TECHNICAL BULLETIN

COROGARD 615

Product Description:

COROGARD 615 is a two component, flake filled, epoxy coating system. This coating system provides remarkable resistance to moisture and corrosion because of the overlapping mineral flakes in their high solids formulation. Only one single coat @ 150 - 200 µm DFT is necessary for long term service life. It can be sprayed, rolled or brushed directly over concrete, rusted steel or old coatings, even with moisture present.

Recommended Uses:

COROGARD 615 is ideal for structural galvanized, coated or rusted steel, such as tank exteriors, for piping, offshore platforms, waste water treatment plants and floating roofs of crude oil tanks, May also be used for corrosion protection in chemical fumes or marine atmospheres.

Temperature Resistance:

+ 120 °C dry

Generic Type:

Epoxy Resin

Filler:

Inert-Flakes

Design:

The steel and concrete construction to be coated must be fabricated according to the EN 14879-1:2005. For concrete structures also refer to DIN 1045. Further information can be taken from our steel or concrete specifications.

Preparation:

Concrete
Contaminants such as oil or grease must be removed prior to the application. The best preparation is abrasive blast to open holes covert with cement and to roughen the surface. The resulting surface should be at least as rough as 40 grit sand paper. Concrete should be thoroughly cured for at least 28 days.

Steel
If the steel surfaces are rusted, only a wire brush is required to remove loose rust. Oil, grease or other contaminations must be removed. The substrate shall be prepared to obtain a SP-2 or SP-3 surface, as defined in SSCP standard.

Zinc galvanised steel
Oil, grease or other contaminations must be removed. The substrate must be clean and dry.

Coatings
Existing coatings should be prepared by grinding with sand paper. Chlorinated rubber and vinyl coatings cannot be over coated with this system.

Build-up of the system:

	Thickness	Coverage
COROGARD 615 for steel	1 x 200 - 250 µm WFT	300 g/m²
COROGARD 615 for concrete	1 x 200 - 250 µm WFT	400 g/m²

Available packing:	5 kg Component “A” and 5 kg Component “B”		
Mixing Ratio:	Mix 5 kg ***COROGARD 615*** Part “A“ with 5 kg ***COROGARD 615*** Part “B“. Use mechanical stirrer to mix Part “A“ and “B“ separately. Then add Part “B“ to Part “A“ while continuously stirring.		
Pot Life:	8 hrs. (+ 10 °C)	5 hrs. (+ 20 °C)	4 hrs. (+ 30 °C)
Recoat Time:	30 hrs. (+ 10 °C)	12 hrs. (+ 20 °C)	6 hrs. (+ 30 °C)
Handling Time:	36 hrs. (+ 10 °C)	16 hrs. (+ 20 °C)	12 hrs. (+ 30 °C)
Application Equipment:	Conventional Air or Airless Spray, Brush and Roller.		
Application:	***COROGARD 615*** shall be applied normally in one coat utilizing an airless or conventional air spray system. Small areas may be coated by brush or roller. The air temperature shall be @ + 10 °C to + 40 °C and the substrate temperature shall be @ + 8 °C (3 K above dew point). Note: In atmospheric exposure ***COROGARD 615*** has a tendency to chalking with the time. May be top coated with polyurethane, if desired.		
Cleaning:	Solvent T-100		
Shelf Life:	The shelf life is 12 months when stored @ + 20 °C. ***COROGARD 615*** Part “A” and Part “B” should be stored at a cool and dry place.		
Density:	1.32 kg/l (mixed)		
Viscosity:	2,700 mPas ± 300 (mixed)		
Solid Content:	86 % ± 2		
Flash Point:	Mixture + 17 °C, Pensky-Martens Closed Up		
Modulus of Elasticity:	3,000 – 3,500 MPa (DIN EN ISO 178) flexural		
Abrasion:	100 mg (ASTM – D 4060)		
Adhesion:	5 N/mm² (EN ISO 4624) to wire brushed C-Steel; 1.5 N/mm² on concrete		
Hardness:	30 Barcol (DIN EN 59)		

TIP TOP Oberflächenschutz Elbe GmbH, Dessauer Strasse 125, D-06886 Wittenberg
Telefon: (0 34 91) 6 35 – 50, Telefax: (0 34 91) 6 35 – 5 52