

COATING DATA

DESCRIPTION:

A two-component, high solids, chemical and corrosion resistant modified polyamidoamine epoxy formulated for excellent protection of steel pipe. Used in pipe type electrical cabling and natural gas flow-coating applications. Pipe Liner SG meets the requirements of the Food Safety and Inspection Service of the U. S. Department of Agriculture as chemically acceptable for use in areas where there may be a possibility of incidental food contact.

Pipe Liner SG Epoxy

Complies with U.S. EPA National Volatile Organic Compound (VOC) Emission Standards for industrial maintenance coatings effective September 13, 1999.

USE:

To protect steel pipe from chemical and corrosion attack. Use in severe environments which include abrasion, moisture, corrosive fumes, chemical contact, and immersion. These industrial environments include pipe type cabling, flow coat applications, chemical processing plants, power plants, offshore oil and gas equipment, laboratories, pulp and paper mills, structural steel, and others.

-Major gas/electrical utilities and cable manufacturers use Pipe Liner SG. The lining is not effected by the oils used in cabling applications and does not effect the power factor, physical or electrical properties of oil or gas.

-Provides internal corrosion protection during pipe shipment and storage

-Resists reverse impacts and provides excellent flexibility.

-Pipe Liner SG has been tested to show improved resistance against “odor fade” in natural gas distribution applications.

LIMITATIONS:

Do not use for immersion service above 120°F (49°C) or dry heat above 200°F (93°C). Not recommended for immersion in concentrated solutions of mineral acids or organic acids. *Not for potable water.*

SURFACE PREPARATION:

STEEL- Mechanical brushing by means of a powered, boom-mounted cleaning head is acceptable. Avoid burnishing by the brushes. Internal surfaces should be free of oil, grease, rust, mill scale, deposits and moisture. For best results, abrasive blast surface to commercial grade per SSPC-S6.

COVERAGE:

Theoretical—962 ft² per gallon at 1.0 mil dry film thickness.

DRY FILM THICKNESS:

1.5 to 6.0 mils per coat.

WET FILM THICKNESS:

3.5 to 10 mils.

APPLICATION DATA**BLEND RATIO:**

One part Pipe Liner SG Activator to four parts Pipe Liner SG Epoxy Base. Power agitate until components are thoroughly mixed. Allow mixed components to stand fifteen minutes prior to application.

STORAGE TEMPERATURE:

Minimum 20° F, Maximum 110° F

SHELF LIFE:

18 months at recommended storage temperature.

POT LIFE:

Six hours at 80°F, decreasing at higher temperature.

APPLICATION:

Airless Spray—Use .017-.021 tip; 60 mesh filter; 30:1 pump ratio at 60-100 psi operating air pressure.

Conventional Spray—Follow instructions of equipment manufacturer for the application of epoxy paints.

Roll—Use lamb's wool cover. Additional coats may be required to achieve desired film thickness.

Brush—Use natural bristle brush. Additional coats may be required to achieve desired film thickness.

THINNING:

If required, thin up to 10% with K-1066 Reducer. Clean equipment with K-1066 Reducer.

CLIMATE:

Use this product only if the substrate temperature and ambient air temperature is above 40°F and is expected not to decrease for at least two hours after application. Also, the substrate temperature must be 5°F above the dew point for a period of at least two hours after application to avoid condensation occurring on wet paint.

DRY TIME:

TO HANDLE—7 hours at 80°F.

TO RECOAT—50°F or higher, over-night; 40°F to 50°F, second day.

Note: High film thickness, low temperature and/or poor ventilation will retard dry time.

Note: E-60 Accelerator may be used to increase the normal curing rate of reaction to provide a rapid low temperature cure. See E-60 Technical Data Sheet for more information.

PHYSICAL DATA:

VOLUME SOLIDS: 60% ± 1%

WEIGHT PER GALLON: 10.6 ± .2 lbs per gallon

VOLATILE ORGANIC CONTENTS:

Mixed unthinned - < 2.5 lbs/gallon;

SAFETY DATA:

See individual product label for safety and health data information. Individual Material Safety Data Sheets are available upon request.