

SELECTION & SPECIFICATION DATA

Generic Type	High density cementitious fireproofing designed for the fire protection of exterior and interior structural steel.
Description	A 55 lb./ft ³ (881 kg/m ³) density, Portland cement based, cementitious fireproofing. It provides both hydrocarbon and cellulosic fire protection for structural steel and can also be used to upgrade the fire resistance of existing concrete. Recommended areas of application include refineries, petrochemical, pharmaceutical facilities, pulp and paper mills, offshore platforms, nuclear and conventional power plants, factories, warehouses, institutional and biomedical facilities.
Features	<ul style="list-style-type: none"> • Over 40 years of proven performance • Exceptional durability and toughness • Tested and approved for exterior use by Underwriters Laboratories Inc • UL 1709 hydrocarbon fire rated up to 4 hours • BS 476 hydrocarbon fire rated up to 4 hours • ISO 22899-1 jet fire rated up to 2 hours • ASTM E119 cellulosic fire rated up to 4 hours • Cryogenic protection against LNG spills and immersion exposures • Resistant to 3 bar blast overpressure • Hose stream resistant • Tolerant to wide range of climates • Lightweight – one-fifth the weight of concrete for equal fire protection • Ideal for onsite and offsite application • Easy application by spray or trowel • Nonflammable – during or after application • Chloride and sulfide free – no special priming required • Asbestos-free – complies with EPA and OSHA regulations • Non-friable – high impact strength
Colour	Non-Uniform Speckled Gray Product colour may vary due to variations in colour of Portland cement.
Finish	Textured If a smooth finish is required, this may be achieved by trowel, roller or brush typically within 1 to 2 hours after final application of Pyrocrete 241.
Primer	Pyrocrete 241 neither promotes nor prevents corrosion. The fireproofing should not be considered as part of the corrosion protection system. For applications where primers are required, use a Carboline approved, alkaline resistant primer. Pyrocrete 241 must meet minimum UL bond strength criteria for contour applications where primers are used. Contact the Carboline Fireproofing Technical Service for further information and approved primers.
Application Thickness	12.5 - 16 mm (1/2" - 5/8") on initial pass
Theoretical Coverage Rates	<p>3.37 m² @ 10 mm thick per 22.7 kg bag 13.3 board foot per bag @ 55 pcf 1.23 m² @ 25.4 mm thick @ 881 kg/m³</p> <p>Field results will vary depending upon application parameters. Coverage based on theoretical gross yield without loss. Material losses during mixing and application must be taken into account when estimating project requirements.</p>
Limitations	Not recommended for use as a refractory cement or where <u>continuous</u> operating temperatures exceed 93°C.

SELECTION & SPECIFICATION DATA

Topcoats	<p>Generally not required. In severely corrosive atmospheres, topcoats may be used for added durability and chemical resistance. consult Carboline Fireproofing Technical Service for selection of the coating most suitable for the operating environment.</p> <p>Seal Coat – In corrosive environments, use an appropriate topcoat. If topcoating is required, apply Carboguard 1340 as a seal coat. Carboguard 1340 shall be thinned 25% with Thinner #2. Carboguard 1340 may be applied 24 hours after final application of Pyrocrete 241. Consult the Carboguard 1340 Product Data Sheet for minimum and maximum cure times.</p> <p>Top Coat – Surface hardness of the sealed Pyrocrete 241 should be a minimum Shore D64 as measured with a Durometer prior to application of the topcoat. Normally, this minimum dry time is 10 days at 21°C or 40 days at 4°C, for thickness of 25.4 mm (1”) or less.</p> <p>Caulking – For exterior installations, Acrilast caulk should be applied at all termination joints between Pyrocrete 241 and the substrate. Contact Carboline Fireproofing Technical Service for full information.</p>
-----------------	---

SUBSTRATES & SURFACE PREPARATION

General	Before applying Pyrocrete 241, the substrate coating must be free of all oil, grease, condensation, or other contamination.
Steel	If primer is required, steel preparation before priming should be done in accordance with the recommended primer’s product data sheet. Contact Carboline Fireproofing Technical Service for approved primers.
Galvanized Steel	Pyrocrete 241 is usually applied directly over galvanized surface. All galvanising must be degreased in accordance with SSPC SP1, and must be abraded to achieve a surface profile of no less than 25µm. Avoid removal of the zinc during abrasion. If priming is required, contact Carboline Fireproofing Technical Service for recommendations.
Concrete	The recommended primer to seal concrete prior to applying Pyrocrete 241 is Carboguard 1340.
Non-Ferrous Metals	Aluminum, copper and other non-ferrous metals shall be primed with one coat of Carboline's Rustbond Penetrating Sealer.
Lathing & Attachments	<p>3.4 lb./yd² (1.85 kg/m²) galvanized metal lath, may be pre-bent and tie-wired into place for appropriate design. Optionally, beam furring clips or electrically welded, pneumatic or self-tapping screws or studs, may be used.</p> <p>Contour Design - 1.85 kg/m² galvanized metal lath wrapped around the flange edges toward the web approximately 38 mm (1½”). Contour column designs allow the use of 50 mm x 50 mm (2"x 2") galvanized or PVC coated hexagonal metal mesh with beam furring clips as an alternate to the 1.85 kg/m² galvanized metal lath. Plastic-nosed corner beads may also be used for better thickness control and aesthetics on flange edges of steel. Please refer to design details. For contour applications on structural members with web span greater than 16” (406 mm) or flange widths greater than 12” (304 mm) refer to the UL Fire Resistance Directory under “Coating Materials” section.</p> <p>Boxed Design - 1.85 kg/m² galvanized metal lath wrapped around member spanning the web, overlapped 25 mm (1”) and tie-wired on the flange face 305 mm (12”) on centre. For large webbed members, additional support for lath may be needed for ease of installation. Plastic-nosed corner beads may also be used for better thickness control and aesthetics.</p> <p>Tower Skirts and Flat Surfaces - Require that 1.85 kg/m² galvanized metal lath be anchored on 305 mm to 610 mm (12” to 24”) centres depending upon requirements. The lath should overlap and be tie-wired. On tower skirts only, PVC coated mesh can be used in lieu of 1.85 kg/m² galvanized lath. Mesh shall be 50 mm x 50 mm (2” x 2”) 0.81 mm (20 gauge) wire coated with PVC as furnished by Carboline.</p>

SUBSTRATES & SURFACE PREPARATION

When ram set or welding is prohibited; a pneumatic fastener may be used. On very large areas, control joints are made by scoring halfway through the thickness of Pyrocrete. This is achieved by using the trowel blade edge or an appropriate scoring tool. A preferred option would be the use of plastic-nosed corner beads. Spacing should be on 3 metre (10') centres, both horizontally and vertically. Please refer to design details or contact Carboline Fireproofing Technical Service.

PERFORMANCE DATA (TYPICAL VALUES)

Test Method	Results
ASTM D2240 Durometer Hardness (Shore DO)	83
ASTM D2794 Impact Resistance	Pass (No cracking at 20 foot pounds)
ASTM E605 Density ¹	55 lb./ft ³ (881 kg/m ³) (minimum average)
ASTM E736 Bond Strength (Unprimed Steel) ²	22,026 psf (1,054 kPa)
ASTM E759 Deflection	Pass
ASTM E760 Bond Impact	Pass
ASTM E761 Compressive Strength	1,111 psi (7.6 MPa)
ASTM E84 Flame Spread	0
ASTM E84 Smoke Development	0
ASTM E937 Corrosion	0.00 gm/mm ²
Coverage 50 lb. (22.7 kg) bag	13.3 Bd.Ft. (1.23 m ² @ 25 mm)
Explosion Resistance	3 bar
Hose Stream Resistance	Pass
Shrinkage	<0.5%

• 1. Air dry at ambient conditions until constant weight is achieved. Do not force dry. Use ASTM E605 Positive Bead Displacement modified to use 1 mm ceramic beads.

• 2. Bond strength testing performed utilizing ASTM E736 with AWCI Technical Manual 12-A modifications.

All test data above was generated under laboratory conditions. Field testing results may vary. Physical property data was derived using 17.01 litres (4.5 gallons) of water per 50 lb. (22.7 kg) bag.

Material shall reach a hardness of Shore DO 64 prior to handling and topcoating.

Test reports and additional data available upon written request.

MIXING & THINNING

Mixer | Use a heavy-duty mortar mixer rotating at 40 rpm with rubber tipped blades that will scrape the sides and bottom of the mixer. A 50 lb. (22.7 kg) bag of Pyrocrete 241 typically requires a mixer volume of 230 litres (8 ft³) minimum. **Do not use pan type mixers.**

Mixing | **Target water level:** 17 litres (4.5 US gallons)
Add 17 litres ± 1.9 litres (4.5 gallons +/- 0.5 gallons) of clean, potable water to a mortar mixer with rubber tipped blades. With mixer running slowly, add powder and mix for 5 minutes (10 minutes maximum) until a homogeneous mortar-like consistency is achieved. Longer mixing times may result in lower densities. Total water must not exceed 19 litres (5 gallons) per 50 lb. (22.7 kg) bag. In cool weather, warm water may be used to enhance application. In hot weather, chilled water may be used.

Pot Life | 2 hours at 21°C and less at higher temperatures. Pot life ends when the material thickens and becomes unusable. Do not re-temper material.

Density | **Target wet density:**
1.217-1.313 kg/m³ (76 - 82 lb./ft³). Wet density measurements are critical to obtaining correct dry densities. When checking wet densities, use the following procedures:
Equipment needed:

MIXING & THINNING

- 1 litre (1000 cc) polyethylene cup
- Small metal spatula
- Scale accurate to 1 gram

Determination of Pyrocrete wet density:

- Weigh the empty cup to the nearest gram, then tare the scale.
- Use the spatula to fill the cup completely with mixed material (do not tamp cup).
- Remove the excess material on top by placing the vertical edge of the spatula on the top edge of the cup. Use a sawing motion to level the mixed Pyrocrete material flush with the top of the cup.
- Weigh the filled cup to the nearest gram.
- Record the weight of material in grams. This value equals the wet density in grams/litre and kg/m³
- To calculate the wet density of the material in lb./ft³, multiply the value in grams/litre by 0.0624.

Contact Carboline Fireproofing Technical Service for additional details.

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.

Pump	<p>This material can be pumped with a wide range of piston, rotor stator and squeeze pumps designed to pump cement & plaster materials including: Essick - model# FM9/FM5E (Rotor Stator/2L4) Putzmeister - model# S5EV(Rotor Stator/2L6) Hy-Flex - model# HZ-30E(Rotor Stator/2L6) Hy-Flex - model# H320E (Piston) Strong Mfg. - model# Spraymate 60 (Rotor Stator/2L6) Airtech - model# Swinger (Piston) Mayco - model# PF30 (Dual Piston) Thomsen - model# PTV 700 (Dual Piston)</p>
Trowel	<p>Standard plasterers' hawk and trowel may be used. A rubber float may also aid in finishing.</p>
Material Hose	<p>Minimum 25 mm (1") I.D. hose with 300 psi minimum bursting pressure. For lengths over 15 metres (50') use 38 mm (1½") I.D. hose. Do not reduce hose diameter by more than 6.4 mm (¼") per 8 metres (25') unless a tapered conical reducer equipped with swivel fitting is used. A 3 metre length of 25 I.D. hose may be added at the gun for use as a whip.</p>
Nozzle/Gun	<p>Binks - part# 7E2 (47-49 fluid tip / 3/8"-1/2" air cap) Graco - part# 204000(3/8" - 1/2" fluid tip / air cap) Speeflow - part# 701(3/8" - 1/2" fluid tip / air cap) Airtech - Internal mix with 3/8" - 1/2" fluid tip Standard plasterers gun with 3/8" - 1/2" fluid tip</p>
Compressor	<p>Be certain that the air supply is a minimum 22 cfm at 100 psi (689 kPa) and higher when distances longer than 75' (22 m) are required.</p>
Air Line	<p>Use 12.5 mm (½") I.D. line, with a minimum bursting pressure of 100 psi.</p>

APPLICATION PROCEDURES

General	<p>Pyrocrete 241 may be applied by spray and/or trowel. Material build will depend on application method, weather conditions and equipment used. For application overhead, a scratch coat of up to 12.5 mm (½") is recommended to key into the lath. Allow to set for approximately 1 to 2 hours at 21°C before applying the subsequent coats. It is recommended that the total required thickness be applied within a 24 hour period. If this is not possible, the preceding coats should be left as a coarse sprayed finish or scored after application. Product must be dampened with water before application of additional coats.</p> <ul style="list-style-type: none"> • Maximum time to achieve the full thickness is 3 days at 21° and 50% relative humidity. This would be less at higher temperatures. • All additional coats are applied monolithically to the entire perimeter of the member. • At no time shall Pyrocrete 241 be applied at a thickness less than 6 mm (¼") or "skim" coated.
Finishing	<p>Material can be left as sprayed or finished with a trowel for better aesthetics.</p>

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	5°C (41°F)	5°C (41°F)	5°C (41°F)	0%
Maximum	38°C (100°F)	51°C (124°F)	43°C (109°F)	95%

CURING SCHEDULE

Surface Temp.	Dry to Recoat
21°C (70°F)	2 Hours

Fresh Pyrocrete 241 must be protected from rain or running water for 24 hours at 21°C. In low humidity, high temperature, direct sun or wind, the Pyrocrete surface should be kept damp for at least 12 hours by applying a water mist or wrapping in plastic sheets to reduce rapid water loss.

Caution: Do not start work if ambient temperatures are expected to drop below 2°C for 24 hours after application. Material shall reach a hardness of Shore DO 64 prior to handling and topcoating. For shipping and handling instructions of shop applied Pyrocrete 241 Series materials to individual steel members or modular steel sections, please contact your local Carboline Sales Representative or Carboline Fireproofing Technical Service.

CLEANUP & SAFETY

Cleanup	<p>Pump, mixer and hose should be cleaned with clean, potable water at least once every 4 hours at 21°C, and more often at higher temperatures. Sponges should be run through the hoses to remove residual material. Wet Pyrocrete 241 overspray must be cleaned up with soapy or clean, potable water. Cured overspray may require chipping and/or scraping to remove.</p>
Safety	<p>Follow all safety precautions on the Material Safety Data Sheet. It is recommended that personal protective equipment be worn, including spray suits, gloves, eye protection and respirators.</p>
Overspray	<p>Adjacent surfaces shall be protected from damage and overspray. Sprayed fireproofing materials may be difficult to remove from surfaces and may cause damage to architectural finishes. Cured overspray may require chipping and/or scraping to remove.</p>
Ventilation	<p>In enclosed areas, ventilation shall be 4 complete air exchanges per hour until the material is dry.</p>

TESTING / CERTIFICATION / LISTING

Underwriters Laboratories, Inc.	<p>Pyrocrete 241 has been tested by Underwriters Laboratories, Inc. and is classified for exterior or interior use by UL in the following designs: UL 1709 Rapid temperature rise hydrocarbon fire exposure Columns – XR701, XR702, XR734, XR738 BS 476: Part 20: Appendix D hydrocarbon fire exposure Columns – Report No. R11193 Cryogenic Testing Tested in accordance to “Specification for Cryogenic Protection and Passive Fire Protection of Structural Members”, dated March 2006 from South Hook LNG Terminal Company Ltd. Additional splash and spill testing perform at varying flow rates. All testing has been witnessed by UL. ASTM E119 (UL 263, NFPA 251) Cellulosic fire exposure Columns - X732, X733, X735, X736, X743, X744, Y707, Y708 Roof Assembly – P734, P735, P736, P737, P738, P739, P926, P927, P928, P929, G706, G707, G708, J713, J714, J715, J716 Beams – N715, N716, N717, N718, N771, N772, N773, N774, N775, S706, S713, S731, S732, S733 Floor Ceiling Assembly – D744, D767, D768, D769, D770, D771, D772, D773, D774, D775, D776, D777, D927, D928 Walls – U704</p>
City of New York	<p>MEA No. 172-80-M (Columns) MEA No. 173-80-M (Columns W14x233) MEA No. 174-80-M (Beams)</p>
City of Los Angeles	<p>RR24763</p>
FM Global	<p>Tested and listed by FM Global for structural Test and LPG vessels at 3/8” (10mm) thickness from face of metal lath for 2 hour rating, including hose stream endurance test.</p>
City of San Francisco	<p>164 C57.7A</p>
Det Norske Veritas	<p>3 bar overblast protection</p>
Lloyd's Register	<p>J-120 jet fire protection - certificate No. SAS F130010</p>

PACKAGING, HANDLING & STORAGE

Shelf Life	24 months (minimum) when kept at recommended storage conditions.
Shipping Weight (Approximate)	50 lb. (22.7 kg)
Storage	<p>Store indoors in a dry environment between -29°C - 66°C</p> <p>Material must be kept dry or clumping may occur.</p>
Packaging	50 lb. (22.7 kg) bags

WARRANTY

Manufactured and / or distributed in Australia & New Zealand by Altex Coatings under license to Carboline Company. To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Altex Coatings to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance or injuries resulting from use. Liability, if any, is limited to replacement of products. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY ALTEX COATINGS OR CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated. Altex Terms and Conditions of Trade, available at www.altexcoatings.com, apply in respect of all coating products and materials supplied, including samples.