

2C-Epex-Hydro-Primer 3E602

Series 3E602 · Waterborne 2K epoxy primer with C4(h) corrosion protection for steel (airmix)



01 PRODUCT DESCRIPTION

2C-Epex-Hydro-Primer 3E602 is a waterborne two-component epoxy primer with excellent corrosion protection on pre-cleaned or blast-cleaned steel substrates. In the coating system with Bergolin Aqua Topcoat it provides durable protection and has been externally tested to DIN EN ISO 12944-6 for corrosivity category C4(h). Thanks to its waterborne formulation, the primer has a low VOC content and can be applied economically by airmix application.

02 PRODUCT PROPERTIES

Binder system	Epoxy resin
Hardener system	Epex Hydro Hardener 7E717
Adjustment thinner	Distilled water (0–3 %)
Cleaning thinner	Flush equipment thoroughly with water first; if required, clean with Hydro Thinner 5P048.
Characteristics	 Waterborne  Corrosion protection  Low VOC content
Color shade	Approx. RAL 1015, RAL 7035, RAL 8012 (further color shades on request)
Shelf life	12 months in the unopened original container at +4 °C to +40 °C. Protect from frost and moisture.
Approvals and specifications	Externally tested to DIN EN ISO 12944-6 for C3(h)

Property	Comp. A	Comp. B	Mixture
Density · DIN EN ISO 2811-1 · +20 °C "	Approx. 1.42 g/ml	Approx. 1.03 g/ml	Approx. 1.36 g/ml
VOC content · IE Directive 2010/75/EU "	Approx. 52 g/l	Approx. 0 g/l	Approx. 44 g/l
Solid content (wt.-%) · in mixture "	–	–	Approx. 58 %
Viscosity · DIN EN ISO 2431 · +20 °C	Approx. 75–85 s (6 mm)	Approx. 36–42 s (4 mm)	Approx. 30–45 s (6 mm)

"1 Depending on color shade

03 APPLICATION

The following information may vary depending on the application. Please contact your direct contact person for more detailed information.

Substrate	Steel (ground), blast-cleaned steel sheet Sa 2½
Surface preparation	Ensure sufficient load-bearing capacity before application. Steel: Surface preparation to EN ISO 12944-4. Free of weld spatter, pores, laps, burrs, grease, oils and dirt. Blast-clean to Sa 2½, mean roughness Rz approx. 50–70 µm (G or operating mix GS).

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Mixing ratio	80 : 10 by weight (with Epex Hydro Hardener 7E717)
Mixing	Add the hardener component to the base component and stir intensively with an electric or pneumatic stirrer for approx. 1 min.
Theoretical consumption	Approx. 140 g/m ² (mixture) at 50 µm dry film thickness
Film thickness	150–200 µm WFT (approx. 50 µm DFT)
Spray viscosity	30–45 s / 6 mm (DIN flow cup)
Application method	 Spray (gravity cup / airmix)
Application conditions	 Application temperature +15 °C to +35 °C  Relative humidity 30–85 %
Pot life ^{*2}	Approx. 2 h
Recoating interval (with itself) ^{*2}	Min. 100 min (at 150–200 µm WFT, +20 °C, 30–85 % rel. humidity); then recoatable with Bergolin Aqua Topcoat 6D3200 or Bergolin Topcoat 6D2300 (testing recommended).
DRYING^{*2}	
Dust-dry (TG 1)	Approx. 60 min (23 °C / 28 %) approx. 25–30 min (35 °C)
Fully dried (TG 7)	< 24 h
Compatible systems	Topcoat: Bergolin Aqua Topcoat 6D3200 Topcoat: Bergolin Topcoat 6D2300 Further applications on request.

^{*2} Lower temperatures slow down drying; higher temperatures accelerate it.

Note: The drying of waterborne coatings depends on temperature, relative humidity, air movement and film thickness and may be considerably longer under unfavourable conditions. Heat-forced drying accelerates the process.

04 NOTE

This product data sheet supersedes all previously published product data sheets. The information contained herein is based on practical experience under standard conditions and assumes proper storage and processing. Substrates, materials and working conditions may vary. Therefore, no warranty or liability can be derived from the information contained in this document or from verbal consultation. It is the buyer's responsibility to verify the product's suitability for the intended use. Preliminary trials are recommended. The relevant legal regulations, the leaflets of the BG RCI and the accident prevention regulations of the responsible employers' liability insurance association must be observed. In all other respects, our General Terms and Conditions of Sale and Delivery apply.

MODIFIED BY

24.08.2026 – Martin Krull, Head of Laboratory

APPROVED BY

24.08.2026 – Stefan Eisenmenger, Product Management