Self-fusing Tape

Cold Application Heavy Duty Butyl Tape

Features

- High adhesion
- High resistivity
- Environmentally friendly and non-toxic
- Flexible and easy to operate

Our self-adhesive anti-corrosion tape is a 100% solid adhesive made from butyl rubber and polyisobutylene, featuring a separate transparent plastic barrier for easy removal. Designed to protect steel pipe field-welded joints from corrosion, it is also highly suitable for small-diameter pipes, tees, elbows, valves, and cables.

Description

The product boasts exceptional waterproofing, moisture resistance, and insulation properties. Its unique self-healing capability effectively seals surface defects, cracks, and holes in pipes and components. It maintains flexibility across a broad temperature spectrum and adapts to various field conditions, conforming seamlessly to irregular shapes.

Storage and Shelf Life

This product should be stored in a dry and ventilated place, and the same environment must be maintained during transportation. The storage temperature range should be no lower than -40°C (-40°F) and no higher than +40°C (+104°F). Humidity should not exceed 90%. Vertical stacking height ≤5 layers. The shelf life is three years.

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.

Preventing Condensation of Water: Before and during construction, the working surface temperature must always remain at least 3°C (37.4°F) above the dew point temperature.

Working Surface Temperature: The surface temperature of the operation should be maintained between +20°C and +40°C (68°F to 104°F) and preheating should be performed if necessary.

Special Handling: For spiral welded pipelines, filler materials should be used. Choose our butyl rubber filler tape to supplement the gaps.

Project	T 3300-118	T 3500-197	Test Method
Naked Thickness	3.0mm (118.11mils)	5.0mm (196.85mils)	ASTM D1000
Elongation at Break @+23°C (+73.4°F)	800%		ASTM D1000
Lap Shear Strength @+23°C (+73.4°F)	15N/cm^2 (21.76psi)		ASTM D1002
Self-bonding @+23°C (+73.4°F)	16.5N/cm (150.7oz/in)		ASTM D1000
Peel Strength Between Primer and Steel @+23°C (+73.4°F)	27.5N/cm (251.2oz/in)		ASTM D1000
Dielectric Breakdownl @+23°C (+73.4°F)	22.5KV/mm (571.5V/mil)		ASTM D149
Volume Resistivityl @+23°C (+73.4°F)	2.6. x 10^{13}Ω·cm (9.8 x 10^{12}ohm·in)		ASTM D257
Water Vapor Permeability 24h @+23°C (+73.4°F)	3.5 x 10^4g/daymF/Pa (4.94 × 10^4lb/day/ft^2/ps)		ASTM E96
Water Absorption @+23°C (+73.4°F) 24h	0.05%		ASTM D570
Cathodic Disbondment @+23°C (+73.4°F) 28D	4.5mm (0.18in radius)		ASTM G8
Application Temperature	-34 to +85°C (-29 to 185°F)		ISO 1133
Available Roll Size (width X ength)	30 to 150mm X 3 to10m (1.18 to 5.91in X 9.84 to 32.81ft)		
Color	Black/Yellow *(Tape width and roll length can be customized)		

Application Instruction

Step 1

Clean substrate to SSPC-SP6/NACE3 or SA2 (Commercial Blast) with a 25–76μm (1–3 mils) anchor profile.

Step 2

When using Self-fusing tape, first apply a layer of rubber primer to achieve a uniform wet film thickness of 50.8 to 76.2 microns (2 to 3 mils). The primer should be "surface dry" before laying.

Step 3

Take a piece of self-adhesive tape off the roll, stretch it properly, and return the spring force to an appropriate level. Wrap it in a spiral pattern, usually with an overlap width of 50/55%, or as required by the design.

Step 4

Wrap with PE or PVC packaging tape. Maintain a necking rate of 1% to 2%, with an overlap width of 50/55%. Alternatively, follow design specifications. The components are bonded together through self-adhesion to form a fully sealed corrosion-resistant protective layer.

Step 5

Perform holiday detection per NACE SP0274 Handling and commissioning.

Friendly Reminder

The backfill should be kept clean and should not contain any foreign matter that could damage the coating system.

For more technical inquiries, please visit our website.

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