

Muki EPS

Product description

This is a two component chemically curing epoxy coating. It is a shop primer designed for high welding and cutting speed, giving reduced weld porosity and back burning. It is fast drying making it suitable for stacking shortly after application. Can be used as temporary primer in a new construction phase, as holding primer or as primer in a complete coating system in atmospheric and immersed environments. Suitable for properly prepared carbon steel substrates and recommended to be applied in an automated shop priming line in lower film thicknesses or applied by airless spray when used as holding primer. Compatible with advanced welding technologies including MIG, MAG and G-FCAW when applied in low film thickness.

Typical use

Marine:

Suitable as shop primer or holding primer on vessels.

Protective:

Suitable for structural steel and piping to be exposed to corrosive environments up to very high and immersed. Recommended for offshore environments, refineries, power plants, bridges, buildings, mining equipment and general structural steel.

Approvals and certificates

Type approved shop primer by RMSR

Type approved shop primer by DNV GL

Welding approved shop primer according to ISO 17652-2

Additional certificates and approvals may be available on request.

Colors

red, grey

Product data

Property	Test/Standard	Description
Solids by volume	ISO 3233	25 ± 2 %
Gloss level (GU 60 °)	ISO 2813	matt (0-35)
Flash point	ISO 3679 Method 1	23 °F (-5 °C)
Density	calculated	1.1 kg/l

The provided data is typical for factory produced products, subject to slight variation depending on color.

All data is valid for mixed paint.

Gloss description: According to Jotun Performance Coatings' definition.

Film thickness per coat

Typical recommended specification range

Dry film thickness	0.6 mils (15 µm)	- 2 mils (50 µm)
Wet film thickness	2.4 mils (60 µm)	- 8 mils (200 µm)
Theoretical spreading rate	680 ft ² /gal (16.7 m ² /l)	- 200 ft ² /gal (5 m ² /l)

Surface preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

Surface preparation summary table

Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	Sa 2½ (ISO 8501-1) or NACE No. 2 / SSPC SP-10	Sa 2½ (ISO 8501-1) or NACE No. 2 / SSPC SP-10

Application

Application methods

The product can be applied by

Spray: Use airless spray. Conventional spray recommended for touch-up purposes.

Brush: Recommended for touch-up purposes.

Product mixing ratio (by volume)

Muki EPS Comp A	18 part(s)
Muki EPS Comp B	0.5 part(s)

Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 17 / Jotun Thinner No. 3

Jotun Thinner No. 17: for slow evaporation

Jotun Thinner No. 3: for fast evaporation

Guiding data for airless spray

Nozzle tip (inch/1000):	15-23
Pressure at nozzle (minimum):	50 bar/700 psi

Drying and Curing time

Temperatures:
-10°C = 14°F / -5°C = 23°F / 0°C = 32°F / 5°C = 41°F / 10°C = 50°F / 15°C = 59°F / 23°C = 73°F / 35°C = 95°F / 40°C = 104°F / 100°C = 212°F

Substrate temperature	5 °C	10 °C	23 °C	40 °C
Surface (touch) dry	15 min	10 min	1 min	20 sec
Walk-on-dry	20 min	15 min	4 min	1 min
Dried to over coat, minimum	15 h	10 h	7 h	3 h
Dried/cured for service	21 d	14 d	7 d	3 d

For maximum overcoating intervals, refer to the Application Guide (AG) for this product.

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The recommended shortest time before the next coat can be applied.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

Induction time and Pot life

Temperatures: 15°C = 59°F / 23°C = 73°F

Paint temperature	23 °C
Pot life	24 h

Heat resistance

	Temperature	
	Continuous	Peak
Dry, atmospheric	120 °C	-
Immersed, sea water	50 °C	-

The temperatures listed relate to retention of protective properties. Aesthetic properties may suffer at these temperatures.

Note that the coating will be resistant to various immersion temperatures depending on the specific chemical and whether immersion is constant or intermittent. Heat resistance is influenced by the total coating system. If used as part of a system, ensure all coatings in the system have similar heat resistance.

Product compatibility

Depending on the actual exposure of the coating system, various primers and topcoats can be used in combination with this product. Some examples are shown below. Contact Jotun for specific system recommendation.

Subsequent coat: epoxy, epoxy mastic, alkyd, acrylic

Packaging (typical)

	Volume (liters)	Size of containers (liters)
Muki EPS Comp A	18	20
Muki EPS Comp B	0.5	1

0.5 l = 0.13 gal
18 l = 4.76 gal

The volume stated is for factory made colors. Note that local variants in pack size and filled volumes can vary due to local regulations.

Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Shelf life at 73°F (23 °C)

Muki EPS Comp A	24 month(s)
Muki EPS Comp B	48 month(s)

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

Note

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Color variation

When applicable, products primarily meant for use as primers or antifoulings may have slight color variations from batch to batch. Such products may fade and chalk when exposed to sunlight and weathering.

Color and gloss retention on topcoats/finish coats may vary depending on type of color, exposure environment such as temperature, UV intensity etc., and application quality. Contact your local Jotun office for further information.

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.
