

**PRODUCT DESCRIPTION**

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

**INTENDED USES**

Enviroline 124 is a new generation system providing improved performance benefits:

- Abrasion and impact resistance
- Excellent chemical resistance
- Rapid return to service
- Ultra low VOC
- Single coat application

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 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**

<b>Colour</b>	Green			
<b>Gloss Level</b>	Not applicable			
<b>Volume Solids</b>	100%			
<b>Typical Thickness</b>	1000-2000 microns (40-80 mils) dry equivalent to 1000-2000 microns (40-80 mils) wet			
<b>Theoretical Coverage</b>	0.50 m <sup>2</sup> /litre at 2000 microns and stated volume solids 3.81 sq.ft/US quart at 80 mils d.f.t. and stated volume solids			
<b>Practical Coverage</b>	Allow appropriate loss factors			
<b>Method of Application</b>	Plural Component Airless Spray, Brush, Knife, Trowel			
<b>Drying Time</b>				
			Overcoating Interval with recommended topcoats	
<b>Temperature</b>	<b>Touch Dry</b>	<b>Hard Dry</b>	<i>Minimum</i>	<i>Maximum</i>
25°C (77°F)	40 minutes	3 hours <sup>1</sup>	40 minutes	55 minutes

<sup>1</sup> 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

**REGULATORY DATA**

<b>Flash Point (Typical)</b>	Part A 93°C (199°F); Part B 93°C (199°F); Mixed 93°C (199°F)		
<b>Product Weight</b>	1.26 kg/l (10.5 lb/gal)		
<b>VOC</b>	0.08 lb/gal (10 g/lt)	EPA Method 24	

See Product Characteristics section for further details

**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.

**Steel Substrates**

Best performance will always be achieved when Enviroline 124 is applied to surfaces prepared by abrasive blast cleaning to Sa3 (ISO 8501-1:2007) or SSPC-SP5. A sharp, angular profile of 75-125 microns (3-5 mils) is recommended.

For immersion service the minimum acceptable standard of surface preparation is St3 (ISO 8501-1:2007) or SSPC-SP3; for atmospheric service the minimum standard is St2 (ISO 8501-1:2007) or SSPC-SP2.

**Concrete Substrates**

Refer to International Protective Coatings for specific recommendations.

**APPLICATION**

<b>Mixing</b>	Material is supplied in two containers as a unit. Complete units should be stored, mixed and applied in accordance with the Enviroline Application Guidelines.	
<b>Mix Ratio</b>	2 part(s) : 1 part(s) by volume	
<b>Working Pot Life</b>	25°C (77°F)    40°C (104°F)	10 minutes    7 minutes
<b>Plural Component Airless Spray</b>	Suitable	Refer to Enviroline Application Guidelines for more details.
<b>Airless Spray</b>	Not suitable	
<b>Brush</b>	Suitable	Refer to Enviroline Application Guidelines for more details.
<b>Trowel</b>	Recommended	Refer to Enviroline Application Guidelines for more details.
<b>Thinner</b>	<b>DO NOT THIN</b>	
<b>Cleaner</b>	Enviroline 71C	
<b>Work Stoppages</b>	Thoroughly clean all equipment with 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.	
<b>Clean Up</b>	Clean all equipment immediately after use with Enviroline 71C.  All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	

**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 3°C (5°F) 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>
<b>Preferred</b>	18-41°C (65-105°F)	21-49°C (70-120°F)	21-38°C (70-100°F)
<b>Minimum</b>	18°C (65°F)	-7°C (20°F)	-7°C (20°F)

Maximum continuous dry temperature resistance for Enviroline 124 is 149°C (300°F).

**Alternative Cure**

Two additional versions of Enviroline 124 are available for choice of cure and overcoating properties: Enviroline 124SL (slow cure) and Enviroline 124 Fast (fast cure).

	<u>Temperature</u>	<u>Touch Dry</u>	<u>Hard Dry</u>	<u>Overcoating Interval with recommended topcoats</u>	
				<u>Minimum</u>	<u>Maximum</u>
<b>124SL</b>	25°C (77°F)	1 hour	7 hours	1 hour	2 hours
<b>124 Fast</b>	25°C (77°F)	7 minutes	35 minutes	5 minutes	20 minutes
<u>Working Pot Life</u>	<u>25°C (77°F)</u>	<u>40°C (104°F)</u>			
<b>124SL</b>	25 minutes	10 minutes			
<b>124 Fast</b>	12 minutes	4 minutes			

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 colour 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.

**ADDITIONAL INFORMATION**

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at [www.international-pc.com](http://www.international-pc.com):

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage
- Enviroline Application Guidelines

Individual copies of these information sections are available upon request.

**SAFETY PRECAUTIONS**

This product is intended for use only by professional applicators in industrial situations. All work involving the application and use of this product should be performed in compliance with all relevant national Health, Safety and Environmental standards, regulations and legislation.

Proper ventilation must be provided during application and afterwards during curing (refer to product datasheets for typical curing times) to ensure safe limits and prevent fires and explosions. Forced extraction will be required in confined spaces. Ventilation and/or respiratory personal protective equipment (airfed hoods or appropriate cartridge masks) must be provided during application and curing. Take precautions to avoid skin and eye contact (overalls, gloves, goggles, masks, barrier cream, etc).

Before use, obtain, read and then follow the advice given on the Material Safety Data Sheets (Parts A and B if two-pack) and the Health and Safety section of the Coatings Applications Procedures for this product.

In the event that welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

The detailed safety measures are dependent on application methods and the work environment. If you do not fully understand these warnings and instructions or if you cannot strictly comply with them, do not use the product and consult International Protective Coatings.

**Warning: This product contains liquid epoxies and modified polyamines and may cause skin sensitisation if not used correctly.**


PACK SIZE	Unit Size	Part A		Part B	
		Weight	Pack	Weight	Pack
	2 lb	1.25 lb	0.25 US gal	0.75 lb	0.13 US gal
	0.6 litre	0.42 litre	0.95 litre	0.19 litre	0.47 litre
Enviroline 124 is supplied in cases; in the USA, one case contains nine kits. In Europe, the Middle East and Africa, one case contains six kits.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	0.25 US gal	1.5 lb		0.9 lb	
	0.6 litre	0.68 kg		0.4 kg	
STORAGE	Shelf Life	24 months minimum at 25°C (77°F) in original, unopened containers. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

**Important Note**

*The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local International Paint representative that this data sheet is current prior to using the product.*

*This Technical Data Sheet is available on our website at [www.international-marine.com](http://www.international-marine.com) or [www.international-pc.com](http://www.international-pc.com), and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.*

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