

**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.

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

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

**General Product Information**

<b>Colour</b>	Green
<b>Finish</b>	Gloss
<b>Primer</b>	Self-priming on FBE and DTM
<b>Dry Film Thickness</b>	40mils (1000micron) for most applications
<b>Coverage Rate (theoretical)</b>	40.8 sq.ft/USG at 40mils (1000micron)DFT. 1,00m <sup>2</sup> /l at 40mils (1000micron)DFT.
<b>Volume Solids</b>	100%
<b>VOC Content</b>	0 g/l
<b>Flash Point</b>	>230°C (446°F) mixed product
<b>Mixing Ratio</b>	2:1 (A to B in volume) 100:36 (A to B by weight)
<b>Potlife</b>	9 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)*	35°F (2°C)	0%
<b>Maximum</b>	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**

<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 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.
<b>Step 3</b>	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).
<b>Step 4</b>	Apply Powercrete® R-65/F1 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>	12 minutes
<b>Dry time:</b>	37 minutes
<b>65 shore D:</b>	1 hour (ready for Holiday test)
<b>75 shore D:</b>	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).	

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 <b>info@corrosioncoatings.com</b>
<b>Certified staff</b>	Application of the described coating system should be carried out and inspected by certified personnel.

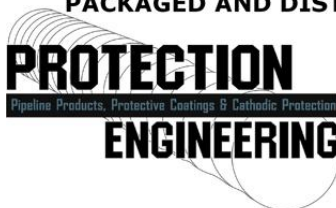
Inspection and Repair	
<b>Inspection</b>	The finished coating must be visually inspected for any defects, such as runs and sags, fisheyes, blistering, pinholes, missed spots and possible contaminants. Pinhole/Holiday detection must generated according to NACE SP0188.
<b>Coating Thickness</b>	The coating 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-65/F1.</b> <u>Product dimensions and contents:</u>	
<b>Drum</b>		
Part A	41 gal/155.2 l	(660 lb/299.4 kg)
Part B	41 gal/155.2 l	(475 lb/215.5 kg)
<b>Pail</b>		
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)
<b>Kit Options</b>		
	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/1.9kg)
	0.13 gal/0.5 l	(2.1 lb/0.95 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 below 18-30°C (65-85°F). Keep from freezing. Shelf life 24 months in the original unopened containers.	

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