

DENSO WELD BEAD FILLER

Thick Mastic Pipeline Filler Tape

Description

Denso Weld Bead Filler Tape is a synthetic fiber fabric impregnated and coated with polymer modified bitumen adhesive. The outer surface of the tape is protected by a high density polyethylene backing.

Uses

A cold applied polymer bitumen tape designed for application to longitudinal, spiral or circumferential weld beads on pipelines prior to the application of Densoclad, Densopol or Densotherm tapes. Also, can be used as a step down tape for steel sleeves. The thick mastic coating conforms to the weld profile and prevents tenting.

Features

- Excellent adhesion
- Provides extra protection at vulnerable areas
- Conforms to weld bead profile
- Consistent uniform thickness
- Easily applied with no special equipment
- Compatible with common pipe coatings
- Excellent resistance to cathodic disbonding

Application

Prepare surfaces by removing all loose scale, rust or other foreign matter by grit blasting or power wire brush. Apply a thin uniform coat of Denso Primer D to all surfaces to be wrapped and allow to tack dry. Apply Denso Weld Bead Filler Tape longitudinally, spirally or circumferentially around weld beads.

For step down of sleeve application: The thickness of a steel sleeve to pipe can be approximately 3/4" - 1" (18.75 - 25 mm) therefore Denso Weld Bead Filler Tape can be used to provide a gradual contour from sleeve to pipe. Apply Denso Weld Bead Filler Tape circumferentially with a 50% overlap starting at the end of the sleeve and proceeding minimally 12" (300 mm) past each side of the sleeve onto the pipe. Apply as many layers circumferentially as needed to create a gradual step down effect from each side of the sleeve. Press down and mold the adhesive into the annular space around the end of the sleeve making sure the tape is in contact with the sleeve. In colder weather, a light heating of the adhesive with a propane torch of the Weld Bead Filler Tape will be required to achieve more conformability and tackiness. In warmer weather, no heating of the bitumen adhesive is required. After a gradual step down is achieved apply a Densopol 60 or Densotherm Tape to the entire area including the steel sleeve and on top of the Denso Weld Bead Filler Tape.



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Property Specifications

PROPERTIES	ENGLISH	METRIC
Thickness (ASTM D1000)		
Backing	1 mils	0.025 mm
Adhesive	105 mils	2.675 mm
Total	106 mils	2.700 mm
Weight	0.57 lbs/ft ²	2.8 kg/m ²
Breaking Strength (ASTM 1000)	40 lbf/in.	350 N/50 mm
Elongation @ Break	22%	22%
Adhesion Peel Strength (ASTM D1000)		
To Primed Steel	8.5 lbf/in.	1.5 N/mm
To Self	8.5 lbf/in.	1.5 N/mm
Impact Strength (ASTM G-14)	5.9 ft lb	5.9 ft lb
Dielectric Strength	20 Kv	20 Kv
Resistance to Cathodic Disbondment (ASTM 6-8 30 Days Group B)	.78 in ² ang.	500 mm ²
Maximum Service Temperature	140°F	60°C
Recommended Holiday Test Voltage		
Single Layer	10 Kv	10 Kv
Double Layer	15 Kv	15 Kv
Roll Length	66 ft.	20 m
Recommender Primer	Denso Primer D	

Packaging

Roll Width	Roll Length	Rolls*/ Case
in.	ft.	ea.
3" (75 mm)	66' (20 m)	4

Other roll widths are available on request.

STORAGE: Keep in cool dry place. Denso Weld Bead Filler has a 2 year shelf life from date of manufacture when stored at or below 80°F (27°C).



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