BERGER PROTECTON
PROTECTIVE COATINGS DIVISION

Epilux WR Super Build

Two Pack System Suitably Cured

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Product Description

A high-performance industrial coating for use on steel work intended for use in a wide range of environmental condition including offshore, chemical & petrochemical plants, refineries, industrial buildings, pulp & paper mills, power plants & bridges.

Usage Areas

Recommended for abrasive blasted steel structures that are to be protected from high humid atmosphere and moist environment like cooling water structures; works well even as a direct to metal coating.

Product Data

Composition	Epoxy resin pigmented with Zinc phosphate, suitably/ Micaceous Iron oxide
Volume Solids	87±2%
VOC	115 gms/ltr
Mixing Ratio	Base: Catalyst :: 4:1 (V/V)
Application Method	Brush or Airless Spray
Recommended DFT	350-500 µ per coat
Recommended WFT	402-575 µ per coat
Theoretical Spreading Rate	1.7-2.5 m^2/ltr /coat
Colour	Brownish Grey
Gloss	Semi Gloss

Practical Coverage : Dependent on-site condition and transfer losses due to substrate design, profile, wind, heights, application method, painter's skill etc.

Pot Life

10°C	15°C	25°C	40°C
4 hrs	3 hrs	2 hrs	1.5 hrs

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Typical Coating Systems

Systems compatibility can be provided on request to the Technical Service Team

Coats	Generic Systems	Compatible Products
Primer	Zinc Phosphate Primer	Epilux WR Superbuild Coating
Mid Coat	-	-
Top Coat	Polyurethane, Polysiloxane	Luxathane Polyurethane Finish, Bergerthane 41 SG PU Finish

Conforms to

Performance requirements of SSPC Paint 20 Type II and ISO 12944 with 80% Zinc on dry film by weight.

Pack size

	UOM	Part A	Part B	Total
Volume	Lt/Kg	16 ltr	4 ltr	20 ltr

Storage

The paints must be in its sealed original containers and be kept under cover in a dry place with ambient conditions inside closed room until use. The curing agent is sensitive to moisture and hence relative humidity within the room should be maintained preferably at ≤55%. Stacking should not be more than 3 drums/ cartons one above other. DO NOT expose to direct rain/ sunlight. Any deviation to the defined storage condition shall have a negative effect on the shelf life.

Shelf life

Up to 12 months as long as the sealed original containers are kept under cover in a dry place under normal temperature conditions until use.

Note :

1. Storage life @23°C will be extended up to 24 months. Storage at elevated temperatures may reduce shelf life; and hence never exceed maximum room temperature of 40°C. Storage life, thereafter, subject to re-inspection; consult tech-service.
2. It may be noted that higher volume solid material will tend to soft settling on long term storage, and it can made to a normal homogeneous consistency by use of a slow speed 200-400 rpm power stirrer particularly in the PART A (BASE) container; and this soft settling is not considered as a failure of keeping properties.

Flash Point

Part A	Part B	Mixed Paint
30°C	30°C	30°C

Health & Safety

Please refer to the separate Safety Data Sheet available with detailed information.

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APPLICATION GUIDELINE

Substrate	Mild Steel, Zinc primed steel, Galvanised steel.	
Surface preparation	Steel : Remove grease, oil and other contaminants preferably by Solvent Cleaning to SP 1. Abrasive blast clean to a minimum of SSPC SP10. For severe corrosive conditions, blast to SSPC SP 5 with a surface profile not exceeding 55-75 microns. Thoroughly dust down all surfaces. The surface should be clean and dry before application of primer.Hydro-blasting for maintenance structures is preferred choice where there are heavy deposits of contaminants. Ultra-high pressure hydro-blasting equivalent with light flash rusting as per standards NACE NO. 5 or SSPC SP 12- WJ2 and NV2 as referred in SSPC vis-5 pictorial standard.	
Atmospheric Condition	Ventilation	Suitable air engineering systems, which will ensure reduction of air contaminants and thatto further help regulate the temperature and humidity of the working environment. Ensure surface temperature to be more than 3°C over the dew point temperature.
	Dew Point	Ensure surface temperature to be more than 3°C over the dew point temperature.
	Humidity	Do not apply when relative humidity rises above 85%.
Mixing	Stir the base thoroughly and then mix base to a homogenous liquid and then add recommended part of catalyst to uniform consistency. Allow the mixture to mature for 10 minutes and stir again before and during application. NOTE : DO NOT ADD THINNER beyond recommendation as it will reduce mixed VS calling for revised WFT calculations as well as challenges on flow properties.	
Thinner	Thinner 844	

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Application

Brush : Apply preferably without thinning. However, if required during application, add upto 5% Thinner 844. Brushing is recommended for touching up small areas only.

Airless Spray : Apply preferably without thinning. However, upto 5-7% Thinner 844 may be added if absolutely essential depending on conditions. Use any standard equipment having pump ratio not less than 56:1.
Tip Size : 0.45 - 0.58 mm. **Tip Pressure :** not less than 176 Kg / cm^2 [2500psi]

*Do not apply on hot/ cold surfaces. Always apply within the window of 10-50°C

Work Stoppage

Ensure to use the mixed paint within pot life as there are no methods to increase working pot life. Keep the working tools and tips free of drying and clogging. Always use fresh material and never add-up to previous mixed paints.

Clean Up

Clean all equipment immediately after use with thinner 844. It is good working practices to flush or clean all the spray equipment periodically.All the surplus materials and empty containers should be disposed of in accordance with appropriateregional regulations.

Drying Time

Temperature	Touch dry	Handle dry	Hard dry
10°C	7 hrs	10 hrs	24 hrs
23°C	5 hrs	7 hrs	18 hrs
30°C	3 hrs	5 hrs	12 hrs
40°C	2 hr	3 hrs	9 hrs

Over Coating Intervals

	@23°C	@30°C
MIN	18 hrs	12 hrs
MAX	4 weeks	4 weeks

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Curing Time	7 days NOTE : Drying and Curing times are determined under controlled temperatures and at relative humidity below 85%, for the NDFT of the product.
Inspection	Refer SSPC PA2 guidelines for measurement of DFT. Do not conduct any destructive test like peel off/ pull off & high voltage Holiday test unless and otherwise mandatory in the specification. Consult Technical Service team for preparation of QAP (Quality Assurance plan).
Repair Methodology	Clean off loose paints, debris, contaminants and ensure spot repair with available tools as practiced in hand/ power tool cleaning using wire brush/buffing, emery/feathering to smoothen the edges of impaired areas. Use appropriate touch up primer followed by recommended coating system, allowing due over coating interval time to area of 2-3 inches in excess of the spot repaired portion.
Product Characteristics	• Epilux WR Super Buildis primarily designed for use as a high build primer cum barrier coat to impart reinforced corrosion protection. • The product is capable of being a monocoat system and has compatibility to be over coated with durable finish of polyurethane to add attribute of UV resistance. • Maximum film build in one coat is best attained by airless spray. The required film build is may easily be achieved by adopting wet-on-wet application procedure. Otherwise, it may be necessary to apply multiple coats to achieve the total DFT.
Disclaimer	The information contained within this Data Sheet is based on information believed to be reliable at the time of its preparation. The Company will not be liable for loss or damage howsoever caused including liability for negligence, which may be suffered by the user of the data contained herein. It is the users' responsibility to conduct all necessary tests to confirm the suitability of any product or system for their intended use. No guarantee of results is implied since conditions of use are beyond our control.