

PROTAL 7250

Fast Cure, High Build Pipeline Coating

Description

Protal 7250 is a VOC free, 100% solids, 2 part epoxy coating specially formulated to compliment FBE coated pipe. It is a high build liquid coating that is spray applied in one coat in the field or shop. It cures very fast to allow quick handling and backfill times.

Uses

On-site protection of girth welds, tie-ins, welds for boring applications, repairs to FBE, push-rack applications, station piping, fittings and fabrication. Also used for main line pipe coating, sacrificial coating for directional drill (ARO) and road bore pipe, and rehabilitation of existing pipelines.

Features

- Fast touch dry and set times
- High temperature resistance up to 203°F (95°C)
- Excellent adhesion (compliments FBE coated pipe)
- High abrasion resistance for drilling applications
- Can be used as an abrasion resistant coating (ARO)
- Safe and environmentally friendly
- Does not shield cathodic protection
- Available in a variety of packaging options
- Meets AWWA C-210-92 specifications
- CSA Z 245.30-14 compliant

Application

Spray: Prepare surfaces by grit blasting to a clean near-white finish, SSPC-SP 10/NACE No. 2. The equipment should be a plural component airless spray unit with a proportioning pump capable of a volume mixing ratio of 3:1. Standard ancillary equipment should include minimum 10 gallon (37.85 liter) hoppers, 2 ea. static mixers, 25 ft. (7.3 m) max x 1/4" (0.64 cm) whip hose, and mastic gun with a 19 to 27 thou tip. (Applicator should consult with Denso regarding recommended equipment). Part A should be heated to 140°F - 167°F (60°C - 75°C) and Part B heated to 110°F - 131°F (43°C - 55°C). Hose bundle shall be set at 140°F - 167°F (60°C - 75°C). A wet on wet spray technique should be used to achieve a minimum thickness of 20 mils (508 microns). The coating thickness should be measured using a wet-film thickness gauge. The equipment settings are only guidelines and may vary based on equipment.

For complete application instructions please refer to manufacturer's qualified application procedure (MQAP).



Protal 7250

TECHNICAL DATA

PROPERTIES	VALUE
Solids Content	100%
Mixed Material - (Mixed) @ 77°F (25°C)	
Specific Gravity	1.63
Viscosity	170,000 cps
Color	Green
Mixing Ratio (A/B) by Volume	3 Parts Base: 1 Part Hardener
Cure Times	
Pot Life @ 77°F (25°C)	14 - 17 Minutes
Pot Life @ 97°F (36°C)	7 - 8 Minutes
Handling Time @ 77°F (25°C)	2.5 - 3 Hours
Handling Time @ 117°F (47°C)	1 Hour
Handling Time @ 157°F (69°C)	20 Minutes
Recoat Window	
@ 57°F (14°C)	5 Hours
@ 77°F (25°C)	2 Hours
@ 97°F (36°C)	1 Hour
Theoretical Coverage	14 ft ² (1.3 m ²)/30 mils/liter
Thickness - Weld Joints / FBE Repairs	
Minimum/Maximum	20/70 mils (508/1178 microns)
Recommended	25 - 30 mils (635 - 762 microns)
Thickness - Bore Pipe	
Minimum/Maximum	40/70 mils (1016/1178 microns)
Recommended	45 - 60 mils (1143 - 1524 microns)
Holiday Detection	125 volts/mil (4,920 V/mm)
Cathodic Disbondment Test (ASTM G95)	
28 Days @ 77°F (25°C)	3 mm
28 Days @ 150°F (65°C)	4 mm
28 Days @ 185°F (85°C)	6 mm
28 Days @ 203°F (95°C)	6 mm
Hardness (ASTM D-2240-02)	Shore D 85 +/-2
Impact Resistance (ASTM G14-04) @ 32°F (0°C)	70.6 in-lbs.
Tabor Abrasion (ASTM 4060-07)	
-1000 cycles, CS-17 wheels, 1000 g. load	1,270 cycles per mil (93 mg)
-5000 cycles, CS-17 wheels, 1000 g. load	1,612 cycles per mil (338 mg)
Gouge Resistance (Partech Test - 40 kg load)	15.4 mils (391 microns)
Dielectric Strength (ASTM D-149)	450 V/mil (17,716 V/mm)
Adhesion to Steel (ASTM D-4541-02)	3,956 psi (27.3 MPa)
Adhesion to FBE (ASTM D-4541-02)	2,579 psi (17.8 MPa)
Service Temperature	-40°F to 203°F (-40°C to 95°C)
Application Temperature	-30°F to 212°F (-34°C to 100°C)

Note: If temperature falls below 50°F (10°C), surface must be preheated and maintained throughout the cure process.

STORAGE: Minimum 24 months when stored in original containers @ 40°F (4°C) to 105°F (41°C). On job site where temperatures are below 50°F (10°C) product should be kept warm to mix properly (65°F to 85°F optimal). Do not allow material to freeze.

CLEANING: Clean equipment with Xylene, MEK, Acetone or equivalent solvent cleaner.

HEALTH AND SAFETY: Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See material safety data sheet for further information.

PACKAGING: 75 liter & 800 liter kits standard.



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