



Protective & Marine Coatings
PRODUCT DATA SHEET

MACROPOXY™ 250
UNIVERSAL EPOXY PRIMER

(FORMERLY WATTYL EPINAMEL PR250)

Revised: May 26th, 2020

PRODUCT DESCRIPTION

MACROPOXY 250 is a multi-functional adhesion promoting polyamide cured epoxy primer for the protection of steel, pigmented with aluminium flake (Olive Green only) or Optical Active Pigment (OAP) (Blue only).

INTENDED USES

- Suitable for the protection of structural steel in a wide range of environments including marine, heavy industrial, and C1 to C5 as defined in AS/NZS 2312 and ISO12944.
- Primer for structural steel on blast cleaned steel for internal and external environments.

PRODUCT DATA

Volume Solids:	55% ± 2%, mixed
VOC (mixed):	Unreduced <450 g/L Reduced 10% <550 g/L (Calculated according to APAS AP-D181)
Finish:	Semi-Gloss
Colours:	Off White, Olive Green (with Aluminium) and Blue (with OAP)
Mix Ratio:	4:1 by volume

Typical Thickness:

Recommended Spreading Rate Per Coat

	Minimum	Maximum
Wet microns	90	365
Dry microns	50	200

Theoretical coverage m²/L @ typical dft (75 micron) 7.3
NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

Shelf Life: at least 12 months, unopened, stored indoors between 5°C and 35°C

Flash Point: 24°C, mixed

Reducer/Clean Up: Thinner L760

Weight: 1.39 Kg/L mixed

Packaging: 5 L kit mixed or 20 L kit mixed
Part A: 4 L (in 5 L can) 16 L (in 20 L container)
Part B: 1 L 4 L

Average Drying Times @ 135 microns wet:

	<i>with standard hardener</i>			
	5°C	15°C	25°C	35°C
	50% RH			
Touch	8 hours	3 hours	1.5 hour	0.75 hour
Handle	12 hours	6 hours	2.5 hours	1.5 hour
Recoat				
- Minimum	36 hours	16 hours	8 hours	6 hours
- Maximum*	3 months	3 months	3 months	2 months
Cure to Service				
- Atmospheric	21 days	10 days	7 days	5 days
Pot Life	16 hours	10 hours	6 hours	3 hours
Induction Time	None Required			

	<i>with low temperature hardener</i>			
	5°C	15°C	25°C	35°C
	50% RH			
Touch	5 hours	2 hours	1 hour	0.75 hour
Handle	7 hours	3 hours	1.5 hours	1 hour
Recoat				
- Minimum	12 hours	6 hours	3 hours	2 hours
- Maximum*	28 days	21 days	14 days	7 days
Cure to Service				
- Atmospheric	9 days	5 days	3 days	2 days
Pot Life	10 hours	6 hours	3 hours	1.5 hours
Induction Time	None Required			

*Drying time is temperature, humidity, and film thickness dependent. Paint temperature must be at least 5°C.
* Maximum overcoating interval is double the stated time above, for coatings **NOT** exposed to direct sunlight.*

SURFACE PREPARATION

Product performance is dependent upon degree of surface preparation. Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Minimum recommended surface preparation:

Iron & Steel:	Atmospheric:	Power tool clean (AS 1627.2) to St 2 minimum (AS1627.9) – power tool cleaning is only recommended for small areas and/or maintenance work. For optimum system performance, abrasive blast cleaning is recommended. Blast clean (AS 1627.4) to Sa 2½ minimum (AS 1627.9), 40-70 micron profile, or Wet blast clean to achieve surface similar to Sa 2½ minimum (AS1627.9), 35-50 micron profile.
	Immersion:	Blast clean (AS 1627.4) to Sa 2½ minimum (AS 1627.9), 40-70 micron profile
Galvanizing:	Atmospheric:	Lightly blast using an inert grit, or power tool clean, to achieve a roughened uniform flat appearance
Aluminium	Atmospheric:	Lightly blast using an inert grit, to achieve a surface profile of 35-50 microns, or Mechanically abrade using 80 grit paper/disc
Stainless Steel	Atmospheric:	Lightly blast using an inert grit, to achieve a surface profile of 35-50 microns, or Mechanically abrade using 80 grit paper/disc
Concrete & Masonry:	Atmospheric:	Must be free from bond breakers, curing agents or any other contaminants that may interfere with adhesion. Blast clean to remove all laitance (acid etch can be used to remove all laitance – for atmospheric exposure only). Concrete should be treated as per AS/NZS 2311. Moisture content of concrete should be a max. 4%. Ensure all new concrete is fully cured prior to coating; typically, this may take a minimum of 4-6 weeks. Test pH to ensure a value of less than 9. Must be absorbent prior to coating. Final finish will vary depending upon the surface profile of the concrete.

