

PRODUCT DESCRIPTION

Two-component, high solids epoxy primer and midcoat.

FEATURE

- Provides cathodic protection and prevents corrosion under the paint film.

RECOMMENDED TO USE

The product is used over blast cleaned steel surfaces as a primer and a midcoat in epoxy paint systems in environmental classes C2-C4 and C5-I/M. Specially recommended for frameworks of industry buildings, pipe bridges, conveyors and structural constructions of process industry.

COMPATIBLE COATINGS

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

Primer:

- WG-WELEFORCE FD Primer
- WG-WELEFORCE FD
- WG-WELEFORCE ZINC

Top coat:

- Epoxy coating WELEFORCE series.
- Polyurethane coatings WG-Sulacover 2K series.

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

TECHNICAL DATA

Appearance	
Color:	Grey
Appearance:	Semi matt coating
Material properties	
Volume solids:	78% ± 2%
Total mass of solids:	1385 g/l
VOC value:	190 g/l

SURFACE PREPARATION

All solid contamination that could prevent adhesion should be removed from the old surfaces. Remove salts and other water soluble contamination by wet cleaning with brush, high pressure-, steam- or alkali cleansing. Remove grease and oils by alkali-, emulsion- or solvent cleansing (ISO 8504-3, ISO 12944-4). The surfaces should be rinsed carefully with fresh water after cleaning. Old, painted surfaces, in which maximum overcoating interval has expired, additional roughening with suitable method is recommended.

Steel surfaces:

Blast cleaning to min Sa 2½ (ISO 8501-1, ISO 8504-2).

Surface profile:

The surface profile must conform to "fine" or "medium" according to ISO 8503-1 (30-75 microns Ry5).

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
Paint Material temperature:	+10°C
Relative humidity, below:	80%
Dew Point	at least 3°C higher than steel temperature

Note:

During application, the **temperature of the coating** should be **at least +10°C**.

THICKNESS & THEORETICAL SPREADING RATE

Standard Grade	Min.	Med.	Max.
Dry Film Thickness:	80 µm	150 µm	200 µm
Wet Film Thickness:	103 µm	195 µm	255 µm
Spreading Rate:	9.7 m ² /l	5.1 m ² /l	3.9 m ² /l

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

DRYING TIME

(Dry Film Thickness 250 µ)	5°C	10°C	23°C
Dry to touch	3 h	2.5 h	1.5 h
Dried to handle	8 h	6 h	3 h
Min. recoating interval; (epoxy)	7 h	5 h	2 h
Max. recoating interval; (PU)	14 h	10 h	3 h
Full curing	14 d	10 d	7 d

¹ Drying times and polymerization depend from the relative humidity, temperature, ventilation conditions and the thickness of the film.

² The maximum overcoating time is 3 months without roughening provided the surface is free from dirt and grease. If the coating has been exposed to direct sunlight for some time, special attention must be paid for the removal of chalking with the suitable method before the painting work.

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

APPLICATION DATA

Mixing ratio: 5:1

Resin	5 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, packaging material and the temperature 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 necessary, the thinner WT-011 could be add up to 10% by volume.

Note:

¹ Adding a thinner will increase the drying time.

² 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:

WT-011

Pot life (+23 °C):

Approx. 1 h after mixing (induction time approx. 15 min).

APPLICATION METHODS

Airless spray application is recommended.

Airless application recommendations:

Pressure	17-20 MPa
Nozzle orifice	0,013-0,018"
Spray angle	Depended on object
Filter:	60 mesh (250 microns) To ensure that filters are clean
Pressure ratio of the pump (minimum)	45:1

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 (litres)	Size of containers (litres)
Comp. A	15	20
Comp. B	3	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 years
Component "B"	2 years

Note: Precipitation does not change its properties or worsen its quality of paint material. After lasting storage paint material shall be stirred thoroughly until its precipitation is spread over the suspension homogeneously.

SAFETY

Use with adequate ventilation. Do not inhale aerosol. Avoid contact with skin. After contact with skin, wash immediately with detergent, soap and water. Eyes rinse with water immediately and call a doctor.

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.