

WEICON Ceramic HC 220



wear protection | surface coating | high temperature resistance | drinking water approval according to BS 6920

The epoxy resin system WEICON Ceramic HC 220 provides high abrasion resistance and serves as wear protection for heavily used surfaces.

It is temperature-resistant up to +220 °C, flowable, ceramic-filled, resistant to chemicals and has a high adhesive strength. Ceramic HC 220 can be easily processed with a paint brush and applied to large surfaces. The epoxy resin system is non-corrosive, anti-magnetic and cures practically without shrinkage.

It adheres excellently to various surfaces such as metal, concrete, stone or asphalt. When combined with coarse materials such as silicon carbide in grain sizes of F14-F24, WEICON Ceramic HC 220 serves as an anti-slip coating, enhancing slip resistance in industrial facilities. This combination is perfectly suited for chemical plants and workshops where stairs or floors are contaminated with aqueous solutions.

The product can be used in mechanical and plant engineering, in equipment engineering, and in many other areas of industry where high temperature loads are part of daily work.

Characteristics

| | |
|--------------------|-------------------------------------|
| Base | Epoxy |
| Filler | silicon carbide, zirconium silicate |
| Texture | flowable |
| Colour | dark grey |
| Minimum shelf life | at room temperature 36 mon. |

Note

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WEICON Middle East L.L.C.
United Arab Emirates
phone +971 4 880 25 05
info@weicon.ae

WEICON Inc.
Canada
phone +1 877 620 8889
info@weicon.ca

WEICON Czech Republic s.r.o.
Czech Republic
phone +42 (0) 417 533 013
info@weicon.cz

WEICON Ibérica S.L.
Spain
phone +34 (0) 914 7997 34
info@weicon.es

WEICON GmbH & Co. KG
(Headquarters) Germany
phone +49 (0) 251 9322 0
info@weicon.de

WEICON Italia S.r.l.
Italy
phone +39 (0) 010 2924 871
info@weicon.it

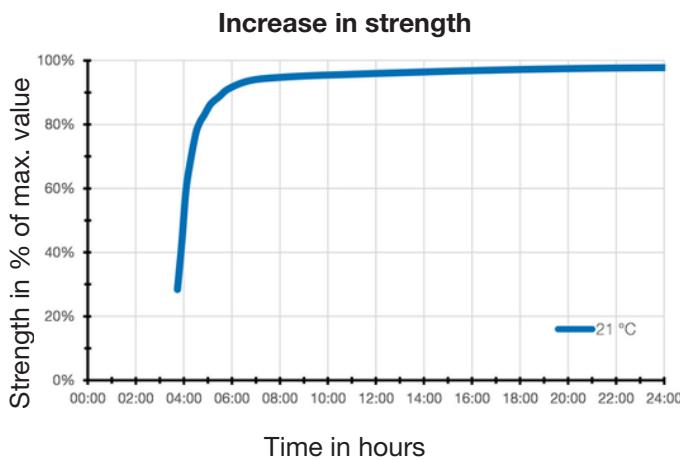
WEICON Romania SRL
Romania
phone +40 (0) 3 65 730 763
office@weicon.com

WEICON SA (Pty) Ltd
South Africa
phone +27 (0) 21 709 0088
info@weicon.co.za

WEICON South East Asia Pte Ltd
Singapore
Phone +65 6710 7671
info@weicon.com.sg

WEICON Kimya Sanayi Tic. Ltd. Şti.
Türkiye
phone +90 (0) 212 465 33 65
info@weicon.com.tr

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Instructions for use

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets (www.weicon.com) must be observed.

Surface Pre-Treatment

The successful application of WEICON Ceramic HC 220 depends on the thorough preparation of the surfaces. This is the most important factor for overall success. Dust, dirt, oil, grease, rust and moisture or wetness have a negative impact on the adhesion. Therefore, before processing WEICON Ceramic HC 220, the following points must be observed: The surfaces must be free of any oil, grease, dirt, rust, oxides, paint and other impurities or residues. For cleaning and degreasing, we recommend WEICON Cleaner Spray S.

Smooth and particularly heavily soiled surfaces should additionally be treated by mechanical surface pre-treatment, e.g. by grinding or preferably by blasting. In case of blasting, the surface should be brought to a degree of purity of SA 2 1/2 - "Near White Blast Cleaning" (according to ISO 8501/1-2, NACE, SSPC, SIS). In order to achieve an optimum surface roughness of 75 - 100 µm, angular, disposable blasting media (aluminum oxide, corundum) should be used. The surface quality is negatively influenced by the use of reusable blasting media (slag, glass, quartz), but also by ice blasting. The air for blasting must be dry and oil-free. Metal parts that have come into contact with sea water or other salt solutions should first be rinsed thoroughly with demineralised water and, if possible, left to rest overnight so that all salts can be dissolved from the metal. Before each application of WEICON Ceramic HC 220, a test for soluble salts should be carried out according to the Bresle method (DIN EN ISO 8502-6). The maximum amount of soluble salts remaining on the substrate should not exceed 40 mg/m². Heating and repeated blasting of the surface may be necessary to remove all soluble salts and moisture. After each mechanical pre-treatment, the surface should be cleaned again with WEICON Cleaner Spray S and protected from further contamination until the coating is applied. Areas where no adhesion to the substrate is desired must be treated with silicone-free mould release agents. For smooth surfaces, we recommend WEICON Mould Release Agent Liquid F 1000 or, for porous surfaces, WEICON Mould Release Agent Wax P 500. After the surface pre-treatment, WEICON Ceramic HC 220 should be applied as soon as possible (within one hour) to avoid oxidation, flash rust or new contamination.

Mixing

First, stir the resin. Then mix the resin and hardener together thoroughly and bubble-free for at least four minutes at 20 °C (68 °F). The included processing spatula or a mechanical mixer, such as the Stirrer Stainless Steel, can be used for this purpose. With mechanical mixers, a low speed of max. 500 rpm should be used. The components should be stirred until a homogeneous mixture is achieved. The mixing ratio of

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Spain
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the two components must be strictly observed, as otherwise, strongly deviating physical values will result (max. deviation +/- 2%). Only prepare a batch as large as can be processed within the pot life of 45 minutes. The indicated pot life time refers to a material batch of 500g and 20 °C (68° F) material temperature. Mixing larger quantities or higher processing temperatures will result in faster curing due to the typical reaction heat of epoxy resins.

Application

For processing, we recommend an ambient temperature of 20 °C (68 °F) at less than 85% relative humidity. The highest adhesive strength is achieved when the parts to be processed are heated to >35 °C (>95 °F) before application. For a thin pre-coat, work WEICON Ceramic HC 220 intensively into the surface in crosswise layers using a paint brush to achieve maximum adhesion. By means of this technique, the epoxy resin penetrates well into all cracks and roughness depths. Afterwards, a second application with a paint brush or foam roller can be carried out straight away, until the desired layer thickness is reached. A layer of approx. 0,25 to 0,50 mm can be achieved per work step. Make sure that the epoxy resin is applied evenly and without air bubbles. Further coats can be applied in each case after approx. 4 hours (layer sequence time).

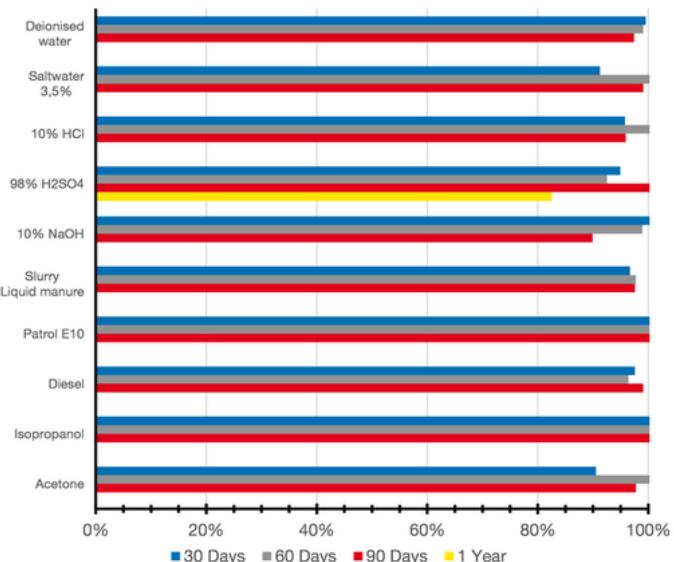
Curing

Final hardness is reached after 10 hours at 20 °C (68 °F) at the latest. At lower temperatures, the curing can be accelerated by evenly applying heat up to max. 40 °C (104 °F), e.g. with a heating pack, hot air blower or fan heater. Higher temperatures shorten the curing time. The following rule of thumb applies: Each increase by +10 °C (50 °F) above room temperature (20 °C/68 °F) will decrease the curing time by half. Temperatures below 16 °C (61 °F) increase the curing time, until at approx. 5 °C (41 °F) and below, almost no reaction will take place at all.

Storage

WEICON Epoxy Resin Systems should be stored in a dry place at room temperature. Unopened containers can be stored at temperatures from +18 °C to +28 °C. Opened containers must be used up within 6 months.

Tensile strength after storage



Scope of delivery

Processing Spatula | Instructions for use | Gloves | Resin & Hardener

Accessories

| | |
|----------|---------------------------------------------------------|
| 10000147 | Cleaner Spray S, 500 ml, transparent |
| 10000347 | Cleaner S, 5 L, colourless, transparent |
| 10024313 | Surface Cleaner, 400 ml, transparent |
| 10025288 | Surface Cleaner, 5 L, transparent |
| 10026647 | Mould Release Agent Liquid F 1000, 250 ml, white, milky |
| 10026712 | Mould Release Agent Wax P 500, 150 g |
| 10053995 | Repair Stick Multi-Purpose, 115 g, vintage white |
| 10000913 | Glass Fibre Cloth Tape, 1 PCE, white |
| 10010887 | Processing Spatula, 1 PCE |
| 10022562 | Processing Spatula, 1 PCE |
| 10059417 | Brush 35 short, flat, Plastic Metal, 1 PCE |
| 10001978 | Stirrer Stainless Steel, 1 PCE |
| 10016002 | Pump Dispenser WPS 1500, 1 PCE |
| 10002034 | Empty cartridge, 1 PCE |
| 10039667 | Cable Scissors No. 35, 1 PCE |
| 10045523 | Processing Kit, 1 PCE |

Recommended equipment

| | |
|---------------------------|-----------------|
| Angle grinder | PE film 0.2 mm |
| Blast machine | Fabric tape |
| Heat pocket | Brush |
| Hot or fan heater | Foam roller |
| Smoothing trowel, spatula | Lint-free cloth |

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Conversion table

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
mm/25.4 = inch
 $\mu\text{m}/25.4 = \text{mil}$
N x 0.225 = lb
N/mm² x 145 = psi
MPa x 145 = psi

Nm x 8.851 = lb·in
Nm x 0.738 = lb·ft
Nm x 141.62 = oz·in
mPa·s = cP
N/cm x 0.571 = lb/in
kV/mm x 25.4 = V/mil

Available sizes

10060702 WEICON Ceramic HC 220, 200 g, dark grey
10060705 WEICON Ceramic HC 220, 0,5 kg, dark grey
10060707 WEICON Ceramic HC 220, 2 kg, dark grey

| | WEICON A | WEICON B | WEICON BR | WEICON C | WEICON F | WEICON F2 | WEICON HB 400 | WEICON HT 111 | WEICON SF | WEICON ST | WEICON TI | WEICON UW | WEICON WR2 | WEICON HP | WEICON Fire Safe | WEICON Anti-Static | WEICON Food Grade | WEICON Anti-Stick | WEICON Ceramic BL | WEICON GL | WEICON GL-S | WEICON Ceramic W | WEICON Ceramic HC 220 | WEICON WP | WEICON WR | WEICON CBC |
|---------------------------------------------------------------------------------|----------|----------|-----------|----------|----------|-----------|---------------|---------------|-----------|-----------|-----------|-----------|------------|-----------|------------------|--------------------|-------------------|-------------------|-------------------|-----------|-------------|------------------|-----------------------|-----------|-----------|------------|
| Repair and moulding | x | x | x | x | x | x | x | x | x | x | x | x | x | | | | | | | | | | | | | |
| Adhesive | | | | x | x | | x | x | | x | | | | x | x | | | | | | | | | | | |
| Wear, erosion and corrosion protection – abrasion-resistant coating | | | | | | | | | | | | | | | | x | x | x | x | x | x | x | x | x | | |
| Casting, relining and gap compensation – casting and injecting potting compound | x | | | | | x | | | | | | | x | | | | | | | | | | x | x | | |

To the product detail page:



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(Headquarters) Germany
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phone +34 (0) 914 7997 34
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phone +39 (0) 010 2924 871
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South Africa
phone +27 (0) 21 709 0088
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Chemical resistance after curing* (Excerpt)

| | | | |
|---------------------------------------------------|---|------------------------------------------------|---|
| Exhaust fumes | + | Potassium carbonate | + |
| Acetone | o | Potassium hydroxide 0-20 % (caustic potash) | + |
| Ethyl ether | + | Milk of lime | + |
| Ethyl alcohol | o | Carbolic acid | - |
| Ethylbenzene | - | Creosote oil | - |
| Alkalies (alkaline substances) | + | Cresylic acid | - |
| Hydrocarbons, aliphatic (petroleum derivatives) | + | Magnesium hydroxide | + |
| Formic acid >10 % (methanoic acid) | - | Maleic acid (cis-ethylenedicarboxylic acid) | + |
| Ammonia anhydrous 25% | + | Methanol (methyl alcohol) <85 % | - |
| Amyl acetate | + | Mineral oil | + |
| Amyl alcohol | + | Naphthalene | - |
| Hydrocarbons, aromatic (benzene, toluene, xylene) | + | Naphthene | - |
| Barium hydroxide | + | Sodium carbonate (soda) | + |
| Petrol (92-100 octane) | + | Sodium bicarbonate (sodium hydrogen carbonate) | + |
| Hydrobromic acid <10 % | + | Sodium chloride (table salt) | + |
| Butyl acetate | + | Sodium hydroxide >20 % (caustic soda) | o |
| Butyl alcohol | + | Caustic soda | + |
| Calcium hydroxide (slaked lime) | + | Heating oil, diesel | + |
| Chloroacetic acid | - | Oxalic acid <25 % (ethanedioic acid) | + |
| Chloroform (trichlormethane) | o | Perchloroethylene | o |
| Chlorosulphuric acid (wet and dry) | - | Kerosene | + |
| Chlorinated water (swimming pool concentration) | + | Oils, vegetable and animal | + |
| Hydrochloric acid | + | Phosphoric acid <5% | + |
| Chromium bath | + | Phthalic acid, phthalic anhydride | + |
| Chromic acid | + | Crude oil | + |
| Diesel fuels | + | Nitric acid <5% | o |
| Mineral oil and mineral oil products | + | Hydrochloric acid <10 % | + |
| Acetic acid diluted <5% | + | Sulphur dioxide (wet and dry) | + |
| Ethanol <85 % (ethyl alcohol) | + | Carbon disulphide | + |
| Greases, oils and waxes | + | Sulphuric acid <98 % | + |
| Hydrofluoric acid diluted | o | White spirit | + |
| Tannic acid diluted <7% | + | Carbon tetrachloride (tetrachloromethane) | + |
| Glycerin (trihydroxipropane) | + | Tetralin (tetrahydronaphthalene) | o |
| Glycol | o | Toluene | - |
| Humic acid | + | Trichloroethylene | o |
| Impregnating oils | + | Hydrogen peroxide <30 % (hydrogen superoxide) | + |
| Potash | + | Xylene | - |

+ = resistant 0 = for a limited time - = not resistant *The storage of all WEICON Plastic Metal types was carried out at +20°C chemical temperature.

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