

Epoxy Novolac

PRODUCT DESCRIPTION

A solvent free, two component polyclamine cured girth weld and pipeline coating system utilizing advanced epoxy novolac technology.

Suitable for high temperature service (203°F [95°C] for pipe externals with cathodic protection, 300°F [149°C] in dry conditions).

INTENDED USES

Applications include pit filling and repair of buried steel pipelines, underground and aboveground storage tanks, as a field joint coating and repair material for external fusion bond epoxy pipeline coatings.

Enviroline 124 can be used as a holiday repair coating for Enviroline series linings.

Enviroline 124 is also suitable as a single coat, high film thickness, external lining for pipes where high performance and rapid return to service is required.

PRACTICAL INFORMATION FOR ENVIROLINE 124

Color	Green
Gloss Level	Not applicable
Volume Solids	100%
Typical Thickness	40-120 mils (1000-3000 microns) dry equivalent to 40-120 mils (1000-3000 microns) wet
Theoretical Coverage	0.50 m ² /litre at 2000 microns and stated volume solids 3.81 sq.ft/US quart at 80 mils d.f.t. and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Brush, Cartridge Gun, Knife, Plural Component Airless Spray , Trowel

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
50°F (10°C)	105 minutes	8 hours ¹	105 minutes	24 hours
77°F (25°C)	75 minutes	3 hours ¹	75 minutes	24 hours
104°F (40°C)	25 minutes	45 minutes ¹	25 minutes	45 minutes

¹ Sufficient coating film strength has developed to permit the handling and movement of coated steelwork. A Shore D hardness reading of 70-80 is a recommended guideline to indicate suitability for return to service.

See Product Characteristics section for further details on Enviroline 124 spray grade

REGULATORY DATA **Flash Point (Typical)** Part A 199°F (93°C); Part B 199°F (93°C); Mixed 199°F (93°C)

Product Weight 12.6 lb/gal (1.506 kg/l)

VOC 10 g/lit EPA Method 24

See Product Characteristics section for further details

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SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to application, all surfaces should be assessed and treated in accordance with ISO 8504:2000

Where necessary, remove weld spatter and where required smooth weld seams and sharp edges.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

This product must only be applied to surfaces prepared by abrasive blast cleaning to Sa2.5 (ISO 8501-1:2007) or SSPC-SP10.

A sharp, angular surface profile of 3-5 mils (75-125 microns) is recommended. For areas of high performance service, where impact and abrasion resistance is important, a minimum surface profile of 4 mils (100 microns) should be achieved.

Enviroline 124 must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidized area should be reblasted to the standard specified above.

Where local VOC regulations allow, surfaces may be primed with Interline 982 to 0.5-1.0 mils (15-25 microns) dry film thickness before oxidation occurs. Alternatively, the blast standard can be maintained by use of dehumidification.

APPLICATION

Mixing	Enviroline 124 must be applied in accordance with the detailed International Protective Coatings Working Procedures for the application of Tank Linings.	
	Material is supplied in two containers as a unit. Complete units should be stored, mixed and applied in accordance with the Enviroline 124 Application Guidelines.	
Mix Ratio	2 part(s) : 1 part(s) by volume	
Working Pot Life	77°F (25°C)	104°F (40°C)
	10 minutes	6 minutes
Plural component airless spray	Recommended	Refer to Enviroline Application Guidelines for more details.
Airless Spray	Not suitable	
Brush	Suitable - Small areas only	Refer to Enviroline 124 Application Guidelines for more details.
Trowel	Recommended	Refer to Enviroline Application Guidelines for more details.
Thinner	Not recommended	
Cleaner	International GTA203 or Enviroline 71C	
Work Stoppages	Thoroughly clean all equipment with International GTA203 (or Enviroline 71C). Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.	
Clean Up	Clean all equipment that has been in contact with mixed Enviroline 124 immediately after.	

Enviroline® 124

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All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

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PRODUCT CHARACTERISTICS

The detailed Enviroline Application Guidelines should be consulted prior to use.

This datasheet provides general guidance on the use of Enviroline 124. Specific project requirements will be dependent upon the service end use and operating conditions of the tank or vessel. Always consult International Protective Coatings to confirm that Enviroline 124 is suitable for contact with the product to be stored.

The detailed project coating specification provided by International Protective Coatings must be followed at all times.

Surface temperature must always be a minimum of 5°F (3°C) above dew point.

Use the following chart for preferred temperature conditions. These conditions plus adequate ventilation must be maintained throughout the curing cycle.

	<u>Coating Temperature</u>	<u>Substrate Temperature</u>	<u>Air Temperature</u>
Preferred	95-130°F (35-55°C)	70-120°F (21-49°C)	70-100°F (21-38°C)
Minimum	95°F (35°C)	20°F (-7°C)	20°F (-7°C)

Maximum continuous dry temperature resistance for Enviroline 124 is 300°F (149°C). Maximum immersion service temperature is dependent on cargo and service conditions. Consult International Protective Coatings for information.

Alternative Fast Grade

A fast apply, high build, sprayable grade of Enviroline 124 is available for field joints. Application is by heated plural airless spray – please contact AkzoNobel for further details.

Enviroline 124 can be used as a holiday repair coating for Enviroline 376F series, Enviroline 125 series and Enviroline 375.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in color and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

Enviroline 124 is designed for application to correctly prepared substrates.

For information regarding suitable topcoats for Enviroline 124, please consult International Protective Coatings.