



SELECTION & SPECIFICATION DATA

Generic Type	General Purpose Epoxy
Description	A 100% solids technologically advanced epoxy coating designed for general purpose corrosion protection in the Oil and Gas Industry. This product can be applied through standard high-pressure airless spray equipment. It has superior anti-corrosive properties on the exterior of steel pipelines for above and below ground service.
Features	<ul style="list-style-type: none">• Excellent resistance to cathodic disbondment up to 65°C (149°F)• Excellent adhesion to grit blasted steel surfaces, fusion bond epoxy, liquid epoxy, and urethane coatings• 100% Solids• High build one-coat application• Standard high-pressure airless application
Typical Uses	<ul style="list-style-type: none">• Coating for pipelines, girth welds, and rehabilitation of existing pipelines• Lining for pipes and tanks
Color	Green (0300)
Dry Film Thickness	20 - 50 mils (508 - 1270 microns) DFT Depends upon application. Consult with an SPC Representative
Solids Content	By Volume 100%
Theoretical Coverage Rate	1604 ft ² /gal at 1.0 mils (39.4 m ² /l at 25 microns) 80 ft ² /gal at 20.0 mils (2.0 m ² /l at 500 microns) 32 ft ² /gal at 50.0 mils (0.8 m ² /l at 1250 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 2 g/L
Dry Temp. Resistance	Continuous: 149°F (65°C)
Specific Gravity	Base: 1.76±0.03 Hardener: 1.05±0.03 Mixed: 1.64±0.03

SUBSTRATES & SURFACE PREPARATION

Steel	Cleanliness: NACE No. 2/SSPC SP-10, Sa 2.5 (ISO 8501-1) Profile: 62.5 microns minimum to 125 microns maximum (2.5 mils to 5.0 mils)
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PRODUCT DATA SHEET



PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

Test Method	Results
Adhesion to Steel (Hot Water Soak) (CSA-Z245.20)	28 days @ 75°C (167°F): Rating #2-3
Adhesion to Steel (Pull Off Strength) (ASTM D4541)	>17.24 MPa (>2500 psi) @ 25°C (77°F)
Cathodic Disbondment Resistance (CSA-Z245.20)	28 days @ 65°C (149°F): 6.5 mmR
Flexibility (CSA Z245.20, Clause 12.11)	1.14°PPD @ 40°C (104°F) 0.97°PPD @ 30°C (86°F) 0.97°PPD @ 21°C (70°F) 0.48°PPD @ 0°C (32°F) 0.47°PPD @ -30°C (-22°F)
Hardness (ASTM D2240)	25°C (77°F): 70 Shore D
Impact Resistance (CSA Z245.20, Clause 12.12)	1.5 J (1.1 ft-lbf) @ 25°C (77°F) 1.5 J (1.1 ft-lbf) @ 0°C (32°F) 1.5 J (1.1 ft-lbf) @ 30°C (-22°F)
Penetration Resistance (ASTM G17)	3 days @ 100°C (212°F): No penetration
Taber Abrasion Resistance (ASTM D4060, CS-17 Wheel, 1 kg, 5000 cycles)	Average weight loss 355.13 mg @ 21°C (70°F)

MIXING & THINNING

Mixing	After mixing the two components, allow the mixed material five (5) minute induction period or sweat in time before use. Component Details for Color: Green (0300): The Base is Green (0300) and the Hardener is Amber (0908)
Thinning	Do not thin.
Ratio	<ul style="list-style-type: none">• 4.87:1 Base to Hardener, by Volume• Materials are packaged in exact ratio.
Pot Life	Brush Grade: 90 minutes at 25°C (77°F)

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Brush Grade	Brush or Roller
Spray Grade	Airless Spray System Graco King 50:1 or manufacture approved equivalent Tip Size: 0.021-0.031



APPLICATION CONDITIONS

Table with 3 columns: Condition, Material, Surface. Rows for Minimum and Maximum values.

Ambient temperature: Minimum 10°C (50°F)
The temperature of the Base and Hardener should be between 30°C–35°C (86°F–98°F) prior to mixing.
Applications at temperatures at or below dew point require preheating of the substrate.

CURING SCHEDULE

Table with 2 columns: Surface Temp., Dry Hard (Spray Grade). Rows for 50°F, 77°F, and 95°F.

As per ASTM D1640
Base and Hardener material temperature: 25°C (77°F).
Note: The information above is to serve as a guide only. The test results were compiled under laboratory-controlled conditions.
Field results may vary due to variable conditions such as radiant heat loss and the cooling effects of wind.
Touch Dry: 3 hours @ 25°C (77°F)

Recoat Interval | Brush Grade
0°C (32°F) @ 50% RH: Maximum 2 hours
Spray Grade
0°C (32°F) @ 50% RH: Maximum 2 hours
The recommended Recoat Intervals are general guidelines only. The Recoat intervals may vary significantly due to variable conditions including but not limited to, humidity, surface temperature, and product application temperature. Contact your SPC representative for assistance in determining minimum and maximum recoat intervals specific to your application.

CLEANUP & SAFETY

Cleanup | Carboline Thinner 2 or SP-100 Equipment Wash
Safety | Refer to SPC's Safety Data Sheet prior to use. Carefully read and follow all safety instructions on labels and packaging. Handle and store material with care in accordance to the Safety Data Sheet. Follow and observe any applicable local or national laws and regulations.

PACKAGING, HANDLING & STORAGE

Shelf Life | A maximum of 24 months from the date of manufacture if the materials are in unopened containers.
Storage | Store in a cool, dry, well-ventilated area at temperatures between 5°C (41°F) and 50°C (122°F). Keep in a tightly sealed container when not in use. DO NOT FREEZE.
Packaging - Brush Grade | 1 Liter (0.26 Gallon) Kit
Part A: 0.83 liters (0.21 gallons)
Part B: 0.17 liters (0.05 gallons)
Packaging - Spray Grade | 16 Liter (4.2 Gallon) Kit
Part A: 13.27 liters (3.5 gallons)
Part B: 2.73 liters (0.72 gallons)

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WARRANTY

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