TECHNICAL DATA SHEET

PROTAL™ 7125

Fast Cure, Low Temperature Pipeline Coating

Description

Protal 7125 is specifically formulated to be applied to colder substrates at colder ambient temperatures. It is a high build liquid coating that is brush or spray applied in one coat to many areas of in-service pipelines or during pipeline construction in the field. It cures fast to allow quick handling and backfilling, even down to -4°F (-20°C). Protal 7125 is intended for use where a quick cure is required at lower substrate and/or ambient conditions such as during winter applications or on colder operating temperature pipelines.

Uses

Used as a rehabilitation coating for existing low temperature in-service operating pipelines, station piping, girth welds, tie-ins, push rack (laybarge applications), repairs to FBE, fittings and fabrication. It may also be used for new construction where colder temperatures exist and preheating or post heating is not practical or feasible.

Features

- Cold temperature application down to -4°F (-20°C)
- Will not freeze when applied to substrates below 32˚F (0˚C)
- Fast cure, fast initial set
- Will cure when submersed in water after application
- High build (up to 50 mils / 1270 microns in one coat)
- Excellent adhesion (compliments FBE coated pipe)
- High abrasion resistance for drilling applications
- Can be used as an abrasion resistant coating (ARO)
- Does not shield cathodic protection
- Repair cartridges available (50 ml and 825 ml)

Application

Brush: Prepare surfaces by abrasive blasting to a clean near-white finish, SSPC-SP 10 / NACE No. 2. Appropriate angular abrasive shall be used to achieve a 2.5 to 5 mil (63 - 127 microns) anchor profile. (Repair areas shall be roughened using Carborundum cloth or 80 abrasive sandpaper and wiped clean with a cloth or brush prior to patching.) Independently mix Part A (resin) and Part B (hardener) prior to adding the hardener to base and mix with a stir stick or power mixer, (at a slow speed so as not to introduce air into the product), until a consistant light gray color is achieved without streaks present. During the mixing process, the inside surface of the container should be scraped to obtain a complete mixture. Pour mixed material onto surface and brush, trowel or roll to required thickness. A wet-film thickness gauge shall be used to measure mil thickness (min. 20 mils / 508 microns). Backfilling times are dependent on temperature and will be extended at cooler temperatures. For complete brush application instructions, refer to "Protal 7125 Brush Application Specifications".

Spray: For complete spray application instructions, refer to "Protal 7125 Spray Application Specifications".

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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 safety data sheet.

Packaging

0.8 liter kits, 1.5 liter kits and 200 liter spray kits.
50 ml and 825 ml repair cartridges.

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

Tech Data

Properties	Imperial	*Metric*
Percent Reactive	100%	*100%*
Base Component - (Unmixed) @ 77°F (25°C)		
Specific Gravity	1.54	*1.54*
Viscosity	Thixotropic Liquid	*Thixotropic Liquid*
Color	White	*White*
Hardener - (Unmixed) @ 77°F (25°C)		
Specific Gravity	1.48	*1.48*
Viscosity	Soft Paste	*Soft Paste*
Color	Black	*Black*
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*
Gel Time/Pot Life — 1.5 liter kit		
Material @ 68°F (20°C)	10 Minutes	*10 Minutes*
Material @ 50°F (10°C)	18 Minutes	*18 Minutes*
Material @ 32°F (0°C)	30 Minutes	*30 Minutes*
Material @ 14°F (-10°C)	45 Minutes	*45 Minutes*
Back Fill Times — Material @ 50°F (10°C)		
Ambient & Substrate Temp. @ 68°F (20°C)	20 - 30 Minutes	*20 - 30 Minutes*
Ambient & Substrate Temp. @ 50°F (10°C)	45 - 60 Minutes	*45 - 60 Minutes*
Ambient & Substrate Temp. @ 32°F (0°C)	2 Hours	*2 Hours*
Ambient & Substrate Temp. @ 14°F (-10°C)	3 - 4 Hours	*3 - 4 Hours*

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TECHNICAL DATA SHEET

Tech Data

Properties	Imperial	*Metric*
Theoretical Coverage	14 ft²/liter at 25-30 mils DFT	*1.3 m²/liter at 635 - 762 microns DFT*
Actual Coverage	10 ft²/liter at 25-30 mils DFT	*1.0 m²/liter at 635 - 762 microns DFT*
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*
Hardness (ASTM 2240)	Shore D 70+	*Shore D 70+*
Gouge Resistance	3 Passes = 0 Fail @ 50 kg	*3 Passes = 0 Fail @ 50 kg*
Application Temperature (Surface)	-4°F to 68°F	*-20°C to 20°C*
Service Temperature	-40°F to 150°F	*-40°C to 65°C*

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