

# ARCHCO 453HTP EPOXY

## Abrasion Resistant Internal Epoxy Phenolic-Novolac Lining for Pipes

### Description

Archco 453HTP Epoxy is a two-part, high-temperature resistant, epoxy phenolic-novolac system designed for internal pipe linings requiring excellent chemical and temperature resistance over a wide range of temperatures and pressures. It is available in 88% solids or 100% solids systems for single-leg airless or plural component spray applications.

### Uses

Corrosion protection for steel internal pipes in a variety of industries. The coating will protect piping against crude oil, seawater, wastewater, fuels, solvents, and lubricants up to 325°F (163°C).

### Features

- Very low permeability
- Excellent adhesion
- Excellent chemical resistance
- Excellent resistance to H<sub>2</sub>S gases
- Excellent temperature resistance (up to 325°F / 165°C)
- Excellent abrasion resistance
- Improved performance with heat soak

### Application

All contaminants shall be removed from the steel surface to be coated. Oil and grease should be removed in accordance to SSPC-SP-1. Prepare surfaces by grit blasting to a clean near-white finish, SSPC-SP 10, NACE No. 2 or Sa 2-1/2. Appropriate angular grit shall be used to achieve a 3 to 5 mil (76 - 127 microns) anchor profile. 453HTP can be applied over blasted surfaces that have been treated by a soluble salt remover or an rust inhibitor.

To spray the 100% solids version of Archco 453HTP Epoxy, a plural-component, airless spray unit with a proportioning pump capable of a volume mixing ration of 4:1 shall be used. Standard ancillary equipment should include minimum 10 gallon (38 liters) hoppers, 2 each static mixers, 25 ft. max x 1/4" (7.6 m x 6.3 mm) whip hose, and mastic gun with a 23 to 31 thou tip. Part A should be heated to 100°F-120°F (38°C-49°C) and Part B should be heated to 90°F-110°F (32°C-43°C). Hose bundle shall be set at 100°F-120°F (38°C-49°C). A single-leg, airless spray unit shall be used with the 88% solids version. On the single-leg airless unit, it shall be a minimum of 68:1 airless pump. When using an airless unit, the Archco 453HTP should not be thinned more than 5% with Archco 400E Thinner (3 lbs /1.4 kg per 5 gal /19 liters kit).

A wet-on-wet spray technique should be used to achieve a minimum thickness of 20 to 40 mils (508 to 1016 microns) DFT in one coat with nothing over 60 mils (1524 microns) DFT unless approved by Denso. The coating thickness should be measured using a wet-film thickness gauge. The equipment settings are only guidelines and may vary based on equipment and specific application.



