

PROTAL 7200 CARTRIDGE (1000 ml)

Fast Cure, High Build Spray Applied Pipeline Coating

Description

Protal 7200 Cartridge (1000 ml) is a VOC free, 100% solids, 2 part epoxy coating specially formulated to compliment FBE coated pipe. It is a high build liquid coating that is spray applied in one coat in the field or shop. It cures very fast to allow quick handling and backfill times.

Uses

On-site protection of girth welds, tie-ins, welds for boring applications, repairs to FBE, push-rack applications, station piping, fittings and fabrication. Also used for main line pipe coating, sacrificial coating for directional drill and road bore pipe, and rehabilitation of existing pipelines.

Features

- Excellent adhesion (compliments FBE coated pipe)
- Fast cure
- High build (up to 60 mils / 1524 microns in one coat)
- High abrasion resistance for drilling applications
- Can be used as an abrasion resistant coating (ARO)
- Does not shield cathodic protection
- CSA Z 245.30-14 compliant

Application

Spray: Prepare surfaces by grit blasting to a clean near white finish, SSC-SP 10/ NACE No. 2. Heat and check temperature of Part "A" Protal Repair Cartridge to approximately 120°F to 135°F (49°C to 54°C) in a microwave. Convection oven, weld box or other methods (do not overheat and check with a infrared gun). Utilize the Protal Air Cartridge Gun to spray product. A wet on wet spray technique should be used to achieve a minimum thickness of 20 mils (508 microns). The coating thickness should be measured using a wet film thickness gauge.

For complete application instructions please refer to Protal 7200 Air Cartridge Gun Application Specifications.



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Protal 7200 Cartridge (1000 ml)

TECHNICAL DATA

PROPERTIES

VALUE

Solids Content	100%
Mixed Material - (Mixed) @ 77°F (25°C)	
Specific Gravity	1.63
Viscosity	170,000 cps
Color	Green
Mixing Ratio (A/B) by Volume	3 Parts Base: 1 Part Hardener
Cure Times	
Pot Life @ 77°F (25°C)	14 - 17 Minutes
Pot Life @ 97°F (36°C)	7 - 8 Minutes
Handling Time @ 77°F (25°C)	2.5 - 3 Hours
Handling Time @ 117°F (47°C)	1 Hour
Handling Time @ 157°F (69°C)	20 Minutes
Recoat Window	
@ 57°F (14°C)	5 Hours
@ 77°F (25°C)	2 Hours
@ 97°F (36°C)	1 Hour
Theoretical Coverage	14 ft ² /30 mils/liter (1.301 m ² /762 microns/L)
Thickness - Weld Joints / FBE Repairs	
Minimum/Maximum	20/70 mils (508/1778 microns)
Recommended	25 - 30 mils (635 - 762 microns)
Thickness - Bore Pipe	
Minimum/Maximum	40/70 mils (1016/1778 microns)
Recommended	45 - 60 mils (1143 - 1524 microns)
Holiday Detection	125 volts/mil (4,920 V/mm)
Cathodic Disbondment Test (ASTM G95)	
28 Days @ 77°F (25°C)	3 mm
28 Days @ 150°F (65°C)	4 mm
28 Days @ 185°F (85°C)	6 mm
28 Days @ 203°F (95°C)	6 mm
Hardness (ASTM D-2240-02)	Shore D 85 +/-2
Impact Resistance (ASTM G14-04) @ 32°F (0°C)	70.6 in-lbs.
Tabor Abrasion (ASTM 4060-07)	
-1000 cycles, CS-17 wheels, 1000 g. load	1,270 cycles per mil
Gouge Resistance (Partech Test - 40 kg load)	15.4 mils (391 microns)
Dielectric Strength (ASTM D-149)	450 V/mil (17,716 V/mm)
Adhesion to Steel (ASTM D-4541-02)	3,956 psi (27.3 MPa)
Adhesion to FBE (ASTM D-4541-02)	2,579 psi (17.8 MPa)
Service Temperature	-40°F to 203°F (-40°C to 95°C)
Application Temperature	-30°F to 212°F (-34°C to 100°C)

Note: If temperature falls below 50°F (10°C), surface must be preheated and maintained throughout the cure process.

STORAGE: Minimum 24 months when stored in original containers @ 40°F (4°C) to 105°F (41°C). On job site where temperatures are below 50°F (10°C) product should be kept warm to mix properly (65°F to 85°F optimal).

CLEANING: Clean equipment with MEK or equivalent solvent cleaner.

HEALTH AND SAFETY: Apply under well ventilated conditions. Wear suitable protective clothing and glasses. See material safety data sheets.

PACKAGING: 1000 ml dual cartridges. (9 per carton).

Dispensing guns and static mixing tips (1000 ml) sold separately.



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