal diameter
Nozzle:	0,021" - 0,027"

**Brush:**

Only recommended for touch up small areas or stripe coat (screws, nuts, weld and sharp edges). Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for touch up.

**Roller:**

Use a thin nap, seamless sheepskin or microfiber roller for epoxy coatings.

Not recommended for painting the interior of tanks

For application with brush and/or roller, two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat. For application with brush and/or roller, two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.

**Cleaning the equipment:**

Epoxy diluent 3005  
Clean all equipment immediately after use.

**NOTE:**

Furthermore, it is a good working practice to periodically wash the spray equipment along the day. The cleaning frequency will depend on the amount sprayed, temperature and elapsed time, including all delays.

Do not leave catalyzed product in contact with the equipment used in the application, because the coating will vary in fluidity at temperatures above specified in the pot life and will cure faster, making the cleaning difficult.

**PERFORMANCE IN THE APPLICATION**

For a good performance of the product, we recommend following the directions below:

Do not apply the product after the pot life has expired.

In paintings carried out in front of the sea, if exposed to sea air, we recommend to wash with fresh water between coats eliminating settled impurities.

We recommend coating only if the measured surface temperature is at least 3 °C (37,4°F) above the dew point temperature. Do not apply at steel temperatures below 10 °C (50°F).

In coatings with variation in application method in the same job, the final aspect and gloss of the painted surfaces may show differences.

The temperature of the substrate, the weather and environmental conditions during the application and during the curing of the product, and the thickness of the coat may interfere in the product drying time.

The product should be applied within the overcoating interval as specified in the data sheet.

Before application, the weather conditions must be observed: There should be no threat of rain or drizzle. The surface temperature must be at least 3°C (37.4°F) above the dew point and the relative humidity must not exceed 85%.

Under adverse weather conditions indoors and/or outdoors with high relative humidity, rain, or drizzle, low or low temperatures and excessively high temperatures, variations in color and other product characteristics may occur. Consult the WEG Technical Department for more information. Epoxy-based products are known by having excellent anti-corrosion properties and low resistance to sunlight exposure. In situations of exposure of the film to the weather, over time it will present a loss of gloss known as chalking and its shade will change as a consequence. Remember that even undergoing such chalking, the film anti-corrosion protection is not impaired.

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

For further information, consult WEG Technical Department.

## COMPATIBILITY OF SYSTEMS AND MAINTENANCE REFINISHING

The primer overcoating interval should be respected before applying the topcoat. If the maximum recommended overcoating interval is exceeded, manual/mechanical sanding is necessary to break the gloss. The primer surface must be dry and free of any contaminants.

In case there is no finishing application on WEGPOXI STD 323, two coats of this product can be applied, in the appropriate thickness.

For further information, consult WEG Technical Department.

## SAFETY PRECAUTIONS

Product developed for industrial use intended for handling by qualified professionals.

Please read carefully all the information contained in the MSDS of this product, available at: [www.weg.net](http://www.weg.net).

Store in a covered, well-ventilated area. 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.

Wear protective gloves / protective clothing / eye protection / face protection.

Avoid release this product and its packaging, as well as materials used during handling and application in the environment.

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## NOTE:

The information contained in this technical datasheet is based upon the experience and knowledge acquired in the field by the technical team of WEG.



If using the product without previous inquiry to WEG Coating concerning its suitability for the customer's intended purpose, the customer is aware that the use shall be its exclusive responsibility, WEG not being responsible for behavior, safety, suitability or durability of the product.

Some information contained in this datasheet are estimated, and can undergo variances arising from factors outside the manufacturer's control. Thus, WEG does not guarantee and does not assume any responsibility regarding the yield, performance or any other material or personal damage resulting from the incorrect use of the products concerned or the information contained in this Technical datasheet.

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