Epoxy Resin Systems
Plastic Metal

WEICON WP

Pasty | high strength | ceramic-filled | extremely high resistance against abrasion and wear |residual elasticity and impact-resistant

WEICON WP serves as protection for highly stressed surfaces. A coating with the epoxy resin system offers high strengths against wear and abrasion and is extremely resistant to chemicals. Plastic Metal WEICON WP prevents metal loss and replaces previously applied wear-resistant alloys, ceramic tiles and rubber linings as well as welded metal coatings. It can be used either for the regeneration of worn metal surfaces or as a wear-resistant coating. A particularly high level of protection is achieved when the wear is caused by particles hitting sideways.

Characteristics		
Base		Epoxy
Filler		Ceramicbeats
Texture		pasty
Colour		grey
Minimum shelf life	at room temperature	36 mon.
Processing		
Processing temperature		+15°C to +40°C
Component temperature		>3 °C above dew point
Relative air humidity		< 85 %
Mixing ratio by weight		100:100
Mixing ratio by volume		100:100
Viscosity of the mixture	at +25 °C	900.000 mPa·s
Density of the mixture		2,2 g/cm³
Consumption	Layer thickness 1.0 mm	2.2 kg/m²
Max. layer thickness	per step	20 mm
Curing		
Pot life	at 20 °C, 2 kg batch	30 min.
Additional layer after	(35 % strength)	7 h
Working strength after	(80 % strength)	12 h
Final strength	(100 % strength)	36 h
Shrinkage		0,11 %

Mechanical properties after curing		
- Measured after curing at		24 h RT + 4 h +60 °C
Tensile strength	DIN EN ISO 527-2	23 MPa
Elongation at break (tensile)	DIN EN ISO 527-2	3,8 %
E-modulus (tensile)	DIN EN ISO 527-2	2500-2900 MPa
Compressive strength	DIN EN ISO 604	51 MPa
Bending strength	DIN EN ISO 178	35 MPa
Impact strength	DIN EN ISO 179-1/1eU	12 kJ/m²
Hardness (Shore D)	DIN ISO 7619	75±3
Adhesive strength	DIN EN ISO 4624	24 MPa
Taber Test	DIN ISO 9352 (H18, 1 kg, 1000 rotations)	0,5 g / 0,2 cm³
Thermal parameters		
Temperature resistance		-35°C (-4°F) to +120°C (+248°F)
Tg after curing at room temperature	(DSC)	~ +64 °C
Tg after tempering (at 90°C)	(DSC)	+87 °C
Heat deflection resistance	DIN EN ISO 75-2	+65 °C
Thermal conductivity	DIN EN ISO 22007-4	0,8 W/m·K
Heat capacity	DIN EN ISO 22007-4	0,78 J/(g·K)
Electrical parameters		
Resistance	DIN EN 62631-3-1	2,2·10¹¹ Ω·m
Magnetic		no
Approvals / Guidelines		
IMPA Code		812957/58

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 WP 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 WP, the following points must be observed: The areas to be bonded or repaired 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 ½ - "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

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and, if possible, left to rest overnight so that all salts can be dissolved from the metal. Before each application of WEICON WP, 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 WP 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 a mortar stirrer, 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 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 30 minutes. The specified pot life refers to a material batch of 2 kg 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.

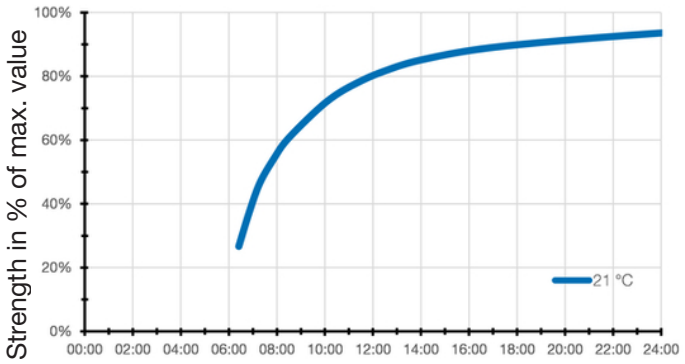
Application

For processing, we recommend an ambient temperature of 20°C (68 °F) at less than 85% relative humidity. For a thin pre-coat, work WEICON WP intensively into the surface in crosswise layers using the Contour Spatula Flexy to achieve maximum adhesion. By means of this technique, the epoxy resin penetrates well into all cracks and roughness depths. Afterwards, further applications can be carried out straight away, until the desired layer thickness is reached. Make sure that the epoxy resin is applied evenly and without air bubbles. To fill large gaps or holes, expanded metal or other mechanical fixing materials should be used. Finally, the surface can be smoothed easily with the help of a PE film and a rubber roller.

Curing

Final hardness is reached after 36 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.

Increase in strength



Time in hours

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.

Scope of delivery

Processing Spatula | Contour Spatula Flexy | 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 short, 1 PCE
10022562	Processing Spatula long, 1 PCE
10016002	Pump Dispenser WPS 1500, 1 PCE
10039667	Cable Scissors No. 35, 1 PCE
10045523	Processing Kit, 1 PCE

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Recommended equipment

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

Conversion table

(°C x 1.8) + 32 = °F
mm/25.4 = inch
µm/25.4 = mil
N x 0.225 = lb
N/mm^2 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

10032320 WEICON WP, 2 kg, grey
10032939 WEICON WP, 10 kg, grey
10054399 WEICON WP, 200 g, grey

	WEICON A	WEICON B	WEICON BR	WEICON C	WEICON F	WEICON F2	WEICON HB 300	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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Chemical resistance after curing* (Excerpt)

1,4-Dioxane	-	Glycol	+
Exhaust fumes	+	Uric acid	-
Adipic acid	-	Impregnating oils	+
aliphatic hydrocarbons	+	Iodides (K, Na etc.)	-
Formic acid >10 % (methanoic acid)	-	Potassium carbonate	+
Ammonia anhydrous 25%	-	Potassium hydroxide 0-20 % (caustic potash)	+
Aniline	-	Milk of lime	+
aromatic hydrocarbons	+	Cresol	-
Barium hydroxide	+	Magnesium hydroxide	+
Benzoic acid	-	Maleic acid (cis-ethylenedicarboxylic acid)	-
Benzyl alcohol	-	Methanol (methyl alcohol) <85 %	o
Benzyl chloride	-	Methylene chloride	-
Boric acid	-	Mineral oil	+
Bromides	-	Naphthalene	+
Butadiene (1,3-)	-	Sodium bicarbonate (sodium hydrogen carbonate)	+
Butyric acid	-	Sodium carbonate (soda)	+
Butyl acetate	o	Sodium chloride (table salt)	+
Butyl alcohol	o	Nitrates	-
Calcium hydroxide (slaked lime)	+	Nitrobenzene	-
Chloroanilines	-	Oils, vegetable and animal	+
Chloroform (trichlormethane)	-	Oxalic acid <25 % (ethanedioic acid)	o
Chlorosulphuric acid (wet and dry)	-	Perchloraethylene	-
Chlorosilanes	-	Kerosene	+
Chlorinated water (swimming pool concentration)	-	Phenol	-
Chromates (K, Na, etc.)	-	Phosphoric acid <50%	+
Chromic acid	-	Phthalic acid, phthalic anhydride	-
Cyanides (K, Na etc.)	-	Nitric acid <5%	-
Cyclohexanone	-	Sulphur dioxide (wet and dry)	-
Diethyl ether	+	Carbon disulphide	-
Mineral oil and mineral oil products	+	Sulphuric acid <5%	+
Acetic acid diluted <5%	o	Soap solution	+
Ethanol <85 % (ethyl alcohol)	o	Turpentine	+
Greases, oils and waxes	+	Carbon tetrachloride (tetrachloromethane)	-
Hydrofluoric acid	-	Tetralin (tetrahydronaphthalene)	-
Tannic acid diluted <7%	o	Trichloraethylene	-
Glycerin (trihydroxipropane)	+	Hydrogen peroxide <30 % (hydrogen superoxide)	o

+ = 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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