Enviroline® 405HT BR

International

Epoxy Novolac

PRODUCT DESCRIPTION

Enviroline 405HT BR is an ultra high solids brush grade version of Enviroline 405HTR and is specifically designed for stripe coat application over welds and seams in tanks that require excellent heat resistance with outstanding corrosion protection.

INTENDED USES

Used in combination with Enviroline 405HTR to handle harsh environments in the petroleum industry, including crude oil, free water knockouts, treaters, and separator vessels and tanks with high operating temperatures.

Typical use is for stripe coating of welds, seams and rivet heads in steel tanks prior to application of Enviroline 405HTR topcoat.

The product offers the following benefits:

- Good brush application
- Excellent flexibility and impact resistance
- Excellent adhesion
- High temperature stability
- Resists wide range of chemicals
- Thermal and mechanical shock resistance

PRACTICAL INFORMATION FOR ENVIROLINE 405HT BR

Colour	Tan
Gloss Level	Not applicable
Volume Solids	90% ± 2%
Typical Thickness	125-250 microns (5-10 mils) dry equivalent to 139-278 microns (5.6-11.1 mils) wet
Theoretical Coverage	7.20 m²/litre at 125 microns d.f.t and stated volume solids 289 sq.ft/US gallon at 5 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Brush

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
25°C (77°F)	3 hours	6 hours	4 hours	2 days
40°C (104°F)	2 hours	4 hours	2 hours	24 hours

REGULATORY DATA

Flash Point (Typical)	Part A 57°C (134°F); Part B 63°C (145°F)	
Product Weight	1.55 kg/l (12.9 lb/gal)	
VOC	53 g/lt (0.44 lb/gal)	Calculated

See Product Characteristics section for further details

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint 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

This product must only be applied to surfaces prepared by abrasive blast cleaning to Sa3 (ISO 8501-1:2007) or SSPC SP5.

A sharp, angular surface profile of 75-125 microns (3-5 mils) is recommended.

Enviroline 405HT BR must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidised area should be reblasted to the standard specified above.

Surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.

APPLICATION

Mixing	Material is supplied in two containers as a unit. Complete units should be stored, mixed and applied in accordance with the Enviroline Application Guidelines.	
Mix Ratio	2 part(s) : 1 part(s) by volume	
Working Pot Life	25°C (77°F) 40 minutes	40°C (104°F) 20 minutes
Brush	Recommended	Typically 125-250 microns (5.0-10.0 mils) can be achieved
Thinner	Not recommended	
Cleaner	Enviroline 71C	
Work Stoppages	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.	
Clean Up	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.	

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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 405HT BR. Specific project requirements will be dependent upon the service end use and operating conditions of the tank or vessel.

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.

	Substrate Temperature	Air Temperature
Preferred	21-49°C (70-120°F)	21-38°C (70-100°F)
Minimum	16°C (60°F)	16°C (60°F)

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.

SYSTEMS COMPATIBILITY

The following topcoat is recommended for Enviroline 405HT BR:

Enviroline 405HTR

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:

- 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 in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event 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.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

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	
		Vol	Pack	Vol	Pack
	1 US gal	0.67 US gal	1 US gal	0.33 US gal	0.5 US gal
	For availability of other pack sizes, contact International Protective Coatings.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	1 US gal	9.5 lb	4.9 lb

STORAGE	Shelf Life	12 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

www.international-pc.com