RESICHEM 530 HA100 – corrosion protection coating

Resichem 530 HA100 is a single component solvent free heat activated epoxy novolac coating. The product has been designed to be applied to metallic surfaces operating at temperatures 100˚C to 240˚C. Once cured the coating provides excellent corrosion protection.

- Heat activated 100˚C to 240˚C
- Surface tolerant coating
- Excellent corrosion protection at high temperatures

Typical applications

Hot process pipes	External tank and process equipment surfaces	Field joints
External pipeline surfaces	Corrosion under insulation protection	

Surface Preparation

Surfaces operating at 100˚C to 240˚C

Metallic Substrates – Mechanical abrasion

1. All surfaces must be mechanically abraded using handheld grinders to ***ISO 8501/4 ST3 (SSPC SP3 ST3)***.

Metallic Substrates – Hydro-blasting

1. All surfaces must be hydro-blasted using clean water at 12,000 psi (850bar) to ***NACE 5 (SSPC SP13 WJ3-WJ1)***.

Metallic Substrates – Abrasive blast cleaning

1. All surfaces must be abrasive blasted to ***ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)*** minimum blast profile of 75 microns (3mil) using an angular abrasive.

The coating can be applied to cold surfaces, however after application the coated surface must be heated to 100˚C+ in order for the coating to cure. Heat must be applied until the coating has cured hard, please see the cure times overleaf. If applying to cold surfaces the following procedures must be followed.

1. All oil and grease must be removed from the surface using an appropriate cleaner such as MEK.
2. All surfaces must be mechanically abraded, hydro-blasted or abrasive blast cleaned to the appropriate standard.
3. Once abraded, the surface must be degreased and cleaned using MEK or similar type material.
4. All surfaces must be coated before gingering or oxidation occurs.

Mixing

1. The product is a single component product
2. Ensure the product is at a temperature between 25-35°C (77-95F°).
3. The ambient & surface temperatures are not less than 3°C (6°F) above the dew point.

Application

Brush or roller applications

1. Pour the material into a paint kettle or paint tray
2. Using a 50mm (2”) wide synthetic brush, stripe coat all edges, joints, corners and equipment with the mixed material. The stripe coat must be approximately 100mm (4”) wide, at 200-300microns (8-12mils) wet film thickness.
3. Once the stripe coat has cured sufficiently and is capable of being overcoated, apply the 1st coat of product to all surfaces at 400 microns (16mils) wet film thickness.
4. Once the 1st coat of material has cured sufficiently (this depends on the surface temperature, please cures times overleaf), apply a 2nd coat of material to all surfaces at 400 microns (16mils) wet film thickness

Spray Applications

1. Spray application should be carried out by airless spray using a 60:1 ratio pump with an attached hot water pump to heat the spray lines.
2. The temperature around the spray lines should be kept around 45°C (115F°).
3. Spray pressure of 3500psi and a tip size of 19-23 thou should be used.
4. Use as short a line as possible to maintain product temperature (maximum 8meters/ 26foot)
5. Circulate the product for a short time to achieve temperature equilibrium.

6. Apply the 1st coat of product to all surfaces at 400 microns (20mils) wet film thickness.
7. Once the 1st coat of material has cured sufficiently (this depends on the surface temperature, please see cures times below), apply a 2nd coat of material to all surfaces at 400 microns (20mils) wet film thickness

Coverage Rates

4ltrs (1.15 US gallon) of fully mixed product will give the following coverage rates –
10m² at 400 microns 108ft² at 16mil

Please note that the coverage rates quoted are theoretical and do not take into consideration the profile or condition of the surface being repaired.

Cure Times

Touch dry

100°C 50 minutes
150°C 3 minutes
200°C 20-30 seconds
240˚C 10-15 seconds

Maximum overcoating time

100°C 3 hours
150°C 1 hours
200°C 15 minutes
240˚C 7 minutes

Fully cured

100°C 24 hours
150°C 4 hours
200°C 30 minutes
240˚C 15 minutes

Pack Sizes

This product is available in the following pack sizes –
4ltrs (1.1 US Gallon)

Colour

Singe component product - red

Storage Life

2 years if unopened and store in normal dry conditions (15-30°C/ 60-86F°)

Other Technical Documents

Quick Application Guide	-	Brush, roller or spray applications
Safety Data Sheets	-	Single component
Product Specification Sheet	-	Technical Performance Information

Health and Safety

Please ensure good practice is observed at all times. Protective gloves, goggles & a disposable coverall must be worn during the mixing and application of this product. Before mixing and applying the material ensure you have read the fully detailed Safety Data Sheet.

Legal Notice: