

WANARMOR®  
**Epoxy Ferric Oxide  
Intermediate Coat**

## Product Description

WANARMOR® EP254 is a two-component, high-solids, low-VOC epoxy micaceous iron oxide intermediate coating specifically designed for severe corrosion environments. Utilizing micaceous iron oxide as pigment combined with an epoxy resin system, it forms a dense film that delivers outstanding abrasion resistance and impermeability, effectively extending the service life of the coating system.

## Product Characteristics

Excellent corrosion resistance, superior low-temperature curing performance.

## Recommended Uses

Can be used as an intermediate coat for epoxy paint systems in severely corrosive environments.

## Technical Specifications

### Physical Parameters

Color	Gray MIO
Surface	Flat
Density	Approx. 2.0 kg/L
Solids By Volume	80±2%
Theoretical Spreading Rate	5.4 m <sup>2</sup> /L, DFT:150 µm
Flash Point	28°C
VOC	196 g/L

## Surface Preparation

Application Conditions: Substrate temperature must be at least 3 °C above dew point, with relative air humidity not exceeding 85%.

New Projects (New Steel): Surfaces must be free of oil, contaminants, and impurities. Sandblasting must achieve ISO 8501-1:2007 Sa 2½ grade, with surface roughness meeting ISO 8503-2 Medium (G) standard.

Repair Projects: Remove loose contaminants such as oil from the surface. Sandblasting to Sa 2½ grade or manual cleaning to St 3 is recommended. Requirements may be appropriately relaxed for localized areas that

are difficult to treat.

## Application Guidance

### Application Method

Airless spraying, brushing.

### Mixing Ratio

Mass Ratio: 27.5 (Base) : 2.5 (Hardener)

Pot Life: 1.5 hours at 20 °C

### Hardener

CEP2540

### Thinner

WANARMOR®TH003

Cleaning Agent : WANARMOR®TH003

### Film Thickness

Film Thickness	
Wet Film	200 µm
Dry Film	150 µm

### Drying Time

Surface Temperature	20°C
Surface Dry	1.5 hours
Hard Dry	9 hours
Fully Cured	7 days

DFT:150 µm

### Overcoating Interval

Product Name	10°C	20°C	30°C	40°C
Epoxy Ferric Oxide	Lowest	16 hours	8 hours	6 hours
Intermediate Coat EP254	Highest	Extendable	Extendable	Extendable

## Ambient Temperature

10°C~40°C. Avoid construction under conditions where relative humidity exceeds 85%.

## Surface Temperature

Above the dew point by 3°C or more.

## Recommended Method

Tools	Application Parameters
Airless Spray	Nozzle Pressure: 25 MPa
	Nozzle Size: 0.48-0.64mm

WANARMOR®EP254 can be applied using airless spraying, roller coating, or conventional spraying.

## Mixing and Thinning

WANARMOR®EP254 is a two-component product with a precise mix ratio. First, stir the Base until uniform and free of lumps, taking no longer than 2 minutes. Then slowly add the hardener and stir for 3 minutes. Use a variable-speed power mixer. Avoid overmixing, as this accelerates curing and reduces product shelf life. High temperatures shorten the mixture's pot life, while low temperatures extend it. If required by application conditions, a small amount of thinner (5% or less) may be added, subject to local regulations regarding volatile organic compounds (VOCs) and air quality.

## Ventilation

For the safety of construction personnel and the proper performance of this product, all areas of the construction site must be well ventilated.

## Packaging and Storage

### Packaging

Two-component, 30 kg combination packaging.

### Storage

Products must be stored in accordance with national regulations. Keep in a cool, well-ventilated area away from heat and ignition. Containers must be kept tightly closed.

### Shelf life

1 year

## Safety Precautions

## Warning

May cause eye and skin irritation. Vapors may cause respiratory irritation in sensitive individuals. May cause skin sensitization. Avoid breathing vapors. Avoid contact with eyes and skin. Use eye, ear, and skin protection, and wear an appropriate respirator to avoid potential respiratory irritation. After use, thoroughly wash skin with water. If discomfort occurs, consult a physician. Wash clothing before reuse. If breathing has stopped, perform artificial respiration, preferably mouth-to-mouth, and seek medical attention. Burns: Exothermic reactions may cause product to become excessively hot. Handle mixtures with caution. Wear gloves. First Aid: If product contacts eyes, immediately flush with water for at least 15 minutes. Remove contaminated clothing and shoes. Wash exposed skin with soap.

Before and during use, observe all safety labels on the packaging. Consult the Safety Data Sheet and comply with relevant national or local government safety regulations.

## Statement

The information listed in this document is reliable. Each value provided is calculated as theoretical data based on the product formulation. Upon request, our company can disclose the internal standard measurement methods used to determine any of the above data. Since usage conditions are beyond the manufacturer's control, this information is provided without warranty. The product is intended for professional use only. For any inquiries, please contact our company.

Our Technical Support and Customer Service Center is available to provide consultation and application technical services regarding the product. We welcome your inquiries via mail or phone. National Customer Service Hotline: 400-059-1116 ext. 3.