



Product Description

Powercrete R-65/F1-C is a 100% solids liquid epoxy coating with a fast cure time for efficient, user-friendly application and rapid backfill. In addition to ease of application, R65/F1-C provides excellent long term corrosion protection for bare steel or FBE coated pipe. This high-build, two-component epoxy can easily achieve a dry film thickness (DFT) of up to 40+ mils (1 mm) in a single application.

Powercrete R-65/F1-C can be applied using Repair Cartridge or by Spray Cartridge. Application of Powercrete R-65/F1-C by cartridge make it the ideal & economical coating for girth welds and/or the repair & rehabilitation of existing pipelines.

Product Features & Benefits

- **100% Solids Epoxy: no V.O.C.s / no Isocyanates**
Safe to use.
- **Super Fast Cure Time**
Speeds up production time and saves costs.
- **High Build: 1 mm (40 mils) in a Single Pass**
Saves time and costs.
- **Compatible with Bare Steel or FBE Coated Pipe**
Flexible use & reduces inventory.
- **1:1 Part A:B Mix Ratio by Volume**
Packed in pre-measured cartridges
- **High Adhesion and Abrasion Resistance**
Superior performance for superior asset protection.
- **High Wet Out for Ultra High Surface Anchorage**
Longer life, better performance.
- **Available for Hand or Spray Application**
Flexible and reduced inventory. Saves money.
- **Excellent Cathodic Disbondment at maximum operating temperature.**
Broad range of applications.

Typical Applications (using Cartridges)

- Pipeline Coating (New Pipe, Girth Welds, Pipe Bends, Fittings, Valves, Odd Shapes), Repair & Rehabilitation

Physical Properties (Tested with coating thickness = 30 mils min.)

Property	Condition	Test Method	Typical Value	
			US Imperial	Metric
Hardness	(Shore D)	ASTM D-2240	85	85
Adhesion to Bare Steel	(On blast cleaned steel)	ASTM D-4541	> 3200 psi	> 22 MPa
Cathodic Disbondment	(25 days @ 65°C)	ASTM G-95	< 0.7 inch	< 18 mm
Hot Water Immersion	(15 days immersion @ 65 C)	-----	No Blisters, No delamination	No Blisters, No delamination
Holiday Detection	Holiday Free	ISO: 21809-3&CSA	125 Volts per mil	5 Volts per micron
		Z245.20ASTM G-62 Method B	84 Volts per mil	3.3 Volts per micron

Product Selection Guide

Maximum Operating Temperature:	65°C (149°F)	Color:	Green
Compatible Line Coatings:	FBE	Typical Single Coat Thickness:	
Mixing Ratio:	1:1 Part A to B	Manually Applied	40 mils (1.0 mm)
		Spray Applied	40 mils (1.0 mm)
Recommended Surface Profile	2.5 - 4.0 mils	Recoat Interval (Spray):	
	63.5 - 101.6 microns	@ 25°C (77°F)	10 - 17 minutes
Surface Preparation:	SA 2 1/2	@ 43°C (110°F)	3 - 7 minutes
	SSPC-10 - Near-White	Theoretical Coverage:	13.5 Sq. Ft./liter @30 mils
	SSPC-SP5 - White	Clean Up:	Acetone, MEK, Toluene

Refer Application Guidelines for 50 mL Repair Cartridge and for 400 mL Spray Cartridge.

Temperature Considerations

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 to application.

Note: The application should only be done when temperature of the steel is at least 3°C (5°F) higher than the dew point, as recommended by NACE.

Storage and Handling

For optimum performance, store Powercrete R-65/F1-C epoxy product in a dry well ventilated area. Maintain products in original packaging and sealed until just before use. Avoid exposure to direct sunlight, rain, snow, dust, and other adverse environmental conditions or contaminants.

Always consult Material Safety Data Sheet prior to handling Powercrete R-65/F1-C.

Note: Avoid prolonged storage at temperatures above 40° C (104° F) or below 5° C (40° F)

Cure Times @ 25°C (77°F)

Pot Life: 0.5 L / 2 Lb kit	9 minutes
Spray Application	
Gel T 40 mils	12 minutes
Dry Time: 40 mils	37 minutes
65 Shore "D" Reading: 40 mils	60 minutes
75 Shore "D" Reading: 40 mils	75 minutes

Shelf life (stored in specified conditions): 6 months

Ordering Information

1. Self-Mixing Cartridges

Repair Cartridge (50 ML size) and Spray Cartridge (400 ML size) are also available.

2. Accessories Kit (optional)

(Accessories Kit contains Latex Gloves, trowels, mixing paddle for electrical drill, hand stirrer, wet film thickness gauge, disposable face masks)



Product Support and Additional Information

For additional information on delivery, application, training, appropriate equipment, sales and customer service, please visit www.berrycpg.com, call or email one of the worldwide locations listed below.



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