

### PRODUCT DESCRIPTION

Two-component zinc epoxy primer.

### FEATURE

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

### RECOMMENDED TO USE

Recommended to use as a primer in epoxy systems in:

- environment classes C3-C4 and C5-I/C5-M on blast cleaned steel surfaces (ISO-12944-2),
- Can also be used thinned as a zinc epoxy shop-primer (20 µm).
- Complies with the compositional requirements for SSPC Paint 20 level 2 and ISO 12944.

### COMPATIBLE COATINGS

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

#### Primer:

- WG-WELEFORCE ZINC

#### Top coat:

- Epoxy coating WELEFORCE series.
- Two-component polyurethane coatings SULACOVER 2K series.
- Could be over coated with one component moisture curing coating (MCC).

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

### TECHNICAL DATA

<b>Appearance</b>	
Color:	Bluish Grey
Appearance:	Matt coating
<b>Material properties</b>	
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

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 cleaning. Remove grease and oils by alkali-, emulsion- or solvent cleaning (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) or for maintenance UHPWJ to WJ2 (NACE No.5/SSPCSP).

#### 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

<b>Ambient air temperature:</b>	from +5 to +50°C
<b>Surface temperature:</b>	from +5 to +50°C
<b>Paint Material temperature:</b>	+15°C
<b>Relative humidity, below:</b>	80%
<b>Dew Point</b>	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 wind 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

<sup>1</sup> 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, 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:

When used as a shop-primer, it is necessary to add a thinner WT-011 or WT-012 (slow) no more than 10% by volume.

#### Note:

<sup>1</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:

WT- 011 or WT-012

#### Pot life (+23 °C):

Approx. 8 hours after mixing (induction time approx. 30 min).

### APPLICATION METHODS

Use high pressure airless spray or brush.

#### 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

#### Air spray & Roller

It is not recommended

#### Brush

For touch-up, stripe coating and small areas only. It is necessary to provide a nominal coating thickness.

**PACKAGING**

On the possible volumes of packaging materials, please contact Welesgard.

**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:** 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.