

**POWERCRETE® R-60**

**Product Information**

**Product description:** Powercrete® R-60 is a solvent free epoxy coating specifically designed to provide corrosion protection to buried pipelines and girth weld areas on FBE (Fusion Bonded Epoxy) coated pipes at operating temperatures up to maximum 60°C (140°F). Ease of application, high-build characteristics, toughness, excellent adhesion values and good corrosion protective properties makes Powercrete® R-60 a good choice to use on valves, bends, fittings and various other new construction-and rehabilitation projects.

**Features:**

- 100% Solids Epoxy
- no VOC
- Excellent adhesion to FBE and abrasive blasted steel
- Good mechanical properties
- Excellent seawater and groundwater resistance
- Can be used in directional drill and thrust bore applications.
- Suitable for pipeline operating temperatures to 60°C (140°F)
- Can be sprayed and hand applied up to 750micron (30mils) in one multi-pass layer

**Application examples**

**Application:** coating system for pipe bends, fittings, valves, girth-welds/field joints, directional drilling, buried tanks and other steel structures in need of protection.

**Product Performance (processing under laboratory conditions)**

	Test Method	Typical Value
<b>Cathodic Disbondment</b>	ASTM G8 (24°C) (75°F) 30 days	5mm
	ASTM G95 (60°C) (140°F) 30 days	10mm
<b>Flexibility</b>	NACE RP-0394	0.2"/PD at 23°C (73°F)
<b>Impact Resistance</b>	ASTM-G14	51 in/lb/5.7Nm/5.7J at 30mils/750micron
<b>Adhesion to FBE</b>	ASTM D4541	>2500psi/>17MPa
<b>Adhesion to Steel</b>	ASTM D4541	>3100psi/20MPa
<b>Abrasion Resistance</b>	ASTM D4060	>1200 cycles a mil (48 cycles/micron)
<b>Resistance to Acids and Alkalies</b>	ASTM C581	Excellent
<b>Dielectric Strength</b>	ASTM D149	650V/mil (26V/micron)
<b>Thin Film Water Absorption</b>	ASTM D570	0.2% (24 hours)
<b>Hardness</b>	ASTM D2240	83 Shore D

**General Product Information**

<b>Colour</b>	Maroon/Burgundy
<b>Finish</b>	Gloss
<b>Primer</b>	Self-priming on FBE and DTM
<b>Dry Film Thickness</b>	20-30mils (500-750micron) for most applications
<b>Coverage Rate (theoretical)</b>	81.5 sq.ft/USG at 20mils (500micron)DFT. 2,00m <sup>2</sup> /l at 20mils (500micron)DFT. 54.2 sq.ft/USG at 30mils (750micron)DFT. 1,33m <sup>2</sup> /l at 20mils (750micron)DFT.
<b>Volume Solids</b>	100%
<b>VOC Content</b>	0 g/l
<b>Flash Point</b>	>100°C (>212°F) mixed product
<b>Mixing Ratio</b>	4.8:1 (A to B in volume) 100:11.2 (A to B by weight)
<b>Potlife</b>	22 minutes at 25°C (77°F)

**Application Instruction: Surface Preparation Steel**

<b>General</b>	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.
<b>Preventing condensation on the substrate</b>	Prior and during the surface preparation, the temperature of the substrate(s) must be at least 5°F (3°C) above the dew point.
<b>Abrasive Blasting</b>	Minimum Sa2½ (SSPC-SP10/ NACE2) .
<b>Recommended Surface Profile</b>	3-4mils (75-100micron) angular profile.

**Application Instruction: Surface Preparation FBE**

<b>General</b>	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.
<b>Preventing condensation on the substrate</b>	Prior and during the surface preparation, the temperature of the substrate(s) must be at least 5°F (3°C) above the dew point.
<b>Abrasive Blasting</b>	Sa1 (SSPC-SP7/NACE4, sweep-blasting for optimum performance.
<b>Recommended Surface Profile</b>	Minimum 2mils (50micron) angular profile.

**Application Safety**

<b>General</b>	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
<b>Optimum</b>	130°F (55°C)	70-90°F (21-32°C)	70-90°F (21-32°C)	25-50%
<b>Minimum</b>	122°F (50°C)	50°F (10°C)*	-20°F (-30°C)	0%
<b>Maximum</b>	140°F (60°C)	180°F (82°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 82°C (180°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**

<b>Step 1</b>	Mix the Part A and B until uniform in consistency.
<b>Step 2</b>	Use only heated plural component Airless equipment capable to maintain a 4.8:1 ratio in volume and 1.25 Gallon/4,73 Liter per minute output, with heated drums, insulated (heated) hoses and minimum 170bar (2500psi.) fluid pressure for Part A and 124bar (1800psi) for Part B. Use Binks 1M Airless spray-gun or equal with preferably changeable spray tips. Consult Powercrete® for specific information.
<b>Step 3</b>	Part A must be heated up and maintained to a temperature of 54°C (130°F) and Part B must be heated up and maintained at 20-30°C (68-86°F).
<b>Step 4</b>	Apply Powercrete® R-60 in the recommended DFT. Use a WFT gauge to check. Do not dilute the product.

Curing Times at 25°C (77°F)	
<b>Gel Time:</b>	30 minutes
<b>Dry time:</b>	1.7 hours
<b>65 shore D:</b>	4.2 hours (ready for Holiday test)
<b>75 shore D:</b>	5.2 hours (full cure)
Cure time is based on 30 mils (750micron) DFT. Recoat interval at 21°C (70°F) is 26-83minutes and 7-10 minutes at 65°C (150°F).	

Additional Information	
<b>Documentation</b>	Application instructions and other documentation can be obtained by contacting our head office, from our local distributor or by sending email to <a href="mailto:info@sealforlife.com">info@sealforlife.com</a>
<b>Certified staff</b>	Application of the described coating system should be carried out and inspected by certified personnel.

Inspection and Repair	
<b>Inspection</b>	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 generated according to NACE SP0188.
<b>Coating Thickness</b>	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.
<b>Repair</b>	Pinholes/Holidays must be located and repaired with approved material. Consult Powercrete <sup>®</sup> for specific information. Retest the repaired area.

Cleaning	
<b>Cleanup</b>	Use Acetone or MEK.

Handling	
<b>General</b>	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 <sup>®</sup> for specific information.

General Order Information	
<b>Product</b>	<b>Powercrete<sup>®</sup> R-60.</b> <u>Product dimensions and contents:</u>
<b>Drum</b>	
Part A	40 gal/151.4 l (600 lb/272.2 kg)
Part B	48.4 gal/183.2 l (400 lb/181.4 kg)
<b>Pail</b>	
Part A	5 gal/18.9 l (75 lb/34 kg)
Part B	5 gal/18.9 l (40 lb/18.1 kg)
<b>Kit Options</b>	
	1.32 gal/5 l (20 lb/9.1 kg)
	0.66 gal/2.5 l (10 lb/4.5 kg)
	0.26 gal/1 l (4 lb/1.8 kg)
	0.13 gal/0.5 l (2 lb/0.9 kg)
<b>Cartridges</b>	On request.
<b>Handling</b>	Handle with care. Keep containers upright.
<b>Storage</b>	Store indoor, clean and dry, away from direct sunlight in a cool place between 18-30°C (65-85°F) Keep from freezing. Shelf life 24 months in the original unopened containers.