

TECHNICAL DATA SHEET

PROTAL™ 7125 REPAIR CARTRIDGE

Fast Cure, Low Temperature Pipeline Repair Coating

Description

Protal 7125 Repair Cartridge are specially formulated for patching and repairing damaged FBE and other liquid coated pipelines. The repair cartridges are packaged in 2-component tubes that are applied with a dispensing gun (sold separately). Two convenient sizes (50 ml and 825 ml) are available.

Uses

Repair coating for damaged FBE and other liquid coated pipelines. Also used for coating of cadweld areas.

Features

- Cold temperature application down to -4°F (-18°C)
- Will not freeze when applied to substrates below 32°F (0°C)
- Fast cure, fast initial set
- Will cure when submersed in water
- High build (in one coat)
- Excellent adhesion (compliments FBE coated pipe)
- High abrasion resistance for drilling applications
- Does not shield cathodic protection
- Static Mixing Tips available

Application

The Protal 7125 Repair Cartridge can be applied from -4°F to 135°F (-20°C to 57°C). For small pinhole repairs: Surfaces of repair up to 1/16 inch (2 mm) in diameter, roughen the surface of the parent coating, to remove gloss, around the holiday for at least 1 inch (25 mm). Use 80 - 120 grit sandpaper or light sweep blasting. Medium sized repairs: Surfaces of repair areas up to 4 in² (25 cm²) in size, shall be prepared by abrasive blasting, as specified in Section 11, or by power tool cleaning in accordance with SSPC- SP 11 to remove dirt, scale, rust, damaged coating and any other foreign material to a bare metal condition and retain or produce the surface profile required by Section 4.0. Large repairs: Surfaces of repair areas exceeding 4 in² (25 cm²) shall be repaired by abrasive blast cleaning as specified in Section 4.0. The adjacent parent coating and any holidays or damaged coating adjacent to the cutback area shall be roughened for at least 1 inch (25 mm) around the repair and the edges shall be feathered. After abrading, all dust shall be removed from the prepared areas using compressed air, a clean, dry bristle brush, a clean dry cloth or removed in accordance with SSPC-SP-1 using acetone, xylene or MEK.



Protal 7125
Repair Cartridge
(825 ml)



Protal Cartridge Gun
10:1 (825 ml)
Sold Separately



Protal 7125 Repair Cartridge (50 ml)
and Cartridge Gun 10:1 (50 ml)
Cartridge and Gun
Sold Separately



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Storage

12 months when stored in original containers between 33°F and 80°F (0.5°C and 27°C).

Cleaning

Clean equipment with MEK or equivalent solvent cleaner.

HSE

Spray or brush under well ventilated conditions. Wear suitable protective clothing and glasses. See material safety data sheet.

Packaging

50 ml and 825 ml repair cartridges.

Dispensing guns and static mixing tips for repair cartridges sold separately.

Tech Data

Properties	Imperial	Metric
Solids Content/Percent Reactive	100%	100%
Mixed Material - (Mixed) @ 77°F (25°C)		
Specific Gravity	1.53	1.53
Viscosity	Thixotropic Liquid	Thixotropic Liquid
Color	Light Gray	Light Gray
Mixing Ratio (A/B) by Volume	10 parts base:1 part hardener	10 parts base:1 part hardener
Handling Times		
Substrate Temp. @ 90°F (32°C)	10 - 15 Minutes	10 - 15 Minutes
Substrate Temp. @ 70°F (21°C)	20 - 30 Minutes	20 - 30 Minutes
Substrate Temp. @ 50°F (-10°C)	1 Hour	1 Hour
Substrate Temp. @ 32°F (0°C)	2 Hours	2 Hours
Substrate Temp. @ 14°F (-10°C)	4 Hours	4 Hours
Thickness - Weld Joints / FBE Repairs		
Minimum/Maximum	20/60 mils	508/1524 microns
Recommended	25 - 30 mils	635 - 762 microns
Thickness - Bore Pipe		
Minimum/Maximum	40/60 mils	1016 /1524 microns
Recommended	45 - 50 mils	1143 - 1270 microns
Cathodic Disbondment		
28 Days @ 68°F (20°C)	7.1 mm	7.1 mm
Adhesion to Steel	2400 psi	16.5 MPa
Adhesion to FBE	1100 psi	7.6 MPa)
Hardness (ASTM 2240)	Shore D 70+	Shore D 70+
Gouge Resistance	3 Passes = 0 Fail @ 50 kg	3 Passes = 0 Fail @ 50 kg
Application Temperatures (Surface)	-4°F to 135°F	-20°C to 57°C
Service Temperature	-40°F to 150°F	-38°C to 65°C



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