

WE-6221

Offshore Tower Coating – Wind Energy

GENERAL DESCRIPTION

WE-6221 is an innovative, color stable and abrasion resistant coating designed specifically to withstand the rigors of long-term offshore exposure. This 100% solids, zero VOC coating system is approved for salt water immersion, splash zone, and the most severe atmospheric corrosion (C5-m). This easy to apply, two coat system provides long term, maintenance free protection for offshore wind towers and nacelles.

FEATURES

- Environmentally friendly, Zero VOC coating system
- Outstanding UV resistance and color stability
- Excellent adhesion to metal, concrete or composite substrates
- Designed for superior longevity with excellent flexibility and abrasion and impact resistance
- May be applied by hand or airless spray equipment

PACKAGING

½ gallon, 1 gallon, 2 gallon and 4 gallon kits

COVERAGE

WE-6221 has the consistency of thick paint and can be applied up to 40 mils per coat. Theoretical coverage at 40 mils is 40 square feet per gallon.

MIXING RATIO

4.1 parts base (B) to 1 part (A) hardener by weight
5 parts base (B) to 2 part (A) hardener by volume

POT LIFE

For a ½ gallon unit, mixed at 70°F, pot life is approximately 70 minutes. Higher temperatures or larger mass will shorten this time, lower temperatures or smaller mass will extend it. Pot life can also be extended by spreading the mass out to dissipate heat.

COLORS

WE-6221 is available in a variety of colors.

TECHNICAL DATA AND INFORMATION

Physical Properties of Cured System:

Density	1.49 g/mL
% Solids	100
Flexural Strength @ 70°F	22,100 psi
Tensile Strength @ 70°F	13,100 psi
Tensile Shear @ 70°F	2,800 psi
Adhesion (Steel)	>2000 psi
Adhesion (Concrete)	>700 psi
Abrasion Resistance ¹	4.9 mg lost
Impact Resistance	158 in lbs
Color Retention ²	Excellent
60° Gloss Retention ²	Excellent
Hardness	82 – 79 Shore D

¹ ASTM D 4060 Taber Abrasion Test, CS 17 wheel with 1 kg weight. Weight lost per 500 cycles.

² ASTM G154 Accelerated Weathering. After 720 hours exposure.

SURFACE PREPARATION

- For maximum adhesion, material should be applied to a firm, clean, dry and abraded surface.
- Best results will be obtained by abrasive blasting the surface.
- If blasting is impractical, a grinding wheel, needle gun, or very stiff wire brush may be used.
- Clean greasy, oily or waxed surfaces with suitable solvent before applying material.

MIXING

For standard kits mix ALL of Part A with ALL of Part B. Pour Part A into Part B bucket and mix for 5 minutes while scraping down the sides. Duromar recommends boxing material to ensure adequate mixing.

CLEANUP

Most solvents and commonly used thinners such as MEK, acetone and xylene can be used for cleaning tools and equipment. Duromar also supplies a non-flammable, non-hazardous safety solvent **Duromar T-1** which can be used. **DO NOT USE TO THIN MATERIAL FOR APPLICATION.**

APPLICATION

WE-6221 is best applied by airless spray equipment or by hand with a roller or brush.

- Min. Thickness/Coat (mils) 15
- Max. Thickness/Coat (mils) 40
- Number of Coats 1-2
- Min. Application Temperature (°F) 55

For best results, do not apply:

- When humidity is over 90%
- When there is moisture on the surface
- When surface temperature is not 5 °F above dew point

OVERCOATING

For thicker coating and repairs, two or more coats may be employed. **WE-6221** can be overcoated with most Duromar high performance materials. In high humidity or cold temperatures a blush may develop which should first be wiped down with clean water. The following table is an approximate guide to the earliest and latest times an overcoat may be applied:

WE-6221 Overcoating Window:

55°F	70°F	85°F
12 - 96 h	6 - 48 h	4 - 24 h

At 70 °F, if 48 hours have elapsed the surface must be roughened before overcoating. The preferred method is a light abrasive brush blasting, light sanding, grinding or wire brushing.

CURING SCHEDULE

Temperature	50 °F	70 °F	90 °F
Dry to Touch	14 hours	6 hours	3 hours
Functional Cure	48 hours	24 hours	12 hours
Full Cure	120 hours	96 hours	48 hours

Q/C

The material should be visually inspected just after application and touched up where necessary.

STORAGE/SHELF LIFE

Store in dry area in closed containers between 50 °F and 100°F. Shelf life at these conditions is greater than one year.

HEALTH AND SAFETY

READ AND UNDERSTAND ALL MATERIAL GIVEN IN THE MSDS SHEETS BEFORE USING THE PRODUCT.

WE-6221 DOES NOT CONTAIN ANY FLAMMABLE MATERIAL OF ANY KIND. HOWEVER, THE MATERIAL IS COMBUSTIBLE. IN THE EVENT OF A FIRE, DRY POWDER, FOAM, OR CARBON DIOXIDE FIRE EXTINGUISHERS SHOULD BE USED. FIRE FIGHTERS SHOULD WEAR RESPIRATORS.

USE PROTECTIVE GLOVES AND EYEGLASSES WHEN USING.

USE IN AREAS OF GOOD VENTILATION.

LIMITED WARRANTY

All recommendations covering the use of this product are based on past experience and laboratory findings. Methods or conditions of application and use of the product are beyond our control. We assume responsibility only for the uniformity of our product within normal manufacturing balances.

All Duromar products are formulated based on over 25 years of experience, laboratory tests, material data, field installations, and technical publications, which we believe to be, to the best of our knowledge, accurate and reliable. This information is intended to be used for guidance only. Because the only true reliable test is one that is in actual operation, Duromar will make available at no charge samples of materials for that testing purpose. Duromar, Inc. has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. Duromar, Inc. does, therefore, not accept any liability arising from loss, injury, or damage resulting from such use or the contents of this data sheet (unless there are written agreements stating otherwise). The data contained herein is liable to modification as a result of practical experience and continuous product development. This data sheet replaces and annuls all previous issues, and it is, therefore, the user's responsibility to ensure that this sheet is current prior to using the product.

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