

### PRODUCT DESCRIPTION

Two-component zinc epoxy primer.

### FEATURE

Provide:

- cathodic protection and prevents corrosion under the paint film.

### RECOMMENDED TO USE

Steel surface:

- as a primer coating in epoxy systems in the 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.

- Single pack, moisture cured polyurethane coatings (1pack PUR) of Welesgard.
- 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:	Bluish Grey
Appearance:	Matt coating
Material properties	
Volume solids (mixed):	53 ± 2%
Total mass of solids:	1740 g/l
VOC value:	420 g/l
Dry heat resistance (ASTM D2485):	150°C

### SURFACE PREPARATION

Surface type	Minimum	Recommended
Surface profile	Ry5 (30–75 µm) (ISO 8503-1)	Ry5 (30–75 µm) (ISO 8503-1)
Steel surfaces	St 3 (ISO 8501-1)	Sa 2½ (ISO 8501-1)
Repair	(UHPWJ) до степени WJ2 (NACE No.5/SSPCSP)	(UHPWJ) до степени WJ2 (NACE No.5/SSPCSP)

**Note:** The service life of coatings depends on the degree of surface preparation. The higher degree of the surface preparation, give the greater coating operation lifetime.

### 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.	Max.
Dry Film Thickness:	40 µm	80 µm
Wet Film Thickness:	75 µm	150 µm
Spreading Rate:	13.3 m <sup>2</sup> /l	6.7 m <sup>2</sup> /l

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

**DRYING TIME**

At temperature +23°C	40 µm	80 µm
Dried to walk on	10 min	20 min
Min. recoating interval epoxy	1.5 h	4 h
Min. recoating interval other types	4 h	8 h

**Note:** Drying times and polymerization depend on 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 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:**

When used as a shop-primer, it is necessary to add a thinner Welethinner EP no more than 10% by volume.

**Note:** - 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. 8 hours after mixing (induction time approx. 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.

**Air spray & Roller:**

It is not recommended

**PACKAGING**

	Volume (liters)	Size of containers (liters)
Component "A"	7.5	10
Component "B"	2.5	3

**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"	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.***