



Denso Protal 7900HT

High Temperature Pipeline coating

Composition

Denso Protal 7900HT is a VOC free, 100% solids, 2-component epoxy coating.

Uses

Denso Protal 7900HT is used for coating pipelines operating at high temperatures.

Characteristics

Denso Protal 7900HT:

- Cures quickly when applied to hot pipe (allowing fast backfill),
- Can be spray or brush applied,
- Achieves high build (up to 1000 μm) in one coat, and
- Provides excellent adhesion and abrasion resistance.

Surface Preparation

Prepare surfaces by grit blasting to a clean, near-white finish Sa 2½ / SSC-SP 10/ NACE No 2.

Surface profile shall be 65-125 μm .

Preheating of the surface may be achieved by propane torch or induction coil.

Application

see *application statement for further information*

Mixing ratio by volume: 3:1

Brush Application

Product temperature at application (brush): $>15^{\circ}\text{C}$
Surface temperature at application: 10°C to 105°C

Mix each component individually. Add the hardener to the base and mix at a slow speed until a consistent colour is achieved, ensuring all material from the sides of the container is incorporated.

Pour mixed material onto surface and spread to a consistent film thickness (minimum of 750 μm). A wet film thickness gauge should be used to measure thickness.

Spray Application

Product temperature at application (spray)

Part A: 50°C

Part B: 40°C

Surface temperature at application: 10°C to 105°C

The equipment shall be a plural component airless spray unit with a proportioning pump capable of a volume mixing ratio of 3:1. Please consult Winn & Coales (Denso) Ltd regarding recommended equipment.

Inspection

Where required, holiday detection may be used: 5kv/mm

Cleaning

Clean equipment with MEK or equivalent solvent cleaner prior to cure.

Availability

Denso Protal 7900HT is available as a pre-measured kit: 1 L, 2 L, 75 L and 800 L

Storage Conditions

Store all components upright in original packaging in a cool, dry, area.

Recommended storage temperatures: 5°C to 35°C

Health and Safety

See Safety Data Sheet (SDS) for further information, prior to use.

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Typical Properties

Colour Mixed Base (A) Hardener (B)	Grey White Black
Solids	100%
Application thickness Minimum Maximum	750 µm 1500 µm
Theoretical coverage (at 750 µm)	1.3 m ² / litre
Actual coverage	0.75-0.95 m ² / litre
Pot life 25°C 35°C	30 minutes 15 minutes
Adhesion to steel	20 MPa
Maximum service temperature Continuous Intermittent	120°C 150°C
Cathodic disbondment (ASTM G95) 28 days at 80°C 28 days at 120°C 28 days at 150°C	5.25 mm 8.1 mm 8.8 mm
Hardness (shore D)	80-85
Initial handling 25°C 104°C	4 to 6 hours 15 to 20 minutes

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