

PRODUCT DESCRIPTION

Two-component, high-solids epoxy coating reinforced with glass flakes.

FEATURE

Application:

- environmental temperature from -5 to +50°C;

Provided:

- stability in aggressive atmospheric, heating, chemical and mechanical exposure;
- long-term protection against corrosion;
- outstanding abrasion resistance for steel and concrete surfaces;

RECOMMENDED TO USE

Steel and concrete surfaces:

- in sever environmental condition;
- for high temperature exposure;
- in aggressive chemical and mechanical exposure;
- for immersion in fresh, sea and waste water.

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, Pink, Alum *
Appearance:	Semi matt coating
Material properties	
Standard Grade:	
Volume solids:	80% ± 2%
Total mass of solids:	1140 g/l
VOC value:	180 g/l
Winter Grade:	
Volume solids:	76± 2%
Total mass of solids:	1050 g/l
VOC value:	210 g/l

Note: *Industrial paint colours with limitations (due to filling pigments there might appear minor colour differences between manufacturing lots).

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)
Concrete Surfaces	SSPC-SP 13/NACE No. 6	SSPC-SP 13/NACE No. 6

AMBIENT CONDITIONS

Standard Grade:

Ambient air temperature:	from +10 to +50°C
Surface temperature:	from +10 to +50°C
Relative humidity, below:	85%
Dew Point	at least 3°C higher than steel temperature

Winter Grade

Ambient air temperature:	from -5 to +40°C
Surface temperature:	from -5 to +40°C
Relative humidity, below:	85%
Dew Point	at least 3°C higher than steel temperature

THICKNESS & THEORETICAL SPREADING RATE

Standard Grade	Min.	Recommend.	Max.
Dry Film Thickness:	200 µm	250 µm	400 µm
Wet Film Thickness:	250 µm	310 µm	500 µm
Spreading Rate:	4,0 m ² /l	3,2 m ² /l	2,0 m ² /l

Winter Grade	Min.	Recommend.	Max.
Dry Film Thickness:	200 µm	250 µm	400 µm
Wet Film Thickness:	270 µm	330 µm	530 µm
Spreading Rate:	3,8 m ² /l	3,0 m ² /l	1,9 m ² /l

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

DRYING TIME**Standard Grade:**

(Dry Film Thickness 250 µm)	10°C	23°C	40°C
Dry to touch	14 h	5,5 h	3 h
Dried to handle	32 h	12 h	6 h
Min. recoating interval	32 h	12 h	6 h
Max. recoating interval; atmospheric	5 d	3 d	2 d
Full curing	14 d	7 d	3 d

Winter Grade:

(Dry Film Thickness 250 µm)	-5°C	5°C	10°C
Dry to touch	20 h	12 h	10 h
Dried to handle	40 h	16 h	12 h
Min. recoating interval	WG-Comp. B is NOT recoated		
Full curing	21 d	14 d	10 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	2 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 WG-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:

WG-Welethinner EP

Pot life (+23 °C):

Approx. 1 h after mixing.

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.

On concrete surfaces:

Use rubber blade trowel, cogged trowel or roller.

PACKAGING

	Volume (liters)	Size of containers (liters)
Comp. A	12	20
Comp. B	6	10

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"	3 years
Component "B"	3 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.