

## WEG TAR FREE WT

<b>PRODUCT DESCRIPTION:</b>	High-build two-component epoxy direct to metal. It provides excellent chemical and corrosion resistance, and good abrasion resistance.
<b>RECOMMENDED USES:</b>	Suitable for highly aggressive environments, providing excellent corrosion protection over steel and concrete (see Surface Preparation). Used inside and outside water storage tanks and piping, it can be applied in a high-build single coat.
<b>CERTIFICATIONS AND APPROVAL:</b>	<p>It complies with standard AWWA C210-15 - Liquid Epoxy Coatings and Linings for Steel Water Pipe and Fittings.</p> <p>It complies with Sabesp standard NTS 036. It complies with the Ministry of Health Directive No. 2914 regarding water for human consumption.</p> <p>It complies with the requirements of Anvisa Resolution No. 105 for contact with non-acid aqueous foods (drinking water).</p> <p>This product complies with regulation GM/MS No. 888 of the Ministry of Health, dated May 4, 2021. This product, when supplied to comply with the RoHs Directive (Restriction of Certain Hazardous Substances) has the letter R in its description.</p>

PACKAGING:	Component	Content	Package	Unit of measurement
	Component A	3,05 16,95	3,6 20	L
	Component B	0,55 3,05	0,9 3,6	L

<b>CHARACTERISTICS:</b>	<b>Color:</b>	Ral, Munsell or as per customer standard.
	<b>Gloss:</b>	Matte
	<b>VOC content:</b>	160 g/l
	<b>Volume solid:</b>	84 ± 2% (ISO 3233).
	<b>Shelf-Life:</b>	24 months at 25°C.
	<b>Thickness per coat (dry):</b>	200 µm –1.000 µm
	<b>Theoretical coverage:</b>	1,35 m <sup>2</sup> /l without dilution in the thickness of 600 µm dry. Without considering loss factors in application.
	<b>Resistance to dry heat:</b>	Maximum temperature 120 °C . The product retains its physical and chemical properties up to the temperature of 120 °C however, variations in the coating color and gloss may occur from 60 °C.

### Drying:

	10°C	25°C	35°C
<b>Touch:</b>	7 hours	3 hours	2 hours
<b>Handling:</b>	15 hours	8 hours	6 hours
<b>Final:</b>	336 hours	240 hours	168 hours

### Overcoating Drying:

	10°C	25°C	35°C
Min	36 hours	16 hours	16 hours
Max	5 days	2 days	2 days

<b>SURFACE PREPARATION</b>	<p>The performance of this product depends on the degree of surface preparation.</p> <p>The surface must be clean, dry and free of any contaminants. Completely remove oils, greases and fats, as described in the SSPC-SP 1 standard.</p>
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The accumulated dirt must be removed using a dry brush, clean and dry cloth, compressed air blow, vacuum cleaner and/or with the combination of such items, and the soluble salts must be removed through wash with a great quantity of fresh water, preferably with low pressure (up to 5,000 psi) according to SSPC-SP 12/NACE No. 5.

### Surface treatment through Abrasive Blasting process

The maximum content of soluble impurities on the blasted surface according to the test described in ISO 8502-6 and distilled water must not exceed a measured conductivity according to ISO 8502-9 corresponding to a maximum content of 20 mg/cm<sup>2</sup> (2 µg/cm<sup>2</sup>) in immersed or buried areas.

Execute the abrasive blasting to near white metal, Sa 2 ½ grade of the ISO 8501-1 visual standard (A Sa 2 ½, B Sa 2 ½, C Sa 2 ½ and D Sa 2 ½) or according to SSPC-SP 10/NACE No. 2, SSPC-VIS 1 visual standard (A SP 10, B SP 10, C SP 10, D SP 10, G1 SP 10, G2 SP 10, G3 SP 10).

It is recommended a roughness profile between 60 and 85 µm.

Inspect the newly blasted surface observing the presence of surface flaws that could become apparent after this stage, adopting appropriate actions to mitigate such defects through grinding, weld filling and/or epoxy putty.

In case of oxidation on the substrate from the end of the abrasive blasting to the beginning of the coating application, the surface must be blasted again until reaching the specified visual standard.

For areas close to sea air, it is necessary to wash the surface with fresh water at low pressure (minimum 3,000 psi) before the abrasive blasting. And in some cases it is necessary to repeat the washing procedure after the abrasive blasting to remove possible soluble contaminants settled on the surface proceeding with a new abrasive blasting.

### Surface treatment through the manual mechanical cleaning process

Execute manual mechanical cleaning for carbon steel surfaces that present the oxidation grades C or D, according to the SSPC-VIS 3 visual standard. For surfaces previously painted that present grades E, F or G according to standard SSPC-VIS 3.

**NOTE:** The manual mechanical cleaning process is only recommended for small areas.

**NOTE:** If it is not possible to execute the manual mechanical cleaning process, as an alternative the surface can be prepared with commercial abrasive blasting, grade Sa 2 of the ISO 8501-1 visual standard (C Sa 2 and D Sa 2) or according to SSPC-SP 6/NACE No. 3, SSPC-VIS 1 visual standard (C SP 6, D SP 6).

Treat the surface mechanically until obtaining at least grade St 3 of the ISO 8501-1 visual standard or according to SSPC-SP 11; the SSPC-VIS 3 visual standard can be used as an aid.

### Application over primer

**NOTE:** Observe the product overcoating interval to apply the next coat. In case the maximum overcoating interval has been exceeded, it is necessary to manually/mechanically sand the surface to break the gloss of the previous coat and clean the sanding residues so as to provide better adhesion between the coats.

### Treatment of Steel Carbon Surfaces

Hard superficial layers (for example, layers resulting from flame cut) must be removed by grinding it before beginning the abrasive blasting.

All the welds must be inspected e, if necessary, be repaired before the ending of the abrasive blasting. Porosity, cavities, weld splashes, etc. must be repaired by means of proper mechanical treatment or weld repair; in the other areas, round the sharp edges ( $r \geq 2 \text{ mm}$ , ISO 8501-3).

### Concrete Surface Treatment

For further information, refer to the Concrete Surfaces Preparation and Application Manual.

Observe the overcoating interval between the coats of the sealer or primer for the application of the product. If the overcoating time is exceeded, sand as described in the sealer or primer data sheet.

This product should be directly applied to a sealer or primer recommended for concrete surfaces, in order to compose a suitable coating system. For the correct application of the sealer/primer, refer to its data sheet.

The performance of this product is related to the degree of surface preparation. The surface must be clean, solid, free of any kind of contaminants, totally dry and rough enough to allow adhesion of the protection system.

No coating of any kind can be directly applied to the concrete floor or subfloor with curing accelerator additives, unless representative tests indicate the possibility of satisfactory adhesion of the coating system.

No type of coating or painting must be applied, without the concrete (or subfloor of sand and cement mortar) being totally dry and cured for at least 28 days in normal climatic condition.

Coatings should not be directly applied to floors contaminated with oil or aggressive products. The floor must be effectively cleaned. In case the application is done over residues of such contaminants, the coating film may come off, and other flaws and defects may occur.

Coating over old concrete only with recommendation of WEG Technical Department.

The application of the product must be carried out as directed by our technical department in order to obtain the best performance. The assessment of factors such as surface conditions, roughness, quantity of contaminants and other characteristics is essential for the proper execution of the surface preparation.

**For further information, consult WEG Technical Department.**

## PREPARATION FOR APPLICATION

### Mixture

Homogenize the contents of each component with mechanical or pneumatic stirring (A and B). Check there are no sediments settled at the bottom of the package. Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

### Mixing ratio (Volume)

5.5 A X 1 B.

### Diluent

**Epoxy diluent 3005**

### Dilution

Depending on the application method, dilute at most 5%

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended dilution percentage.

Only add the diluent after complete mixing of components A + B.

The quantity of diluent may vary depending on the type of equipment used and the ambient conditions during the application.

Excessive dilution of the coating may affect the formation and aspect of the film and not allow to reach the specified thickness.

### Pot life of the mixture (25°C)

1 h 30 min

The pot life is reduced with a higher room temperature.

The pot-life test is performed according to the Brazilian standard ABNT NBR 15742; however, different volumes of coating prepared at once combined with different ambient and coating temperatures will influence the pot life, and different results than those mentioned in this data sheet may be found.

### Induction time (25°C)

No induction time required.

In hot areas, we recommend consulting WEG Technical Department.

## APPLICATION FORMS

**The data below is a guide, and similar equipment may be used.**

In the spray application, make a 50% overlap in each gun pass, concluding with a cross pass. This technique is used to avoid uncovered and unprotected areas and to obtain a suitable aesthetic finish.

Recoat all sharp edges, cracks and weld beads with a brush to prevent premature failures in these areas.

Changes in nozzle sizes and pressures may be necessary to improve spraying characteristics. Before application, check if the equipment and its components are clean and in best condition. Purge the compressed air line to prevent contamination of the coating.

After mixing two-component products, if there are stops in the application, and pot life is exceeded (the coating shows variation in fluidity) it can no longer be diluted for further application.

The data below is a guide, and similar equipment may be used.





**Conventional gun:**

Gun: JGA 502/3 Devilbiss or equivalent  
 Fluid nozzle: EX  
 Air cap: 704  
 Atomization pressure: 50 - 70 psi  
 Pressure in the tank: 10 - 20 psi  
 Dilution: 5%

**Airless Gun:**

Use Airless: Use at least pump 60: 1  
 Fluid pressure: 3500 – 4500 psi  
 Hose: ¼" internal diameter  
 Nozzle: 0,019" - 0,023"

**Brush:**

Only recommended for touch up small areas or stripe coat (screws, nuts, weld and sharp edges). Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for touch up.

**Roller:**

Only recommended for small areas or retouching. Use a thin nap, seamless sheepskin or microfiber roller for epoxy coatings.

**NOTE:**

For application with brush and/or roller, two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.

**Cleaning the equipment:**

Epoxy diluent 3005  
 Clean all equipment immediately after use.

Do not leave catalyzed product in contact with the equipment used in the application, because the coating will vary in fluidity at temperatures above specified in the pot life and will cure faster, making the cleaning difficult.

Furthermore, it is a good working practice to periodically wash the spray equipment along the day. The cleaning frequency will depend on the amount sprayed, temperature and elapsed time, including all delays.

**PERFORMANCE IN THE APPLICATION**

For a good performance of the product, we recommend following the directions below:

Variations in color, aspect and gloss (more noticeable in dark colors) may occur, as well as delay in curing and low coating performance, when applied during periods of high air relative humidity, rainy days, low temperatures or drying the coating outdoor.

Epoxy-based products are known by having excellent anti-corrosion properties and low resistance to sunlight exposure. In situations of exposure of the film to the weather, over time it will present a loss of gloss known as chalking and its shade will change as a consequence. Remember that even undergoing such chalking, the film anti-corrosion protection is not impaired.

In paintings carried out in front of the sea, if exposed to sea air, we recommend to wash with fresh water between coats eliminating settled impurities.

Depending on the application method and conditions, thicknesses of up to 1000 microns can be obtained.

It should not be applied in adverse conditions, such as air relative humidity above 85% or on condensed surfaces. Small variations in color, appearance and gloss of the coated parts may occur in periods of high air relative humidity, rainy days, at low temperatures or in situations where the coated parts are placed to dry outdoors.

The product will change color when placed outdoors and exposed to temperatures above 120 °C, without affecting the anti-corrosion performance.

We recommend coating only if the surface temperature is at least 3 °C above the dew point temperature.

Do not apply the product after the pot life has expired.

For better application properties, the coating temperature should be between 21 - 27 °C prior to the mixing and application.

In coatings with variation in application method in the same job, the final aspect and gloss of the painted surfaces may show differences.

The temperature of the substrate, the weather and environmental conditions during the application and during the curing of the product, and the thickness of the coat may interfere in the product drying time.

This product may present color variations between batches due to component B (catalyst) presenting this characteristic, not compromising the product's performance as it is a primer.

<b>COMPATIBILITY OF SYSTEMS AND MAINTENANCE REFINISHING</b>	<p>For further information, consult WEG Technical Department.</p> <p>The primer overcoating interval should be respected before applying the topcoat. If the maximum recommended overcoating interval is exceeded, manual/mechanical sanding is necessary to break the gloss. The primer surface must be dry and free of any contaminants.</p>
<b>SAFETY PRECAUTIONS</b>	<p>For further information, consult WEG Technical Department.</p> <p>Product developed for industrial use intended for handling by qualified professionals.</p> <p>Please read carefully all the information contained in the MSDS of this product, available at: <a href="http://www.weg.net">www.weg.net</a>.</p> <p>Store in a covered, well-ventilated area. Keep the container tightly closed and away from sources of heat or ignition.</p> <p>Use only in well-ventilated areas avoiding the accumulation of flammable vapors. Keep the product away from heat and sources of ignition.</p> <p>Do not inhale mists / vapors / aerosols generated during handling and / or application.</p> <p>Wear protective gloves / protective clothing / eye protection / face protection.</p> <p>Avoid release this product and its packaging, as well as materials used during handling and application in the environment.</p>

<b>NOTE:</b>	<p>The information contained in this technical datasheet is based upon the experience and knowledge acquired in the field by the technical team of WEG.</p> <p>If using the product without previous inquiry to WEG Coating concerning its suitability for the customer's intended purpose, the customer is aware that the use shall be its exclusive responsibility, WEG not being responsible for behavior, safety, suitability or durability of the product.</p> <p>Some information contained in this datasheet are estimated, and can undergo variances arising from factors outside the manufacturer's control. Thus, WEG does not guarantee and does not assume any responsibility regarding the yield, performance or any other material or personal damage resulting from the incorrect use of the products concerned or the information contained in this Technical datasheet.</p> <p>The information contained in this technical datasheet is subject to periodic modification, without prior notice, due to the policy of evolution and continuous improvement of our products and services, providing solutions with quality to satisfy our customers' requirements.</p>
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