

PRODUCT DESCRIPTION

Two-component, surface-tolerant, high solids, pigmented with micaceous iron oxide and aluminium, epoxy based primer/topcoat.

FEATURE

- Contains special ingredients which penetrate through existing rust.
- Could be used as an interior coating for the storage tanks and vehicles employed in the transport of grain.
- Suitable for immersion in fresh and sea water.
- Available in Standard (Std) & Winter Grade (WG) versions.
- Cures at low temperatures, down to -5°C.

RECOMMENDED TO USE

As a primer or top coat in environmental classes C2-C4 and C5-I, C5-M. Could be used as a single coat on box girders and plate structures. Suitable for maintenance coating on deep seated rust and old paint surfaces. Used for protection of structures immersed in fresh and sea water. Applied e.g. for painting paper machines, bridges, navigation marks and ships.

COMPATIBLE COATINGS

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

Primer:

- Epoxy and zinc containing primers WELEFORCE series.
- WG-WELEFORCE MASTIC AL

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:	Aluminium and RT-aluminium
Appearance:	Semi matt coating
Material properties	
Standard Grade:	
Volume solids:	80% ± 2%
Total mass of solids:	1190 g/l
VOC value:	180 g/l
Winter Grade:	
Volume solids:	74± 2%
Total mass of solids:	1140 g/l
VOC value:	230 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:

Exposed to weather: Blast cleaning to Sa2 or steel brushing to min. St2. (ISO 8501-1, ISO 8504-2).

Exposed to immersion: Blast cleaning to min. Sa2½ (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).

AMBIENT CONDITIONS

Shop-primed surfaces:

Damaged or corroded surfaces should be prepared as describe in surface preparation for steel surfaces.

Old painted surfaces:

WG-Weleforce Mastic may be used over most types of properly prepared and tightly adhering coatings, however a test patch is recommended for use over existing coating.

For maintenance UHPWJ to WJ2 (NACE No.5/SSPC-SP 12) or Power tool cleaning to min. St 2 for rusted areas.

Standard Grade:

Ambient air temperature:	from +10 to +50°C
Surface temperature:	from +10 to +50°C
Paint Material temperature:	+10°C
Relative humidity, below:	80%
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
Paint Material temperature:	+10°C
Relative humidity, below:	80%
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 paint is at room temperature before the application.

The surface should be dry and clean. The surface temperature should be min 3°C above the dew point of the air.

THICKNESS & THEORETICAL SPREADING RATE

Standard Grade	Min.	Med.	Max.
Dry Film Thickness:	120 µm	200 µm	300 µm
Wet Film Thickness:	150 µm	250 µm	375 µm
Spreading Rate:	6,7 m ² /l	4,0 m ² /l	2,7 m ² /l

Winter Grade	Min.	Med.	Max.
Dry Film Thickness:	120 µm	200 µm	300 µm
Wet Film Thickness:	160 µm	270 µm	405 µm
Spreading Rate:	6,2 m ² /l	3,7 m ² /l	2,5 m ² /l

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

DRYING TIME

Standard Grade:

(Dry Film Thickness 200 µ)	23°C
Dry to touch	3 h
Dried to handle	5 h
Min. recoating interval	7 h
Full curing	7 d

Winter Grade:

(Dry Film Thickness 200 µ)	-5°C	0°C	5°C	10°C	23°C
Dry to touch	24 h	18 h	12 h	6 h	4 h
Dried to handle	48 h	26 h	18 h	12 h	5 h
Min. recoating interval (itself)	48 h	26 h	18 h	12 h	
Min. recoating interval (PU)	---	---	96 h	48 h	
Full curing	21 d	14 d	7 d	3 d	

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

² 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: 1:1**

Resin	1 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 is necessary, the thinner WT-011 or WT-012 (slow) could be added from 5 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:**Std. Grade (+23 °C)**

Approx. 1 h after mixing.

Winter Grade

Approx. 1 h after mixing (+23 °C)

Approx. 3 h after mixing (+10 °C)

APPLICATION METHODS

Airless spray application is recommended. For other spraying methods, viscosity adjustment may be necessary.

Airless application recommendations:

Pressure	17 - 20 MPa
Nozzle orifice	0,017-0,023"
Spray angle	Depended on object
Filter	60 mesh (250 microns) To ensure that filters are clean

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 (litres)	Size of containers (litres)
Comp. A	10	20
Comp. B	10	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: 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.