

PRODUCT DESCRIPTION

Is a two-component, solvent-free, weather- and wear-resistant epoxypolysiloxane based coating.

FEATURE

Provide:

- high hardness and good impact resistance;
- withstands sunlight and UV radiation;
- resistant to continual splashing of water and various process chemicals.

RECOMMENDED TO USE

Steel surface:

- as a single coat for atmospheric corrosivity categories C2, C3 (ISO-12944-2/2018);
- epoxy system in atmospheric corrosivity categories C3, C4, C5 and CX (ISO-12944-2/2018);
- maintenance painting over old paint surfaces;

Non-ferrous and galvanized surfaces:

- as protective coating.

COMPATIBLE COATINGS

Depending on the operating conditions the material can be used with different type of coatings.

- Two-component epoxy coatings (2pack EP) of Welesgard.
- Two-component polyurethane coatings (2pack PUR) of Welesgard.

(For details please contact the Welesgard Technical Sales Support).

TECHNICAL DATA

Appearance	
Color:	RAL
Appearance:	Glossy
Material properties	
Volume solids (mixed):	96% ± 2%
Total mass of solids:	1280 g/l
VOC value:	50 g/l
Dry heat resistance (ASTM D2485):	120°C

SURFACE PREPARATION

Surface type	Minimum	Recommended
Surface profile	Ry5 (30–75 µm) (ISO 8503-1)	Ry5 (30–75 µm) (ISO 8503-1)
Primed and previously painted surfaces	P St3; P Ma ISO 8501-2, ISO 12944-4	P Sa2; P Ma ISO 8501-2½, ISO 12944-4
Steel surfaces	Sa 2 (ISO 8501-1)	Sa 2½ (ISO 8501-1)
Surfaces of non-ferrous metals and stainless steel	Clean with alkaline solution, rinse with water. (SSPC-SP 1)	Light surface roughness ISO 8501-2, ISO 12944-4
Galvanized surfaces	Clean with alkaline solution, rinse with water. (SSPC-SP 1)	Light surface roughness ISO 8501-2, ISO 12944-4

AMBIENT CONDITIONS

Ambient air temperature:	from +5 to +50°C
Surface temperature:	from +5 to +50°C
Relative humidity, below:	85%
Dew Point	at least 3°C higher than steel temperature

THICKNESS & THEORETICAL SPREADING RATE

	Min.	Med.	Max.
Dry Film Thickness:	80 µm	100 µm	120 µm
Wet Film Thickness:	84 µm	104 µm	125 µm
Spreading Rate:	12 m ² /l	9.6 m ² /l	8.6 m ² /l

Note: Practical coverage depends on the application conditions, structure to be painted, roughness of the surface and application method.

DRYING TIME

(Dry Film Thickness 80 µ)	10°C	23°C	50°C
Dry to touch	7 h	1 h	-
Dry to handle	14 h	3.5 h	2h
Min. overcoating interval	14 h	3 h	-
Full curing	21 d	7 d	-

Note: Drying times and polymerization depend from the relative humidity, temperature, ventilation conditions and the thickness of the film.

(For details please contact the Welesgard Technical Sales Support).

APPLICATION DATA

Mixing ratio: 3:1

Resin	3 parts by volume
Curing Agent	1 part by volume

Stir resin and curing agent separately (slow stirring) and then mix both components thoroughly with propeller stirrer. Before use, packaging material and the temperature should not be less than 3 ° C higher than the dew point.

Thinning:

Thinning is not necessary. If needed maximum 5% of Ethanol may be added.

Note: Thinning may cause reduction of the gloss.

Cleaner: WG-Welethinner EP

Pot life (+23 °C):

Approx. 2 hour after mixing (reduced at higher temperatures).

APPLICATION METHODS

Spray application:

Airless spray is the main method of application. For other spraying methods, viscosity correction may be required.

Note: If spraying will be paused for more than 10 minutes, paint hose should leave without pressure.

Brush:

Recommended for touch-up, stripe coating and small areas only. It is necessary to provide a nominal coating thickness.

Roller:

Could be used for repair or minor touch-up work.

PACKAGING

Note: The dimensions of the package may vary.

For packaging details please contact the Welesgard Technical Sales Support.

STORAGE & SHELF LIFE

The product must be stored in original sealed containers. The storage conditions are to keep the containers in a dry, well ventilated space away from source of heat and ignition.

Storage temperature:	from 5 to 30°C
Component "A"	2 years
Component "B"	1.5 years

Note: After lasting storage primer shall be stirred thoroughly until its precipitation is spread over the suspension homogeneously. Precipitation in primer does not change its properties or worsen its quality.

After the expiration date has passed, it is necessary to check the quality of the paint material.

SAFETY

Use with adequate ventilation. Do not inhale aerosol. Avoid contact with skin. After contact with skin, wash immediately with detergent, soap and water. In case of contact with eyes, rinse immediately with water and seek medical advice immediately.

For detailed information on the health and safety protection for use of this product see Safety Data Sheet (SDS).

IMPORTANT NOTE

The above-mentioned information is given according to our laboratory tests and practical application experience. The manufacturer takes into consideration the fact that the material can be used out of control; the manufacturer cannot give guarantees except of the material quality. The manufacturer has the right to improve the product and change the above-mentioned data without preliminary notification.