WG-WELEFORCE FD

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

Two-component, high solids epoxy primer and midcoat. Cure at low temperature.

FEATURE

Provide:

- cathodic protection and prevents corrosion under the paint film;
- the possibility of applying polyurethane coatings without an intermediate layer.

RECOMMENDED TO USE

Steel surface:

- as a primer or intermediate coating in corrosivity categories C2-C4, C5 and CX (ISO-12944-2 / 2018);

Aluminium surfaces:

- as a primer or protective coating in corrosivity categories C2-C4, C5 and CX (ISO-12944-2 / 2018);

COMPATIBLE COATINGS

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

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

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

TECHNICAL DATA

Appearance	
Color:	Grey
Appearance:	Semi matt coating
Material properties	
Volume solids:	78% ± 2%
Total mass of solids:	1385 g/l
VOC value:	190 g/l

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; PMa ISO 8501-2½, ISO 12944-4
Steel surfaces	St 3 (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

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

Note: During application, the temperature of the coating should be **at least +10°C.**

THICKNESS & THEORETICAL SPREADING RATE

Standard Grade	Min.	Middle	Max.
Dry Film Thickness:	80 µm	150 µm	200 µm
Wet Film Thickness:	103 µm	195 µm	255 µm
Spreading Rate:	9.7 m^2/l	5.1 m^2/l	3.9 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)	5°C	10°C	23°C
Surface dry (Dust free)	3 h	2.5 h	1.5 h
Dried to touch	8 h	6 h	3 h
Min. recoating interval	7 h	5 h	2 h
Max. recoating interval	14 h	10 h	3 h
Full curing	14 d	10 d	7 d

Note: - Drying times and polymerization depend from the relative humidity, temperature, ventilation conditions and the thickness of the film.
- The maximum overcoating time is 3 months without roughening provided the surface is free from dirt and grease. If the coating has been exposed to direct sunlight for some time, special attention must be paid for the removal of chalking with the suitable method before the painting work.

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

APPLICATION DATA

Mixing ratio: 5:1

Resin	5 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 the temperature of packaging and material should not be less than 3 ° C higher than the dew point.

Add thinner only after both components have been thoroughly mixed and stir the mixture.

Thinning:
If is necessary, the thinner Welethinner EP could be add up to 10% by volume.
Note:- Adding a thinner will increase the drying time.
- In the case of using thinner other than recommended, the manufacturer not takes responsibility for any possible reduction in the quality of the coating!

Cleaner:
Welethinner EP

Pot life (+23 °C):
Approx. 1 h after mixing (induction time approx. 15 min).

APPLICATION METHODS

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

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

Roller:
Prohibited to use roller for application of priming coat. Roller could be used to build up the dry film thickness or minor touch up work.

PACKAGING

	Volume (liters)	Size of containers (liters)
Comp. A	15	20
Comp. B	3	5

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”	1 years
Component “B”	2 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.

THE PRESENT TECHNICAL DATA SHEET REPLACES ALL PREVIOUS EDITIONS.