

**PRODUCT DESCRIPTION**

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

**FEATURE**

- Could be applied with dry film thickness up to 1 mm in one layer in the field or factory condition.
- Excellent for immersion or burying.
- Application temperature vary from 5 to +50°C with a brush or spatula.
- Very short drying time.
- Volatile Organic Compound – 0 g/l

**RECOMMENDED TO USE**

Designed for manual application using brush or spatula. Intended for long-term maintenance-free protection of exterior metal and concrete as well as FRP, GRP, RTRP, etc. surfaces of pipes and their joints, fittings, slide valves. Repair of the main Welepipe coating such as mechanical or other damages in reservoirs and tanks as well as other structures immersed in water, buried / underground or laying above-ground.

**COMPATIBLE COATINGS**

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

**Primer:**

- WG-Weleforce JW Primer (for FRP, GRP, RTRP, etc. surfaces).
- Epoxy and zinc containing primers Weleforce series.
- WG-Weleforce Sealer (for concrete surfaces).

**Top coat:**

- Polyurethane coatings WG-Sulacover 2K series.

**(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**

Structural steelwork before coating application has to be prepared according ISO 8501-3 grade P3 or ISO 12944-3 standards.

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. Sa2½ (ISO 8501-1, ISO 8504-2).

**Surface profile:**

Surface profile after cleaning shall correspond to “rough” as per ISO 8503-1 (75-120 µ, Ry5).

**Concrete surface:**

Before application, concrete surface shall be impregnate thoroughly with the primer recommended by Welesgard.

Old concrete shall be washed with water and dried thoroughly before surface preparation will start.

New concrete shall be kept for at least 28 days before surface treatment and coating application.

Uneven surfaces should be smoothed down by grinding. Holes and cracks should be filled with specially designed filler. Abrasive blasting is recommended to remove laitance and other contaminants.

**FRP, GRP, RTRP and similar surfaces:**

The surface must be clean and dry. Contaminated surfaces should be cleaned with a 50/50 Isopropyl Alcohol and water mixture.

Before application, surface shall be impregnate thoroughly with WG-Welepipe JW Primer or other primer recommended by Welesgard Technical Sales Support department.

**AMBIENT  
CONDITIONS****Plural component airless application:**

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

**Note:** 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.
<b>Dry Film Thickness:</b>	500 µm	700 µm	1000 µm
<b>Wet Film Thickness:</b>	500 µm	700 µm	1000 µm
<b>Spreading Rate:</b>	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 painted, roughness of the surface and application method.

**DRYING TIME****At temperature 23°C:**

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

<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**

<b>Resin</b>	3 parts by volume
<b>Curing Agent</b>	1 part by volume

Stir resin and curing agent separately (slow stirring) and then mix both components thoroughly with propeller stirrer. Before use, material packaging temperature 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.

**APPLICATION METHODS**

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

**PACKAGING**

	<b>Volume (litres)</b>	<b>Size of containers (litres)</b>
<b>Component. A</b>	1.5	2
<b>Component. B</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.

<b>Storage temperature:</b>	<b>from 5 to 30°C</b>
<b>Component "A"</b>	1 year
<b>Component "B"</b>	1 year

**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.