

TECHNICAL DATA SHEET

ARMAMASTIC[®]

Description

A two-pack, high solids epoxy resin based coating designed for application to steel substrates prepared to the standard ST2 minimum, mill scale free. The product will cure down to -10°C and can be brush or spray applied.

Uses

For the corrosion protection of the externals of steel structures in aggressive environments. Provides good resistance to water, sea water and dilute acids for offshore platforms, pipelines, valves, tanks for refineries, petrochemical & chemical units.

Features

- Salt Water resistance Good
- Chemical resistance Good
- Water resistance Good
- Substrate wetting Good
- Flexibility Good
- Impact resistance Good
- Abrasion resistance Good

Surface preparation

Steel surfaces must be clean from all contamination, such as grease, dirt, oil and salt. Grease and oil must be removed with a suitable degreaser. Cleaning can be carried out using hand or power tool e.g. needle guns, to ST2, minimum.

Refer to Armamastic Method Statement.

Mixing and Application

The product is supplied in pre-weighed kits, Part A Base and Part B Hardener. Mix Part A & Part B thoroughly for at least two minutes, using a mechanical mixer until homogenous. Do NOT thin or split packs.

First apply Armamastic Weld Coat (see Technical Data Sheet and Application Method Statement) to all sharp edges, exterior weld areas, bolt areas, etc. before application of the first coat of Armamastic. Allow to dry (1-2 hours) before application of next coat.

May be spray or brush applied. When spraying use a 68:1 airless spray machine, Tip size 521-535.

During application the steel substrate temperature must be at least +10°C and at least 3°C above the dew point. Humidity must be below 90%.

When applying the product carry out regular wet film thickness tests with a film thickness comb to ensure even thickness. Ensure adequate ventilation of enclosed areas during application.

Epoxy coating will chalk when exposed directly to sunlight.

First Coat

| | |
|--------------------------------------|---|
| Colour | Grey |
| Film Thickness dry (um) | 200 (typical) |
| Film Thickness wet (um) | 250 (typical) |
| Application rate (m ² /l) | 2.5 to 5 depending on surface roughness |

Subsequent coats:

As first coat

Application

| | |
|---|---------------|
| Mixed density at 30°C | 1.2 |
| Pot life at 30°C | 40 minutes |
| Drying time at 30°C -touch dry | 3 Hours. |
| Overcoating time at 30°C | 6 Hours |
| Maximum humidity | 90% |
| Minimum dewpoint/substrate Differential (steel) | Dewpoint +3°C |

Properties

| TEST METHOD | STANDARD | UNIT | VALUE |
|------------------------------------|-----------------|-------------|--------------|
| Volume Solids | | % | 88 ± 2 |
| Shore D hardness | ASTM D2240 | | 86 |
| Tensile strength | ASTM D638 | MPa | 4.2 |
| Flexural strength | ASTM D790 | MPs | Pass |
| % Elongation | ASTM D638 | MPa | 28.0 |
| Taber Abrasion | ASTM D4060 | mg | 65 |
| Water vapour permeability test | ASTM D1653 | MPa | 0.13 |
| Pull off adhesion on rusted sample | ASTM D4541 | MPa | 6.2 |
| Salt Spray test 2000 hrs | ASTM B117 | hrs | Pass |
| Humidity test 2000 hrs | ASTM D2247 | hrs | Pass |
| Cathodic disbondment | ASTM G-8 | mmr | 1.2 |
| QUV resistance 1000 hrs | ASTM G-53 | hrs | Pass |

Thinning and Cleaning

Clean tools with Diacetone alcohol or styrene. Do not thin.

Storage

Store in a dry, well ventilated area, away from direct sunlight, maximum temperature 35°C.

Shelf life

12 months.

Packaging

Armacoat standard packing size.

Health and safety

Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes.

Refer to material Safety Data Sheet.

Contact Information



<http://armaccoat.in>

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