

**Starting Point  
Formulation**

An Anticorrosive Primer starting point formulation based on OUDRASperse™ WB 4001 Epoxy Dispersion dispersion is provided below (WBED-4001-01). When applied at 12mil dry film thickness (DFT) to blasted hot-rolled steel (bHRS), this primer shows excellent corrosion resistance after 1500hours of continuous salt spray exposure, as displayed in the images below. Note that films were cured for 7 days at 25°C and 65% Relative Humidity (%RH) prior to salt spray exposure.

<b>Anticorrosive Primer for Metal Protection (&lt;50 g/L) WBED-4001-01</b>		
<b>Ingredients</b>	<b>Pounds</b>	<b>gallons</b>
<b>Part A</b>		
<i>On high-speed mixer, disperse following in order</i>		
Water	92.7	11.11
Disperbyk 190	10.5	1.19
Surfynol DF-62	2.2	0.27
Surfynol 440	6.7	0.82
Red iron oxide	56.4	1.32
Zeeosphere 400	48.8	2.44
Barytes	48.8	1.33
Calcium Silicate	48.8	5.62
halo SW-111	75.1	3.15
Mica 325	7.5	0.32
<i>Reduce mixing speed and add</i>		
Bentone LT	11.3	0.59
OUDRASperse™ WB 4001 Epoxy Dispersion	323.3	34.72
ACRYSOL™ RM-12W	10.9	1.26
<b>Part A subtotal</b>	<b>743.2</b>	<b>64.14</b>
<b>Part B</b>		
AnqaminE 419	192.4	21.28
DOWANOL™ PM Glycol Ether	55.7	7.25
Water	61.2	7.33
Part B Subtotal	309.2	35.86
<b>Totals</b>	<b>1052.4</b>	<b>100</b>
PVC	23.3%	
Volume Solids	39.3%	
Weight Solids	52.0%	
Density (lb/gal)	10.52	
VOC (g/L)	209	
Stoichiometry (epoxy: amine)	1.4: 1	