

# PROTAL 7200

## Fast Cure, High Build Pipeline Coating

### Description

Protal 7200 is a VOC free, 100% solids, 2 part epoxy coating specially formulated to compliment FBE coated pipe. It is a high build liquid coating that is brush or spray applied (referred to as Protal 7250 in Canada) in one coat in the field or shop. It cures very fast to allow quick handling and backfill times.

### Uses

On-site protection of girth welds, tie-ins, welds for boring applications, repairs to FBE, push-rack applications, station piping, fittings and fabrication. Also used for main line pipe coating, sacrificial coating for directional drill (ARO) and road bore pipe, and rehabilitation of existing pipelines.

### Features

- Fast touch dry and set times
- High temperature resistance (up to 185°F)
- High build (up to 50 mils in one coat)
- Excellent adhesion (compliments FBE coated pipe)
- High abrasion resistance for drilling applications
- Can be used as an abrasion resistant coating (ARO)
- Safe and environmentally friendly
- Does not shield cathodic protection
- Can be applied with brush, roller or spray
- Available in a variety of packaging options

### Application

**Brush:** Prepare surfaces by grit blasting to a clean near white finish, SSC-SP 10/ NACE No. 2. Appropriate angular grit shall be used to achieve a 2.5 to 5 mil anchor profile. Initially stir the base and hardener. Add the hardener to base and mix at a slow speed until a constant color is achieved making sure all sides of container are scraped. Apply mixed material onto surface and brush, trowel or roll to required mil thickness. A wet film thickness gauge shall be used to measure mil thickness. If surface temperature falls below 50°F (10°C), surface should be preheated to achieve faster cure. Preheat may be achieved with a propane torch or induction coil. Resin and hardener component shall be kept warm, at a minimum of 60°F (15°C), to mix easily.

**Spray:** Prepare surfaces by grit blasting to a clean near white finish, SSC-SP 10/ NACE No. 2. The equipment should be a plural component airless spray unit with a proportioning pump capable of a volume mixing ratio of 3:1. Standard ancillary equipment should include minimum 10 gallon hoppers, 2 ea. static mixers, 25 ft. max x 1/4" whip hose, and mastic gun with a 19 to 27 thou tip. (Applicator should consult with Denso regarding recommended equipment). Part A should be heated to 140°F - 150°F and Part B heated to 100°F - 110°F. Hose bundle shall be set at 140°F - 150°F. A wet on wet spray technique should be used to achieve a minimum thickness of 20 mils. The coating thickness should be measured using a wet film thickness gauge.

For complete application instructions please refer to Protal 7200 application specifications.



# Protal 7200

## TECHNICAL DATA

PROPERTIES	VALUE
<b>Solids Content</b>	100%
<b>Base Component - (Unmixed) @ 77°F (25°C)</b>	
Specific Gravity	1.63
Viscosity	255,000 cps
Color	White
<b>Hardener - (Unmixed) @ 77°F (25°C)</b>	
Specific Gravity	1.05
Viscosity	5,500 cps
Color	Dark Green
<b>Mixed Material - (Mixed) @ 77°F (25°C)</b>	
Specific Gravity	1.63
Viscosity	170,000 cps
Color	Green
<b>Mixing Ratio (A/B) by Volume</b>	3 Parts Base: 1 Part Hardener
<b>Cure Times</b>	
Pot Life @ 77°F (25°C)	14 - 17 Minutes
Pot Life @ 97°F (36°C)	7 - 8 Minutes
Handling Time @ 77°F (25°C)	2.5 - 3 Hours
Handling Time @ 117°F (47°C)	1 Hour
Handling Time @ 157°F (69°C)	20 Minutes
<b>Recoat Window</b>	
@ 57°F (14°C)	5 Hours
@ 77°F (25°C)	2 Hours
@ 97°F (36°C)	1 Hour
<b>Theoretical Coverage</b>	14 ft <sup>2</sup> /30 mils/liter
<b>Thickness - Weld Joints / FBE Repairs</b>	
Minimum/Maximum	20/60 mils
Recommended	25 - 30 mils
<b>Thickness - Bore Pipe</b>	
Minimum/Maximum	35/60 mils
Recommended	45 - 55 mils
<b>Holiday Detection</b> - based on min. mil. thickness specified	125 volts/mil
<b>Cathodic Disbondment Test (ASTM G95)</b>	
28 Days @ 77°F (25°C)	3 mm
28 Days @ 150°F (65°C)	4 mm
28 Days @ 175°F (80°C)	6 mm
<b>Hardness (ASTM D-2240-02)</b>	Shore D 85 +/-2
<b>Impact Resistance (ASTM G14-88)</b>	60.89 in-lbs.
<b>Adhesion to Steel/FBE (ASTM D-4541-02)</b>	3,200 psi
<b>Application Temperature</b>	-30°F to 212°F (-34°C to 100°C)
<b>Service Temperature</b>	-40°F to 185°F (-40°C to 85°C)

Note: If temperature falls below 50°F (10°C), surface must be preheated and maintained throughout the cure process.

**STORAGE:** Minimum 24 months when stored in original containers @ 40°F (4°C) to 105°F (41°C). On job site where temperatures are below 50°F (10°C) product should be kept warm to mix properly (65°F to 85°F optimal).

**CLEANING:** Clean equipment with MEK or equivalent solvent cleaner.

**HEALTH AND SAFETY:** Wear protective clothing and ensure adequate ventilation. Avoid contact with skin and eyes. See material safety data sheet for further information.

**PACKAGING:** 1, 1.5, 1.75 and 2 liter kits and 75 liter & 800 liter kits standard. Dual cartridge repair tubes (400 ml & 50 ml) and dispensing guns available for small repair areas.



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