

HEGSEL® Coat 162

Multi-Purpose Epoxy Based Primer / Coating

You Build, We Protect!

Description:

HEGSEL Coat 162 is a two-component, high-solids epoxy primer / coating based on anti-corrosion pigments and inert fillers. It provides excellent corrosion protection and is designed for easy application at high film thickness with very good build on sharp edges. The coating can be used as a multipurpose primer or finish within epoxy coating systems.

Characteristics:

- Superior corrosion protection
- Extreme barrier performance
- High adhesion strength
- High flexibility
- Resistant to water spill, various solvents and chemicals
- Suitable for indoor applications as a single-coat system or as a primer/coating in epoxy systems
- Suitable for steel, galvanized steel, and aluminium substrates
- VOC ≤ 290 g/l

Application Areas:

HEGSEL Coat 162 is suitable for protection of new steel structures, galvanized steel and aluminium surfaces exposed to aggressive atmospheric, marine, and offshore environments, where high-grade protection must be combined with fast curing and reduced solvent emissions.

Application Data:

Finish	Silk gloss Note: The final gloss level is influenced by the substrate condition and applied film thickness, and may in some cases differ from the stated values.	
Colour	Standard colours (e.g. RAL, NCS)	
Mixing Ratio	Base : Activator = 4: 1 (Parts by volume)	
Theoretical Consumption	~ 0.12 l/m ² @ 80 microns DFT	
Practical Consumption	For large areas: ~ 0.17 l/m ² @ 80 microns DFT For small areas: ~ 0.24 l/m ² @ 80 microns DFT Note: Performance in practice varies with site conditions; so, the stated consumption values should be used as guidelines for airless spraying.	
Standard Dry Film Thickness (DFT)	60-140 microns (depends on application process)	
Temperature	10 °C	20 °C
Pot Life	-	5 hrs
Drying Time (Dust Free)	4 hrs	2 hrs
Drying Time (Manageable)	12-16 hrs	6-8 hrs
Overcoat Interval	16 hrs	8 hrs

Note 1: All the provided values are approximate and should be used as guidelines for specifications.

Note 2: Drying times obtained using **HEGSEL Coat 162 Activator A** at a dry film thickness of 80 µm. At higher film thicknesses, longer drying times must be considered.

Technical Data:

Title	Standard	Value
Solids Content (Mix)	-	~ 68 vol.% (depends on colour)
Biobased Content (See Note 2)	-	Up to 16%; reduces CO ₂ footprint by 0.8 kg/l
Density (Mix) @ 20 °C	-	~ 1.45 kg/l
Corrosion Resistance	Electrochemical Impedance Spectroscopy (EIS)	Rc = 3.5 × 10 ⁹ Ω, n=0.96 (after 21 days)
Salt Spray Resistance	ISO 9227 (NSS) / ASTM B117	4000 hrs
Pull-Off Adhesion	ISO 4624 / ASTM D4541	Before salt spray: 5.5 MPa After salt spray: 5.3 MPa
Flexibility	ISO 1519 / ASTM D522	25 mm (Cylindrical mandrel)
Temperature Resistance	-	Dry heat: Up to 150 °C (up to 200 °C for Aluminum RAL 9006/9007)
Outdoor Exposure	ISO 2810	2 years

Note 1: Corrosion resistance test was conducted in Direct to Metal (DTM) state.

Note 2: CO₂ impact varies with HEGSEL activators and project conditions. See Mixing section; for project-specific calculations, contact HEGSEL.

Packaging:

20 litre cans and 200 litre drums,
HEGSEL Coat 162 Thinner: 25 litre jerry cans

Storage:

12 months, in sealed original containers under dry and cool conditions, ideally between 5 – 40 °C. Protect from heat and freeze!

1. Surface Preparation

Steel: Steel surfaces shall be prepared to a cleanliness level of Sa 2½ in accordance with ISO 8501-1, with a blasting profile of 40–70 µm, or alternatively cleaned using power tools to a minimum standard of ISO St3 / SSPC SP3.

For untreated steel, surface preparation shall be carried out in accordance with ISO 12944-4 §6.2.3. All grease, oil, dirt, and other contaminants must first be removed using a suitable cleaning agent such as **HEGGEL Cleaners** applied with a high-pressure spraying pistol. The surface shall then be grit blasted to Sa 2½ according to ISO 8501-1. After blasting, all dust must be removed from the entire surface using clean, dry, oil free compressed air. The first coating layer must be applied within 6 hours after blasting. If the final coating layer is to be applied on the construction site, additional precautions must be taken to maintain surface cleanliness and coating performance.

Hot dip galvanized: The surface must be prepared in accordance with ISO 12944-4, section 6.2.3.4.1 (sweep blasting with inert grit) and NEN 5254 for duplex systems. All grease, oil, and contaminants should be removed using a suitable cleaning agent like **HEGGEL Cleaners**. The entire galvanized surface must then be lightly sweep blasted using an inert abrasive with a grain size of 0.3–0.5 mm, at a blasting pressure of 2.0–2.5 bar and a minimum nozzle diameter of 6 mm. After blasting, the surface should exhibit a uniform, matte appearance. Depending on the zinc coating thickness, a maximum of 5–10 µm of zinc may be removed, as specified in NEN 5254. Finally, remove all dust from the surface using clean, dry, oil free compressed air. Apply first coating layer within 2 hours.

2. Environmental Conditions

Prior to, during, and after application of the coating, ensure that the substrate temperature is at least 3 °C above the dew point and the maximum relative humidity shall be below 80%. Furthermore, any contact with moisture must be avoided during curing process. Ensure adequate ventilation during application and curing to facilitate solvent evaporation and proper drying.

3. Application Tools

Air Spray: For effective application, use conventional air spray equipment. Thin the material with **HEGGEL Coat 162 Thinner**

at 10–15% by volume. Maintain a flow pressure of 3–4 bar for optimal operation. Use a nozzle size of 2.0–2.5 mm. The achievable dry film thickness ranges from 60–140 µm.

Airless Spray: Apply using standard airless spray equipment. Dilution with **HEGGEL Coat 162 Thinner** may be required at 0–10% by volume. Operate at a pressure range of 140–160 bar and a nozzle size of 0.015 inch is recommended. The resulting dry film thickness typically falls between 60 and 140 µm.

Air mix: Application may be carried out using Air mix spray equipment. Thin the material with **HEGGEL Coat 162 Thinner** at 5–10% by volume. A working pressure of 70–100 bar is recommended. Use a nozzle size of 0.015 inch. The recommended dry film thickness per coat is 60–140 µm.

Brush / Roller: Application by brush or roller may require thinning with **HEGGEL Coat 162 Thinner** at 0–5% by volume. Using this method, a typical dry film thickness of approximately 60 µm can be achieved.

4. Mixing

Thoroughly mix the base component and activator using a mechanical mixing device. Ensure the temperature of the mixed material is maintained at a minimum of 10°C during application.

Activators options: All listed activators use a 4:1 mixing ratio by volume.

HEGGEL Coat 162 Activator A– standard activator (16% biobased content)

HEGGEL Coat 162 Activator B accelerated curing (15% biobased content)

HEGGEL Coat 162 Activator C for improved chemical resistance.

5. Application

The coating is preferably recommended to be applied using airless or air mix spray equipment, as brush application may result in variations in film thickness and reduced flow properties.

The product can be applied without thinning when using airless spray equipment at 18–23 °C.

Apply uniformly to achieve required dry film thickness.

Where thinning is required, the amount of **HEGGEL Coat 162 Thinner** should be adjusted to the equipment used, application method, temperature of the mixed material.

In electrostatic spraying applications, the paint's electrical resistance can be

adjusted to 500–1000 Ω using **HEGGEL Coat 162 Solvent**.

Note: Clean all equipment immediately after application using **HEGGEL Coat 162 Thinner**.

6. Chemical Resistance

According to ISO 2812-1 / ISO 2812-2 / ASTM D543 (indicative, based on immersion testing):

- Distilled water
- Seawater
- Mineral oil

7. Repairing Defects

Touch-up of damaged or untreated areas shall be carried out on site. Remove grease, oil, and dirt using suitable cleaning agents such as **HEGGEL Cleaners**. Remove rust from mechanically damaged areas, untreated weld seams, weld spots, and heat-affected zones using rotating steel wire brushes, sanding discs, or coarse sandpaper to a minimum cleanliness grade of St 3 in accordance with ISO 8501-1.

Smooth the transition between cleaned areas and adjacent intact coatings by sanding and scraping. After sanding, remove all dust using clean, dry, oil-free compressed air. Then repair the area using the complete coating system in accordance with the coating specification. Minor surface damage may be repaired using the top coat only.

Note: Regular cleaning of the surface is recommended. The coating system should be inspected annually for defects, and any damage shall be repaired using the original coating system.

8. Safety Measures

HEGGEL Coat 162 (UN number: 1263) is in accordance with EU Directive 67/548/EEC and the applicable hazardous substances regulations. Ensure adequate ventilation during application and drying to reduce solvent vapors. This is necessary to achieve proper drying conditions and to protect applicators' health. Causes skin and eye irritation and may be harmful if inhaled. In case of eye contact, immediately rinse thoroughly with water and seek medical attention. Do not eat, drink, or smoke while handling this product. Keep away from heat, sparks, and open flames.

The material safety data sheets of the individual components, the safety instructions on the packing (label) as well as the legal requirements for handling hazardous materials must be observed.

HEGGEL Coat 162; Revision No: 0.00 / Last Revision Date: 18.03.2026

All information contained herein is based on the current state of our knowledge and practical experience at the time of release. Therefore, please make sure that this is the latest edition of the Technical Data Sheet. All data are only intended as a guideline for informational purposes and do not constitute a legally-binding warranty of the suitability for a certain purpose of use, due to its dependence on site conditions and possible processing, use and applications. All information contained in this technical datasheet is subject to change without notice.

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