



SELECTION & SPECIFICATION DATA

Type	Cycloaliphatic Amine Cured Novolac Epoxy
Description	SC2200 is a 100% solids Novolac epoxy coating that is fast-setting and cures down to 0°C (-17°C). Cured films up to 40 mils DFT provide an excellent balance of flexibility and toughness making it highly versatile for a variety of petrochemical and industrial applications. SC2200 is available in spray grade (plural component applicators only) and patch kits for brush, roller, or squeegee application.
Features	<ul style="list-style-type: none"> • 100% solids, no VOCs • 40 mils per coat in a single coat application • Resistance to cathodic disbondment • Good flexibility at colder temps • Good abrasion and impact resistance • Excellent thermal cycling properties • Excellent corrosion and barrier properties • Quick return-to-service
Uses	<ul style="list-style-type: none"> • High performance tank lining • Internal pipeline and vessel lining • Girth weld coating • External pipe lining
Color	Beige
Finish	Gloss
Primer	Self-priming
Dry Film Thickness (DFT)	Total dry film thickness (TDFT) should range 20 – 40 mils per coat for optimum performance. This range of thickness is achievable in a single coat with proper atomization, good technique, and proper substrate temperature. For applications requiring TDFT's above 50 mils, two coats should be applied. Refer to Section on "Recoat Intervals" and "Temperature Considerations" for additional information.
Solids Content	100% ± 1% by volume
Theoretical Coverage Rate	1604 square feet <i>per ???</i> at 1 mil 106 square feet <i>per ???</i> at 15 mils 64 square feet <i>per ???</i> at 25 mils Allow for loss in mixing and application
Maximum Dry Temperature Resistance	Continuous: 300°F (149°C) Non-Continuous: 350°F (177°C)
Under Insulation Resistance	Continuous: 300°F (149°C) Discoloration and loss of gloss occurs above 200°F (93°C) but does not affect performance.

SUBSTRATES & SURFACE PREPARATION

All	Surfaces must be clean and dry. Remove all dirt, dust, oil and all other contaminants.
Steel	Immersion: SSPC-SP10 Near White with jagged profile of 2.5 – 3.5 mils. Non-immersion: SSPC-SP6 1.5-3.0 mils SSPC-SP2 or SP3 are suitable cleaning methods for mild environments.
Previously Painted Surfaces	Consult with ErgonArmor Technical Service Department

MIXING & THINNING

Mixing	Due to the rapid set of this material, plural spray is the only method recommended for application other than for girth weld repairs.
Thinning	Consult with ErgonArmor representative before adding thinner to product or using hose lengths/diameters outside the stated recommendations.
Ratio	3:1 ratio (A to B) by volume
Pot Life	35 minutes at 41°F (5°C) 25 minutes at 59°F (15°C) 17 minutes at 77°F (25°C) 9 minutes at 95°F (35°C) Pot life times will be less at higher temperatures.

APPLICATION EQUIPMENT GUIDELINES

Spray Application	This is a 100% solids coating and may require adjustments in spray techniques. Wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
Airless Spray Plural Component	Due to the fast reactivity of this coating system, this product should be applied via heated plural component spray systems only. Tip Size: 0.025 – 0.029 reversible type Part A Fluid Line: 1/2 in ID Part B Fluid Line: ??? in ID Spray Line: 1/2 in ID x 50 feet maximum Whip: 1/4 in ID Length of Whip: 10 feet Pump Size: Graco 56:1 or greater Static Mixer: 1/2 in ID x 12 in behind mixing valve Part A Resin: 135°F – 140°F (57°C – 60°C) in reservoir tank Part B Hardener: 90°F – 95°F (32°C – 35°C) in reservoir tank
Brush & Roller	Manually mixed material should be brushed or rolled within the specified working life of the mix.
Brush	Medium bristle brush
Roller	Short-nap synthetic roller cover with phenolic core



CLEANUP & SAFETY

Cleanup MEK or Acetone

Safety Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.

Ventilation When used as a tank lining or in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. User should test and monitor exposure levels to insure all personnel are below guidelines.

PACKAGING, HANDLING & STORAGE

Shelf Life Part A: 12 months at 75°F (24°C)
Part B: 12 months at 75°F (24°C)
When kept at recommended storage conditions and in original unopened containers.

Package Sizes & Shipping Weight 1 gallon kit - 13 lbs (6 kg)
200 gallon drum kit - 2,730 lbs (1,240 kg)

Storage Temperature & Humidity Substrate temperature should be 35°F – 10°F (1.7°C – 43.3°C) and a minimum of 5°F (3°C) above the dewpoint to achieve best adhesion properties. Maximum substrate temperature should be kept to 140°F (60°C). Contact ErgonArmor for conditions where the substrate temperature exceeds 140°F (60°C).

Storage Novocoat SC2200 Rapid Set Pipe Coating should be stored in a dry, well-ventilated area. Maintain products in original packaging and sealed until ready for use. Avoid exposure to direct sunlight or any adverse environmental conditions that would cause contamination. Refer to safety data sheet for additional information.

PERFORMANCE DATA

TEST METHOD	SYSTEM	RESULTS
Compressive strength, 5 days ambient	ASTM C109	12,000 – 15,000 psi
Dry ASTM D4541	Blasted steel 1 ct	>2,700 psi
ASTM D4541 Wet 5 days 158°F (70°C) water	Blasted steel 1 ct	>2,500 psi
Abrasion ASTM D4060	1000 cycles, CS17 wheel 1000 gm load	0.59 mils loss of DFT 1,750 cycles per mil
Impact resistance	ASTM G14-88	70 – 80 in lbs
Cathodic disbondment CSA Z245.20-06	28 days at 185°F (85°C)	4.9 mm disbondment
Cathodic disbondment CSA Z245.20-06	28 days at 77°F (25°C)	1.1 mm disbondment
Dielectric strength (in paraffinic oil)	ASTM D149 Blasted steel 1 ct	730 – 760 volts/mil
Operating temperature range		-40°F – 52°F (-40°C – 125°C)

CURE SCHEDULE & RECOAT WINDOW

TEMPERATURE	MINIMUM RECOAT	MAXIMUM RECOAT	RETURN TO SERVICE (AQUEOUS/HYDROCARBON IMMERSION)
50°F (10°C)	1 hour	24 hours	24 hours
77°F (25°C)	30 minutes	2 hours	4 hours
95°F (35°C)	15 minutes	45 minutes	3 hours
DRY TO TOUCH 1.5 HOURS AT 77°F (25°C)			

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