

PROTAL 7250

Fast Cure, High Build Pipeline Coating

Description

Protal 7250 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 brush or spray applied (referred to as Protal 7200 in USA) 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

- Fast touch dry and set times
- High temperature resistance (up to 185°F)
- High build (up to 50 mils in one coat)
- Excellent adhesion (compliments FBE coated pipe)
- High abrasion resistance for drilling applications
- Safe and environmentally friendly
- Does not shield cathodic protection
- Can be applied with brush, roller or spray
- Available in a variety of packaging options

Application

Prepare surfaces by grit blasting to a clean near white finish, SSC-SP 10/ NACE No. 2. The equipment should be a plural component airless spray unit with a proportioning pump capable of a volume mixing ratio of 3:1. Standard ancillary equipment should include minimum 10 gallon hoppers, 2 ea. static mixers, 25 ft. max x 1/4" whip hose, and mastic gun with a 19 to 27 thou tip. (Applicator should consult with Denso regarding recommended equipment). Part A should be heated to 140°F - 150°F and Part B heated to 100°F - 110°F. Hose bundle shall be set at 140°F - 150°F. A wet on wet spray technique should be used to achieve a minimum thickness of 20 mils. The coating thickness should be measured using a wet film thickness gauge.

For complete application instructions please refer to Protal 7200 application specifications.

Note: Protal 7200 when used for sprays applications, is referred to as Protal 7250 in Canada



Protal 7250

TECHNICAL DATA

PROPERTIES	VALUE
Solids Content	100%
Base Component - (Unmixed) @ 77°F (25°C)	
Specific Gravity	1.63
Viscosity	255,000 cps
Color	White
Hardener - (Unmixed) @ 77°F (25°C)	
Specific Gravity	1.05
Viscosity	5,500 cps
Color	Dark Green
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
Thickness - Weld Joints / FBE Repairs	
Minimum/Maximum	20/60 mils
Recommended	25 - 30 mils
Thickness - Bore Pipe	
Minimum/Maximum	35/60 mils
Recommended	45 - 55 mils
Holiday Detection - based on min. mil. thickness specified	125 volts/mil
Cathodic Disbondment Test (ASTM G95)	
28 Days @ 77°F (25°C)	3 mm
28 Days @ 150°F (65°C)	4 mm
28 Days @ 175°F (80°C)	7 mm
Hardness (ASTM D-2240-02)	Shore D 85 +/-2
Impact Resistance (ASTM G14-88)	60.89 in-lbs.
Adhesion to Steel/FBE (ASTM D-4541-02)	3,200 psi
Application and Service Temperature	-30°F to 185°F (-34°C to 85°C)

Note: If temperature falls below 50°F (10°C), surface must be preheated.

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: Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See material safety data sheet for further information.

PACKAGING: 90 liter & 800 liter kits standard. Dual cartridge repair tubes (400 ml & 50 ml) and dispensing guns available for small repair areas.



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