INERTA 205

Epoxy coating

INERTA 205 is a two-pack, solvent-free epoxy coating based on liquid epoxy resin.

Use: On steel surfaces. Suitable also on concrete surfaces.

INERTA 205 has good adhesion to blast-cleaned steel (grade Sa 2½), to aluminium and concrete. It has excellent abrasion resistance. The coating has good resistance to water, chemical solutions, grease and certain solvents even on immersion. In water immersion the temperature must not be over +40°C. For other chemicals the highest temperature allowed is defined individually.

TECHNICAL DATA

Recommended substrate	Steel
Binder	Epoxy
Solids	Approx. 100% by volume
Total mass of solids	Approx. 1500 g/l
Volatile organic compound (VOC)	(For mixed product, base and hardener ratio 2:1) Approx. 0 g/l (Theoretical, according to IED 2010/75/EU) 39 g/l (Tested according to China GB/T 38597-2020)
Theoretical spreading rate	

Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m^2/l)
125	125	8.0
200	200	5.0

As many of the paint's properties will change if too thick coats are applied, it is not recommended that the product is applied to a film thickness that is more than double of the thickest recommended film.

Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.
Colours	White. Other colours by agreement.
Gloss (60°)	Gloss
Hardener	Comp. B: INERTA 205 HARDENER
Mixing ratio (A:B)	2:1 parts by volume
Pot life, +23°C	30-40 min.
Storage	The storage stability is shown on the label. Store in a cool place and in tightly closed containers.

DIRECTION FOR USE

Surface preparation	Remove from the surfaces any contaminants that might be detrimental to surface preparation and application. Remove also water-soluble salts by using appropriate methods. The surfaces are prepared according to the different materials as follows: STEEL SURFACES: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). The profile of the blast-cleaned surface must be at least coarse (reference comparator "G"). See standard ISO 8503-2 (G). CONCRETE SURFACES: The concrete must be at least 4 weeks old, well-hardened and solid. The water content of the top layer must not exceed 4% by weight. Smooth down any spatter and irregularities on the surfaces by grinding. Brush away loose cement, sand and dust. Wash oily and greasy surfaces with detergent or solvent. Remove dense laitance if present by etching with RENSA ETCHING etching liquid or by grinding or blast-cleaning. Big cavities in the concrete are repaired with cement mortar immediately after the removal of moulds. Before the product is applied, all holes are to be filled, and if necessary, the whole surface is stopped up with water-borne TEKNOPOX AQUA FILL 5900 Epoxy Stopper or with solvent-free TEKNOPOX FILL Epoxy Stopper. OLD PAINTED SURFACES SUITABLE FOR OVERCOATING: Any impurities that might be detrimental to the application of paint (e.g. grease and salts) are removed. The surfaces must be dry and clean. Old, painted surfaces that have exceeded the maximum overcoating time are to be roughened as well. Damaged parts are prepared in accordance with the requirements of the substrate and the maintenance coating. The place and time of the preparation are to be chosen so that the prepared surface will not get dirty or damp before the subsequent treatment. Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2. All prefabrication primer coats must be completely removed regardless of the binder type. In practice this means that when the surface is viewed vertically from a distance of 1 meter and in normal lighting conditions the surface is of an evenly grey colour, i.e. the preparation grade is Sa 2½ (ISO 8501-1).
Application method	Airless spraying

Application	Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before application the base and hardener are mixed in right proportion. Stir thoroughly down to the bottom of the vessel. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties. Suitable airless nozzle size 0.018 - 0.021". Brush or roller can be used for touching up. Take the pot life of the paint into consideration while painting.
Application conditions	The surface to be treated has to be dry. During the application and drying period the temperature of the ambient air, the surface and the product shall be above +10°C and the relative air humidity below 80%. Additionally, the temperature of the surface to be treated and the product must be at least +3°C above the dew point of the ambient air.
Drying time	+23°C / 50% RH (dry film 120 µm)
dust free	6 h (ISO 9117-3:2010)
Overcoatable	

surface temperature	by itself	
	min.	max.*
+15°C	10 h	7 d
+23°C	6 h	4 d

* Maximum overcoating interval without roughening.
Increase in film thickness and rise in the relative humidity of the air in the drying space usually slow down the drying process.

Cleaning	TEKNOSOLV 9506, TEKNOCLEAN 0205C

HEALTH AND SAFETY

Safety and precaution measures	See safety data sheet.

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