

PRODUCT DESCRIPTION

Two component an ultra-high build, polyamide cure epoxy coating.

FEATURE

Application:

- to surfaces prepared by high pressure water jetting (HPWJ) as well.

Provide:

- corrosion and abrasive resistance;
- curing even after immersion in sea water;
- excellent cathodic disbondment protection and chemical resistance properties.

RECOMMENDED TO USE

Steel surfaces as:

- a primer or top coat in protective systems with environmental corrosivity classes C2-C4, C5 and CX (ISO-12944-2/2018);
- for structures immersed in fresh, sea or brackish water penetrating to soil compatible with cathodic protection as well (Im1; Im2; Im3 and Im4 - ISO-12944-2 / 2018);
- a single coat in environmental corrosivity classes C2-C5;
- maintenance coating for surfaces damaged by pitting corrosion as well as for previously painted surfaces in marine environment.

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, Yellow, Light red
Appearance:	Semi-Gloss coating
Material properties:	
Volume solids (mixed):	85% ± 2%
Density (at +20°C):	1.43 g/cm ³
VOC value:	136 g/l
Dry heat resistance (ASTM D2485):	120°C
Adhesion: (ASTM D4541)	>7 MPa
Taber abrasion, CS-17, 1Kg, 1000 cycles	55 mg

SURFACE PREPARATION

Surface type	Minimum	Recommended
Surface profile	Ry5 (50–80 μm) (ISO 8503-1)	Ry5 (50–80 μm) (ISO 8503-1)
Primed and previously painted surfaces	P St3; P Ma ISO 8501-2, ISO 12944-4; Wa 2,(ISO 8501-4) or WJ2 (NACE No.5/SSPC- SP 12)	P Sa2; P Ma ISO 8501-2, ISO 12944-4 Wa 2, (ISO 8501-4) or WJ2 (NACE No.5/SSPC- SP 12)
Steel surfaces in environmental corrosivity classes C2-C5 (ISO-12944-2/2018)	Sa 2 (ISO 8501-1); Wa 2,(ISO 8501-4) or WJ2 (NACE No.5/SSPC- SP 12)	Sa 2½ (ISO 8501-1); Wa 2,(ISO 8501-4) or WJ2 (NACE No.5/SSPC- SP 12)
Steel surfaces in environmental corrosivity classes Im1; Im2; Im3 and Im4 (ISO-12944-2/2018)	Sa 2½ (ISO 8501-1);	Sa 2½ (ISO 8501-1);

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: In order to ensure the best possible performance of the product, it is recommended that the temperature of paint itself be from 10 to 25°C during the application.

THICKNESS & THEORETICAL SPREADING RATE

	Min.	Med.	Max.
Dry Film Thickness:	200 µm	500 µm	850 µm
Wet Film Thickness:	235 µm	588 µm	1000 µm
Spreading Rate:	4.25 m ² /l	1.7 m ² /l	1 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 500 µ)	5°C	10°C	23°C	40°C
Dry to touch	7h 30m	6h 20m	2h 30m	1 h
Min. overcoating interval (itself)	20 h	12 h	6 h	4 h
Max. overcoating interval (itself)	60 d	50 d	45 d	30 d
Min. overcoating interval (2pack EP/PUR)	18 h	10 h	5 h	3 h
Max. overcoating interval (2pack EP/PUR)	50 d	45 d	36 d	30 d
Cure for service	16 d	10 d	7 d	6 d

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

- The curing and polymerization times are determined at a controlled temperature and relative humidity (RH) of 60 - 80%.

- In case of long periods of overcoating, it is necessary to consider the possibility of contamination of the substrate (grease, dust), which must be removed before carrying out the overcoating.

- 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: 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 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: Add up to 5% by volume of thinner **WG-Welethinner EP** when thinning is needed.

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:

Temperature:	Pot life
10°C	2 h.
23°C	60 min.
40°C	30 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: Could be used for repair or minor touch-up work. Do not use roller for application of priming coat.

PACKAGING

	Volume (liters)	Size of containers (liters)
Comp. A	15	20
Comp. B	5	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"	2 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.