

**PRODUCT DESCRIPTION**

Two-pack, solvent free, high build polyurethane coating for manual application.

**FEATURE**

Application:

- in one layer with dry film thickness up to 1 mm in the field or factory condition;
- temperature vary from -5 to +50°C

Provide:

- very short drying time;
- Volatile Organic Compound – 0 g/l

**RECOMMENDED TO USE**

Steel or concrete surfaces:

- for manual application with a brush or spatula;
- for long-term maintenance-free protection of exterior metal and concrete as well as FRP, GRP, RTRP, etc.;
- for structures with environmental corrosivity classes C3, C4, C5 and CX (ISO-12944-2/2018) and 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).

**COMPATIBLE COATINGS**

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

- WG-Weleforce JW Primer (for FRP, GRP, RTRP, etc. surfaces).
- 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**

<b>Appearance</b>	
Color:	Grey, Dark Yellow and Black
Appearance:	Semi-gloss coating
<b>Material properties</b>	
Volume solids:	100 ± 2%
Density of the mixture:	1,40 ± 0,05 g/cm <sup>3</sup>
VOC value:	0 g/l
Temperature resistance:	50°C
Adhesion to steel in the temperature range of 23°C to Tmax=50°C:	≥8 MPa
Adhesion after keeping in water for 1000 hours at the temperature Tmax=+50°C:	≥5 MPa
Service life expectancy *:	30 years

**Note:** \* Service life expectancy depends to a considerable extent on the accuracy of compliance with the technology in the process of surface preparation and coat application, as well as on the peculiarities of coat operation conditions.

**SURFACE PREPARATION**

Surface type	Minimum	Recommended
Surface profile	Ry5 (75-120 μm) (ISO 8503-1)	Ry5 (75-120 μm) (ISO 8503-1)
Primed and previously painted surfaces	P St3; P Ma ISO 8501-2, ISO 12944-4	P 2½; P Ma ISO 8501-2, ISO 12944-4
Steel surfaces	Sa 2 (ISO 8501-1)	Sa 2½ (ISO 8501-1)

Surface type	Minimum	Recommended
Concrete surfaces	SSPC-SP 13/NACE No. 6	SSPC-SP 13/NACE No. 6
FRP, GRP, RTRP and similar surfaces	Clean contaminated surfaces with a 50/50 mixture of isopropyl alcohol and water. Before application, the surface should be impregnated with WG-Welepipe JW Primer or other primer recommended by the Welesgard technical support department.	

## AMBIENT CONDITIONS

### Plural component airless application:

Ambient air temperature:	from -5 to +50°C
Surface temperature:	from -5 to +50°C
Paint Material temperature*:	
Component "A" not less than:	+15°C
Component "B" not less than:	+15°C
Relative humidity, below:	85%
Dew Point	at least 3°C higher than steel temperature

## THICKNESS & THEORETICAL SPREADING RATE

Standard Grade	Min.	Med.	Max.
Dry Film Thickness:	500 µm	700 µm	1000 µm
Wet Film Thickness:	500 µm	700 µm	1000 µm
Spreading Rate:	2,0 m <sup>2</sup> /l	1.43 m <sup>2</sup> /l	1.0 m <sup>2</sup> /l

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

## DRYING TIME

### At temperature 23°C:

(Dry Film Thickness 700 µ)	23°C
Dry to touch	2 h
Dry through	8 h
Min. recoating interval	2 h
Max. recoating interval	24 h
Full curing	7 d

**Note:** Drying times and polymerization depend from 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.

### Thinning:

Thinning is not allowed.

### Cleaner:

Use the cleaner WG-Pipecleaner. Toluene, acetone or their mixture as well as other alcohol-free thinner could be used as the cleaning agent.

**Pot life** of the mixed material - 15 min. at 20 ° C.

## APPLICATION METHODS

**WG-Welepipe BG** designed and recommended for manual application with brush or spatula.

## PACKAGING

	Volume (litres)	Size of containers (litres)
Component A	1.5	2
Component B	0.5	0.5

## 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 year
Component "B"	1 year

**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.