Epoxy Resin Systems
Plastic Metal

WEICON WPG-19

extreme wear protection | pasty | fibre-reinforced | ceramic-filled

WEICON WPG-19 is a fibre-reinforced, ceramic-filled, 2-component epoxy resin system. It is used as wear protection in industrial applications. The grey coating contains ceramic beads up to two millimetres in size and protects surfaces against erosion and abrasion caused by the impact of coarse particles. The system can be applied with a spatula. It is viscoplastic, highly impact-resistant and extremely resistant to abrasion. It is used for coating and lining various surfaces and components in industrial plants. It is used, for example, to protect gutters, bends, hoppers, tanks, chutes and many other processing systems that are exposed to abrasion and impact.

Characteristics		
Base		Epoxy
Colour		grey
Processing		
Component temperature		>3 °C above dew point
Mixing ratio by weight		1:1
Density of the mixture		2,2 g/cm³
Curing		
Pot life	at 20 °C, 500 g batch	60 min.
Additional layer after	(35 % strength)	7 h
Working strength after	(80 % strength)	24 h
Final strength	(100 % strength)	42 h
Shrinkage		0,17 %
Mechanical properties after curing		
- Measured after curing at		24 h RT + 24 h 60 °C
Tensile strength	DIN EN ISO 527-2	23 MPa
Elongation at break (tensile)	DIN EN ISO 527-2	1,1 %
E-modulus (tensile)	DIN EN ISO 527-2	2.500 - 3.200 MPa
Hardness (Shore D)		82±3
Taber Test	DIN ISO 9352 (H18, 1 kg, 1000 rotations)	0,5g 0,22 cm²
Lap shear strength material thickn. 1,5mm DIN EN 1465		
Steel 1.0338 sandblasted		6 MPa
Stainless steel V2A sandblasted		6 MPa
Approvals / Guidelines		
MIL-Spec	complies with	MIL-T-83523

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 WPG-19 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 WPG-19, 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 and, if possible, left to rest overnight so that all salts can be dissolved from the metal. Before each application of WEICON WPG-19, 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 WPG-19 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

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(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 60 minutes. The specified pot life refers to a material batch of 500 g 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 WPG-19 thoroughly 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 42 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.

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, 1 PCE
10022562	Processing Spatula, 1 PCE
10016002	Pump Dispenser WPS 1500, 1 PCE
10039667	Cable Scissors No. 35, 1 PCE
10045523	Processing Kit, 1 PCE

Recommended equipment

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

Conversion table

(°C x 1.8) + 32 = °F	Nm x 8.851 = lb·in
mm/25.4 = inch	Nm x 0.738 = lb·ft
µm/25.4 = mil	Nm x 141.62 = oz·in
N x 0.225 = lb	mPa·s = cP
N/mm^2 x 145 = psi	N/cm x 0.571 = lb/in
MPa x 145 = psi	kV/mm x 25.4 = V/mil

Available sizes

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