

PRODUCT DESCRIPTION

Two-pack, solvent free, high build polyurethane coating

FEATURE

- Could be applied with dry film thickness up to 3 mm in one layer in the field or factory condition.
- Operating temperature up to 60°C.
- Excellent for immersion or burying.
- Application temperature very from -5 to +50°C.
- Very short drying time.
- Volatile Organic Compound – 0 g/l

RECOMMENDED TO USE

Intended for long-term maintenance-free protection of exterior metal and concrete surfaces of pipes and their joints, fittings, slide valves, reservoirs and tanks as well as other structures immersed in water, buried / underground or laying above-ground with operating temperature up to 60°C.

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 Sealer (for concrete surfaces).

Top coat:

- Polyurethane coatings WG-Sulacover 2K series.

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

TECHNICAL DATA

Appearance	
Color:	Grey, Dark Yellow and Black
Appearance:	Semi-gloss coating
Material properties	
Volume solids:	100 ± 2%
Density of the mixture:	1.27 g/cm ³
VOC value:	0 g/l
Temperature resistance:	60°C
Impact strength at 23°C	≥15 J
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=+60°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.

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

Ambient air temperature:	from -5 to +50°C
Surface temperature:	from -5 to +50°C
Paint Material temperature*:	
Component "A":	+40°C
Component "B" not less than:	+15°C
Relative humidity, below:	85%
Dew Point	at least 3°C higher than steel temperature

Note:

* Built-in heater for the base material component shall ensure heating upon application of component A to the temperature +50°C.

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:	500 µm	1500 µm	3000 µm
Wet Film Thickness:	500 µm	1500 µm	3000 µm
Spreading Rate:	2,0 m ² /l	0.67 m ² /l	0.33 m ² /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:**

(Dry Film Thickness 1500 µ)	23°C
Gel time	45 sec.
Dry to touch	< 10 min.
Dry through	< 20 min
Full curing	7 d

¹ 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

Plural component airless spray application:

Should be applied by plural component airless spray unit using proportioning pump capable to supply a volume mixing ratio of 3:1.

Thinning:

Thinning is not allowed.

Cleaner:

Mixer should have a safety valve and additional inlet for flushing with thinner, and for washing equipment off mixed components when work is completed.

Use the cleaner WG-Pipecleaner. Toluene, acetone or their mixture as well as other alcohol-free thinner could be used as the cleaning agent.

When spraying of materials is stopped, wash mixer, whip hose with the thinner within 5-8 sec. Otherwise, whip hose and sprayer will get clogged with material.

APPLICATION METHODS

Plural component airless spray application unit with a proportioning pump capable to supply a volume mixing ratio of 3:1 and built-in heater is recommended only.

Heated hose supplying components from the pump to the mixer shall be heat-insulated to keep the temperature of components. Hose pipe of component "A" shall have inner diameter 3/8", and hose pipe of component "B" shall have inner diameter ¼".

Do not use whip hose longer than 1,5 meters after static mixer.

PACKAGING

	Volume (litres)	Size of containers (litres)
Component. A	200	200
Component. B	200	200

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 year
Component "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.

THE PRESENT TECHNICAL DATA SHEET REPLACES ALL PREVIOUS EDITIONS.