

COVALENCE® S1239 EPOXY PRIMER

Description:	S1239 primer is a specially formulated 100% volume solids (solventless) 2 component epoxy
Recommended use:	As a epoxy primer in a 3 layer polyethylene coating system for superior corrosion protection of field welded joints of steel pipes. Can be used with Covalence 3 layer coating systems: HTLP60, DIRAX, ROCS60E. For DIRAX, ROCS60E the epoxy primer needs to be applied on the steel surface only. For HTLP60 the epoxy needs to be applied onto the steel surface AND onto the line coating, when this line coating is PE, FBE or CTE.
Colour:	Black
Volume solids:	100%
Weight solids:	100%
Mixing ratio:	(by volume) : 100 parts of base (part A) to 60 part of hardener (part B) (by weight) : 100 parts of base (part A) to 40 part of hardener (part B)
Typical coverage:	6.14 sq.m/litre (66 sq.ft/litre) or 23.2 sq.m/US gallon (249.8 sq.ft/US gallon). This coverage is based on 100-150 microns or 4-6 mils average thickness.
Specific gravity:	Base : 1.39 Hardener: 0.93
Typical thickness:	100-150 microns (4-6 mils)
Pot life:	100 min at 23°C (73°F), 25 min at 40°C (104°F)
Shelf life:	5 years 23°C (73°F, 163°F), out of direct sunlight. Shelf life will be lesser at higher temperatures.
Flash point:	Part A (Base) : >132°C (270°F) Part B (Hardener): 33°C (91.4°F)
Thinner:	Do not dilute
Application:	1. Prepare the pipe surface as recommended in the product application guide 2. Pour hardener into base as per mixing ratio. Stir the mixture for approximately 1 minute to ensure a homogeneous mixture. 3. Carefully apply mixed epoxy primer as indicated in the product application guide.
Ordering info:	Bulk Epoxy: Part A : S1239-PART-A-14.7L-20.4KG Part B: S1239-PART-B-17L-15.6KG Always order in multiples of 2 pails of part A by 1 pail of part B. For accessories to apply epoxy see DS-ACCESSORIES.

Epoxy usage on steel surface only for DIRAX, ROCS60E

Assumption: 300 mm or 12" cut back, coverage 6.14 sq m/litre

Pipe diameter		Quantity required (ml)		# Joints/ US gallon	# Joints/ litre
DN	inches	Part A	Part B		
80	3.500	8.7	5.2	273	72
100	4.500	11.1	6.7	212	56
150	6.625	16.4	9.8	144	38
200	8.625	21.4	12.8	110	29
250	10.750	26.6	16.0	88	23
300	12.750	31.6	18.9	74	19
350	14.000	34.7	20.8	68	18
400	16.000	39.6	23.8	59	15
450	18.000	44.6	26.7	53	14
Pipe diameter		Quantity required (ml)		# Joints/ US gallon	# Joints/ litre
DN	inches	Part A	Part B		
500	20.000	49.5	29.7	47	12
550	22.000	54.5	32.7	43	11
600	24.000	59.4	35.7	39	10

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650	26.000	64.4	38.6	36	9
700	28.000	69.3	41.6	34	9
750	30.000	74.3	44.6	31	8
800	32.000	79.2	47.5	29	7
850	34.000	84.2	50.5	28	7
900	36.000	89.1	53.5	26	7
950	38.000	94.1	56.4	25	6
1000	40.000	99.0	59.4	23	6

Epoxy usage on steel surface and line coating (PE, FBE, CTE) for HTLP60

Assumption: 450 mm or 17.5" wide HTLP60 sleeve, coverage 6.14 sq m/litre

Pipe diameter		Quantity required (ml)		# Joints/ US gallon	# Joints/ litre
DN	inches	Part A	Part B		
80	3.500	12.8	7.7	184	48
100	4.500	16.5	9.9	143	37
150	6.625	24.3	14.6	97	25
200	8.625	31.6	19.0	74	19
250	10.750	39.4	23.6	60	15
300	12.750	46.7	28.0	50	13
350	14.000	51.3	30.8	46	12
400	16.000	58.6	35.2	40	10
450	18.000	65.9	39.6	35	9
500	20.000	73.2	43.9	32	8
550	22.000	80.6	48.3	29	7
600	24.000	87.9	52.7	26	7
650	26.000	95.2	57.1	24	6
700	28.000	102.5	61.5	23	6
750	30.000	109.9	65.9	21	5
800	32.000	117.2	70.3	20	5
850	34.000	124.5	74.7	18	5
900	36.000	131.8	79.1	17	4
950	38.000	139.2	83.5	16	4
1000	40.000	146.5	87.9	16	4

For other sleeve widths, divide by 17.75 and multiple by new sleeve width in inches.

Example: 20" (508 mm) sleeve width on a DN400 diameter pipe

Part A: 58.6 ml x 20/17.75 = 66.1 ml

Part B: 35.2 ml x 20/17.75 = 39.7 ml

Information

Documentation Extensive information is available on our web-site. Application instructions and other documentation can be obtained by contacting our head office, from our local distributor or by sending an email to info@sealforlife.com

Certified staff Application of the described coating system should be carried out by certified personnel.



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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 herewith. 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, see revision date.

Local distributor / representative



For contact details of local distributor / representative
Please visit www.sealforlife.com

Seal For Life Industries LLC
Franklin, MA, USA
Tel: +1 508 918 1600
US Toll Free: +1 800 248 7659
Fax: +1 508 918 1905
franklin@sealforlife.com

Seal For Life Industries Mexico
S de R.L. de C.V.
Tijuana, Mexico
Tel USA: +1 858 633 9797
Fax US: +1 858 633 9740
Tel Mexico: +52 664 647 4397
Fax Mexico: +52 664 607 9105
mexico@sealforlife.com

Seal For Life Industries
Stopaq B.V.
Stadskanaal, the
Netherlands
Tel: +31 599 696 170
Fax: +31 599 696 177
info@sealforlife.com

Seal For Life Industries BVBA
Westerlo, Belgium
Tel: +32 14 722 500
Fax: +32 14 722 570
belgium@sealforlife.com

Seal For Life India Private Ltd.
Baroda, India
Tel: +91 2667 264 721
Fax: +91 2667 264 724
india@sealforlife.com