

ACOTHANE WELDCOAT

PRODUCT DESCRIPTION

A two pack solvent-free polyurethane coating material designed for brush application to pipe girth welds to effect complete corrosion protection in water immersion, soil burial or atmospheric exposure conditions.

USES

Rapid drying and curing characteristics, allowing early completion of coating to recommended film thicknesses (see below).

TECHNICAL PROPERTIES

Colour	Grey, Cream		
Finish			
Curing Agent	Acothane Activator		
Mix Ratio	3 Base : 1 Activator by volume		
Specific Gravity			
Volume Solids	100%		
Recommended Film Thickness	1.0-1.5 mm (two coats) depending on service conditions		
Theoretical Spreading Rate	1 m ² /litre @ 1mm.		
Application Method	Brush		
Flash Point	200°C		
VOC	0 g/litre.		
Drying Times	10°C 20°C 30°C		
Touch Dry		30-45 mins.	
Hard Dry		4 hours	

CERTIFICATION/APPROVALS

RECOMMENDED SYSTEMS

SURFACE PREPARATION

- Steel:** Ensure surfaces are clean, dry and free from oil, grease, salts and other contaminants. Grit blast to minimum BS 7079 standard SA 2 ½ to give recommended surface profile depth of 75-100 microns.
- Overlap Area:** Remove any loose material to establish a firm edge. Feather sound coating (inducing surface roughness) for a distance of 25-50 mm to remove gloss, surface contaminants etc. by suitable method (sweep blasting, abrasive disk etc.).

PRODUCT APPLICATION

Mixing	Activator must be added to base and thoroughly mixed ensuring an even mix throughout the 'pot'. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating on walls has cured. Pot life 8-10 mins. approx. @ 25°C.
Thinners	Do not thin.
Brush	Once mixed use immediately
Roller	
Conventional Spray	
Airless Spray	
Air Assisted Airless Spray	
Cleaner	Thinner No.4
Cleanup Considerations	All equipment should be cleaned immediately after use with Thinner No.4 It is advisable that equipment should be cleaned/flushed during the course of application, the frequency of which will depend on the volume of material used and timescale over which applied. Ensure all waste materials (including packaging) are disposed of in accordance with local regulations.

HEALTH, SAFETY & ENVIRONMENTAL

This product must be used in accordance with the Material Safety Data Sheet supplied by Spencer Coatings Limited.
The user must observe local health, safety and environmental regulations when using this product.
Consult Spencer Coatings Limited if there are any concerns over the suitability of this product.

PACK SIZES

1 litre

PACK WEIGHTS

STORAGE CONDITIONS

Shelf life: 12 months

LIMITATIONS

Normal application requires relative humidity below 80% . To avoid risk of condensation, application should be done only when the temperature of the steel surface is at least 3°C (5°F) higher than the dew point. Application at temperatures below 1°C (33°F) must be watched carefully since the possible presence of ice in the pores of the surface could result in poor adhesion and reduced corrosion protection.

Temperature: At Application: Preferably above 0°C (surfaces free from ice/ condensation)
In Service: Immersion 0 to 70°C depending on solution
Dry -20 to 120°C continuous

<u>TEST</u>	<u>SPECIFICATION</u>	<u>RESULT</u>
Bond Strength	DIN 53232 (Primed and Unprimed Steel)	15 N/mm ²
	DIN 53151 (Cross cut)	Glass G1
Water Vapour Permeability	DIN 52615	0.005 metric/perm.cm
Shrinkage	-	Negligible
Impact	ASTM 2794 – 69/14	20 N.M.
Tensile Strength	DIN 53504/13	20 N/mm ²
Elongation	ASTM D2370	20-35%
Abrasion Resistance	ASTM 4060, CS17, 1 kg. load, 1000 cycles	<100 mg. loss
Shore Hardness	-	'D' 80 approx.
Flexibility	British Gas PS/CW6	Pass 2% strain @ 5°C
Cathodic Disbonding	British Gas GBE/CW6 (28 days @ 20°C) 1500 mV (calomel) 1.5 mm DFT Thickness	Pass

DISCLAIMER

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It is the user's responsibility to ensure that this sheet is current prior to using the product.