

PRODUCT DATA SHEET
POWERCRETE® R-65/F1

Product Information

Product description: Powercrete® R-65/F1 is a solvent free epoxy coating with an extreme fast curing time for handling efficiency in pipe-mills and workshops, has user friendly application characteristics and rapid backfill properties. Powercrete® R-65/F1 provides excellent long term corrosion protection to abrasive blasted steel and FBE coated pipes. This high-build epoxy coating system can easily achieve a dry film thickness (DFT) up to 40mils (1000micron) in one multi-pass layer. Powercrete® R-65/F1 Repair Cartridges and Spray Cartridges are available to make this the ideal coating for girth welds, Touch-up and rehabilitation projects.

Features:

- 100% Solids Epoxy
- no VOC
- Extreme fast curing time for reducing production costs
- User friendly 2:1 mixing ratio (cartridges 1:1)
- Excellent adhesion to FBE and abrasive blasted steel
- Good mechanical properties
- Can be used in a broad range of applications
- Suitable for pipeline operating temperatures to 65°C (150°F)
- Can be sprayed and hand applied up to 1000micron (40mils) in one multi-pass layer

Application examples

Application: coating system for new construction and rehabilitation of pipes, pipe bends, fittings, valves, girth welds/field joints, buried tanks and other steel structures in need of protection.

Application Instruction: Surface Preparation Steel

General	The area to be coated has to be clean, dry and free from oil, grease and dust. All contamination that could interfere with the adhesion of the coating has to be removed according to SSPC-SP1.
Preventing condensation on the substrate	Prior and during the surface preparation, the temperature of the substrate(s) must be at least 5°F (3°C) above the dew point.
Abrasive Blasting	Minimum Sa2½ (SSPC-SP10/ NACE2) .
Recommended Surface Profile	3-4mils (75-100micron) angular profile.

Application Instruction: Surface Preparation FBE

General	The area to be coated has to be clean, dry and free from oil, grease and dust. All contamination that could interfere with the adhesion of the coating has to be removed according to SSPC-SP1.
Preventing condensation on the substrate	Prior and during the surface preparation, the temperature of the substrate(s) must be at least 5°F (3°C) above the dew point.
Abrasive Blasting	Sa1 (SSPC-SP7/NACE4, sweep-blasting for optimum performance.
Recommended Surface Profile	Minimum 2mils (50micron) angular profile.

Application Safety

General	Read the Product Data Sheet and follow the caution statements on the Material Safety Data Sheet. Personnel who will come into contact with the product should be using appropriate protection equipment. Follow national safety guidelines.
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Application Conditions

	Product	Surface	Ambient	Humidity
Optimum	130°F (55°C)	70-90°F (21-32°C)	70-90°F (21-32°C)	25-50%
Minimum	122°F (50°C)	50°F (10°C)*	35°F (2°C)	0%
Maximum	140°F (60°C)	176°F (80°C)	120°F (49°C)	85%

* If the surface to be coated is below 10°C (50°F), preheating of the substrate is recommended. Preheat temperatures should not exceed 80°C (176°F). Prior and during the application, the temperature of the substrate must be at least 3°C above the dew point.

Application Instruction: Plural Component Spray

Step 1	Mix the Part A and B until uniform in consistency.
Step 2	Use only heated plural component Airless equipment capable to maintain a 2:1 ratio in volume and 1.25 Gallon/4,73 Liter per minute output, with heated drums, insulated (heated) hoses and minimum 193bar (2800psi.) fluid pressure for Part A and 193bar (2800psi) for Part B. Use Binks 1M Airless spray-gun or equal with preferably changeable spray tips. Consult Powercrete® for specific information.
Step 3	Part A must be heated up and maintained to a temperature of 60-65°C (140-150°F) and Part B must be heated up and maintained at 38-49°C (100-120°F).
Step 4	Apply Powercrete® R-65/F1 in the recommended DFT. Use a WFT gauge to check. Do not dilute the product.

Product Performance (processing under laboratory conditions)

	Test Method	Typical Value
Cathodic Disbondment	ASTM G95 (70°C) (158°F) 30 days	5mm
Flexibility	NACE RP-0394	0.28"/PD at 23°C/73°F.
Impact Resistance	ASTM-G14	72in/lb/8.1Nm/8.1J at 40mils/1000micron
Adhesion to FBE	ASTM D4541	2981psi/20MPa
Adhesion to Steel	ASTM D4541	3200psi/22MPa
Abrasion Resistance	ASTM D4060	1000 cycles a mil (40 cycles/micron)
Resistance to Acids and Alkalies	ASTM C581	Excellent
Dielectric Strength	ASTM D149	750V/mil (28V/micron)
Thin film Water Immersion	ASTM D570	0.1% (24 hours)
Hardness	ASTM D2240	85 Shore D

General Product Information

Colour	Green
Finish	Gloss
Primer	Self-priming on FBE and DTM
Dry Film Thickness	40mils (1000micron) for most applications
Coverage Rate (theoretical)	40.8 sq.ft/USG at 40mils (1000micron)DFT. 1,00m²/l at 40mils (1000micron)DFT.
Volume Solids	100%
VOC Content	0 g/l
Flash Point	>230°C (446°F) mixed product
Mixing Ratio	2:1 (A to B in volume) 100:36 (A to B by weight)
Potlife	9 minutes at 25°C (77°F)

DISCLAIMER: Seal For Life Industries warrants that the product(s) represented within conform(s) to its/their chemical and physical description and is appropriate for the use as stated on the respective technical data sheet when used in compliance with Seal For Life Industries written instructions. Since many installation factors are beyond the control of Seal For Life Industries, the user is obligated to determine the suitability of the products for the intended use and assume all risks and liabilities in connection therewith. Seal For Life Industries liability is stated in the standard terms and conditions of sale. Seal For Life Industries makes no other warranty either expressed or implied. All information contained in the respective technical data sheet(s) should be used as a guide and is subject to change without notice. This document supersedes all previous revisions. Please see revision date on the left. Powercrete® is a registered trademark of Seal For Life Industries.

Curing Times at 25°C (77°F)		Additional Information
Gel Time:	12 minutes	
Dry time:	37 minutes	
65 shore D:	1 hour (ready for Holiday test)	
75 shore D:	75 minutes (full cure)	
Cure time is based on 40 mils (1000micron) DFT. Recoat interval at 21°C (70°F) is 34-60minutes and 4-7 minutes at 65°C (150°F).		
		Documentation Application instructions and other documentation can be obtained by contacting our head office, from our local distributor or by sending email to info@corrosioncoatings.com
		Certified staff Application of the described coating system should be carried out and inspected by certified personnel.

Inspection and Repair	
Inspection	The finished coating must be visually inspected for any defects, such as runs and sags, fisheyes, blistering, pinholes, missed spots and possible contaminants. Pinhole/Holiday detection must be generated according to NACE SP0188.
Coating Thickness	The coating thickness (DFT) must be within the specified DFT range. Use calibrated equipment and measure according to SSPC-PA 2 or other specified standard.
Repair	Pinholes/Holidays must be located and repaired with approved material. Consult Powercrete® for specific information. Retest the repaired area.

Cleaning	
Cleanup	Use Acetone or MEK.

Handling	
General	Transport and stacking is possible after full cure of the coating and generating a Holiday test (NACE SP0188). This time can be reduced by increasing the curing temperature. Consult Powercrete® for specific information.

General Order Information	
Product	Powercrete® R-65/F1. <u>Product dimensions and contents:</u>
Drum	
Part A	41 gal/155.2 l (660 lb/299.4 kg)
Part B	41 gal/155.2 l (475 lb/215.5 kg)
Pail	
Part A	5 gal/18.9 l (80.4 lb/36.5 kg)
Part B	5 gal/18.9 l (55 lb/24.9 kg)
Kit Options	1.32 gal/5 l (21 lb/9.5 kg) 0.66 gal/2.5 l (10.5 lb/4.8 kg) 0.26 gal/1 l (4.2 lb/1.9 kg) 0.13 gal/0.5 l (2.1 lb/0.95 kg)
Cartridges	On request.
Handling	Handle with care. Keep containers upright.
Storage	Store indoor, clean and dry, away from direct sunlight in a cool place below 18-30°C (65-85°F). Keep from freezing. Shelf life 24 months in the original unopened containers.



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