

PRODUCT DESCRIPTION

Two components high build, solvent free, polyamine cured epoxy coating.

FEATURE

Provide:

- high resistance to corrosion, abrasion, impact and chemical influences;
- high resistance under severe operating conditions, in highly aggressive environments;
- superior barrier protection in both single and in multilayer systems;
- withstands extreme ice loads, penetration into the soil and atmospheric influence;
- compatibility with impressed current cathodic protection (ICCP).

RECOMMENDED TO USE

Steel and concrete surfaces:

- as a primer for new steel structures, as well as for repairs with complete removal of existing coatings;
- as an anode shield around ICCP anodes (Im4 - ISO-12944-2/2018);
- for immersion, splash zone, extreme ice loads areas of offshore platforms and icebreakers, penetration into the soil and atmospheric influence (Im1; Im2; Im3 and Im4 - ISO-12944-2 / 2018);
- internal protective coating for sewage, industrial water, oil and petroleum products.

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:	Red
Appearance:	Gloss coating
Material properties	
Volume solids:**	98 ± 2%
Density in the mixed state:	1.51 ± 0.05 g/sm ³
VOC -EU value; IED (2010/75/EU) :	≤ 42 g/l
Dry heat resistance:	120°C
Heat resistance Immersed, sea water	≤ 60°C
Adhesion (ASTM D4541):	> 5 MPa

Note: Colour of epoxy products may fade and chalk when exposed to sunlight and weathering.

SURFACE PREPARATION

Surface type	Minimum	Recommended
Surface profile	Ry5 (90–150 µm) (ISO 8503-1)	Ry5 (90–150 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)
Concrete Surfaces	SSPC-SP 13/NACE No. 6	SSPC-SP 13/NACE No. 6

**AMBIENT
CONDITIONS**

Ambient air temperature:	from +10 to +60°C
Surface temperature:	from +10 to +50°C
Paint Material temperature:	+10 to +30°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:	250 µm	500 µm	700 µm
Wet Film Thickness:	250 µm	500 µm	700 µm
Spreading Rate:	3.9 m ² /l	1.96 m ² /l	1.6 m ² /l

Note: * For ice resistance, film thickness 500 µm applied as one coat is recommended.

DRYING TIME

(Dry Film Thickness 500 µ)	10°C	23°C	40°C
Dry to touch	6 h	3 h	2 h
Dried to handle (walk on)	20 h	10 h	4 h
Min. recoating interval	20 h	10 h	4 h
Max. recoating interval	5 d	3 d	2 d
Cured for service	14 d	7 d	3 d
Cured for immersion	5 d	3 d	2 d

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

- If maximum recoat time is exceeded, it is necessary to make surface roughness with abrasive, rinse with clean water to remove dirt and allow drying.

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

APPLICATION DATA

Mixing ratio: 2 : 1

Resin "A"	2 parts by volume
Curing Agent "B"	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 WG-Welethinner EP could be added up to 10% by volume.

Note: - Adding a thinner will increase the drying and curing time.

- For application on structures with ice load and under water hull of ice-going vessels no thinning is allowed.

Cleaner: WG-Welethinner EP

Pot life: Approximately 30 min at 23°C.

**APPLICATION
METHODS****Spray application:**

Airless spray application is recommended.

Plural component airless spray equipment could be used as well.

Recommended data for pump output, pressure at nozzle, nozzle tip and filters are the same as for airless spray equipment.

It is recommended to store both components at 20-25 °C before use.

Brush:

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

For detailed information refer to "Application Data Sheet" or contact the Welesgard Technical Sales Support.

PACKAGING

	Volume (litres)	Size of containers (litres)
Component "A"	10	20
Component "B"	5	5

On other possible volumes of packaging materials, please contact Welesgard representative office.

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"	4 years
Component "B"	4 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.