Liquid Epoxy Resin Primer

A Solvent-free Two-component Epoxy System

Features

- Environmentally friendly, non-toxic
- Thick coating
- Same as the factory coating
- Quick and simple construction

Our liquid epoxy resin primer is a wet film coating primarily designed for circumferential weld joint coatings on buried pipelines. When used in conjunction with WS 65/85HMA and TS 55/65, it forms a comprehensive three-layer corrosion protection system. This product features an exceptionally high solid content, ensuring firm adhesion to most common substrate surfaces. Additionally, it exhibits excellent chemical resistance and is non-toxic.

Description

Our liquid epoxy primer during the application process, components A and B must be mixed in the precise proportions specified. The mixture is then applied directly to pre-treated steel pipeline surfaces. The liquid epoxy primer cures through thermal contraction sleeves upon installation, utilizing heat-induced curing. The cured coating provides exceptional cathodic disbondment resistance and impact resistance, while also enhancing overlap shear strength and wear resistance. With superior sealing performance and high durability, this solution offers robust protection for pipeline joints.

Storage and Shelf Life

Store products in a dry, well-ventilated area. Protect from direct sunlight, rain, snow, dust, or other adverse environmental conditions and contaminants. Maintain temperature between +5°C (40°F) and +40°C (104°F). Keep in original packaging and sealed until use. Shelf life: 12 months (re-inspection required after expiration).

General Requirements for Applications

General: The area to be coated has to be cleandry, and free from oil, grease and dust. All contamination including mill-scale has to be removed.

Degreasing: Degrease surfaces with Toluene or Heptane and e.g. a lint-free cloth.

Working surface temperature: The minimum operating temperature is 30°C (86°F).

For uneven working surfaces and both sides of the weld seam, Butyl rubber filler should be used for corrective transition treatment.

Property		Typical Value	Test Method
Color		Black	Visual
Solid Content		99.8.%	ASTM D2697
Density	A	1.50g/cm³ (12.5lb/gal)	ASTM D1475
	B	0.96g/cm³ (8lb/gal)	ASTM D1475
Flash Point	A	145°C (293°F)	ASTM D92
	B	118°C (244.4°F)	ASTM D92
Viscosity (Base)		17500mPa·s	ASTM D1473
Mixing Ratio (by volume)		4:1	-
Minimum Curing Temperature		10°C (50°F)	ASTM D3418
Curing Time	23°C	60 minute	ASTM D2471
	65°C	15 minute	ASTM D2471
Thickness		>150μm	ASTM D1000
Number of Coats		once	-
Appearance		Smooth and even	Visual
Shear Strength @23°C		13.2MPa (1914.5psi)	ASTM D1002
Cathodic Disbonding	65°C,48h	4.4mm (0.17in) radius	ISO21809,3
	85°C,30d	10mm (0.39in) radius	SO21809,3
Packaging		Heat shrink tube is equipped with a single unit.	

Application Instruction

Step 1

Clean the working surface to ST3 or SA2½.

Step 2

Mix A and B according to the provided mixture for about 1 minute to obtain a uniform mixture (epoxy primer).

Step 3

Carefully apply the mixed epoxy primer to the working surface using a roller or pad (sponge) with a brush according to the instructions in the product application guide.

Step 4

Then the heat shrink tube is installed in time.

Step 5

Perform holiday detection per NACE SP0274 Handling and commissioning.

Friendly Reminder

Keep it original and do not add dilution.

For more technical inquiries, please visit our website.

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