

### PRODUCT DESCRIPTION

Two components high build; rust penetrating epoxy mastic coating, reinforced with glass flakes.

### FEATURE

- Due to excellent rust penetrating properties it can be apply on poor prepared surfaces till grade St2 according ISO 8501-1.
- Could be applied to damp surfaces at relative humidity up to 95%.
- Have excellent corrosion, abrasion, impact and chemical resistant product, with proven properties under severe conditions.
- Suitable for immersion in fresh, sea water and buried in the ground.
- Excellent to apply on surfaces prepared by high pressure water jetting.
- Excellent protection in all atmospheric corrosivity categories such as C2-C4 including C5-I/C5-M and immersion such as Im1; Im2 and Im3.

### RECOMMENDED TO USE

Ideal for protection of steel surfaces in corrosive environments as single or multiple systems, both independently and in conjunction with other coatings.

Can be used in all kinds of immersion conditions, alternating wetting areas, extreme ice load, penetration into the soil and compatible with cathodic protection system.

The main usage: ballast tanks, sheet piles, tanks, bridges, piers, offshore platforms and other steel structures.

Repair work under severe conditions.

### 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 RP

#### 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:	Gloss coating
Material properties	
Volume solids:**	84 ± 2%
Density in the mixed state:	1.42 ± 0.05 g/sm <sup>3</sup>
VOC value:	≤246 g/l
Impact Resistance (ASTM 2794):	>4 J
Adhesion (ASTM D4541):	>5 MPa

**Note:** \*Other colours could be requested.

\*\*Volume solid could vary and depended from colour.

### 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.

**Power Tooling:** Prepare surface using scraper, needle guns, wire brush, disc sander etc. to grade St2 according to international standard ISO 8501-1 or corresponding one.

Make sure to remove all rust scale.

**Blast cleaning:** Blast clean to a minimum Sa1 grade according to international standard ISO 8501-1 or relevant it.

**High pressure water jetting or slurry blasting** could be used for cleaning as well. Visual evaluation of surface state after the water jetting can be determined in accordance with ISO 8501-4, but not below the category of Wa 2.

**New steel:** before the application is necessary to remove all mill scale.

**Surface profile:**

The surface profile should correspond to the "Medium" according to ISO 8503-1 (50-80 µm, Ry5).

## AMBIENT CONDITIONS

<b>Ambient air temperature:</b>	from +2 to +50°C
<b>Surface temperature:</b>	from +2 to +45°C
<b>Paint Material temperature:</b>	+5°C
<b>Relative humidity, below:</b>	95%
<b>Dew Point:*</b>	Visually dry

**Note:**

\*There is no need to control the dew point.

WG-Weleforce RP may be applied to damp surfaces, but it should not contain a drop drips, puddles or to be covered with a film of water.

In order to ensure the best possible performance of the product, it is recommended that the paint is at room temperature before the application.

## THICKNESS & THEORETICAL SPREADING RATE

Standard Grade	Min.	Med.*	Max.
<b>Dry Film Thickness:</b>	150 µm	250 µm	350 µm
<b>Wet Film Thickness:</b>	179 µm	298 µm	417 µm
<b>Spreading Rate:</b>	5.6 m <sup>2</sup> /l	3.4 m <sup>2</sup> /l	2.4 m <sup>2</sup> /l

**Note:** \* Recommended dry film thickness (DFT) - 250µm.

## DRYING TIME

(Dry Film Thickness 250 µ)	2°C	10°C	15°C	23°C	35°C
<b>Dry to touch</b>	-	12 h	6 h	4 h	3 h
<b>Min. recoating interval</b>	48 h	28 h	16 h	8 h	6 h
<b>Max. recoating interval</b>	7 d	4 d	3 d	2 d	1.5 d
<b>Full curing</b>	-	14 d	11 d	7 d	3 d

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

<sup>2</sup> 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: 4,12:1**

<b>Resin "A"</b>	4,12 parts by volume
<b>Curing Agent "B"</b>	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 WG-Welethinner EP could be added up to 5% by volume.

**Note:**

<sup>1</sup> Adding a thinner will increase the drying time.

<sup>2</sup> 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 (not less than)
2°C	3 h
15°C	2 h
23°C	1 h
35°C	45 min.

**APPLICATION METHODS**

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

**Airless application recommendations:**

Pressure ratio of airless pump	63:1
Pressure	17 - 20 MPa
Nozzle orifice	0,019-0,045"
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)
Component "A"	8.7	10
Component "B"	1.7	2

On other possible volumes of packaging materials, please contact Welesgard representative office.

**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"	1 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.***