



CORROPIPE II JOINT COATING (E)

TECHNICAL DATA

PIPE JOINT COATING SYSTEM

THE PRODUCT AND ITS USES

CorroPipe II Joint Coating (E) is a 100% solids (no VOC) polyurethane-epoxy hybrid coating system that meets the requirements of NSF/ANSI Standard 61. The product offers corrosion protection for both the interior and exterior surfaces of field welded steel pipeline joints.

CorroPipe II Joint Coating (E) combines the superior chemical resistance and moisture tolerance of an epoxy coating with the high adhesion, impact and abrasion resistance of a rigid polyurethane coating. CorroPipe II Joint Coating (E) is well suited to high humidity and field applications, and your perfect joint coating choice for applications involving highly chemical resistant main coatings, such as Madison's CorroPipe II UltraLiner. Typical applications include pipe joints and repairs for industrial water and wastewater. For less chemically aggressive environments, such as regular municipal water and wastewater, we recommend Madison's CorroPipe II EC 120. End users concerned with ease of application may also wish to consider CorroPipe 'S', a 72% solids polyurethane coating.

APPROVALS AND LISTINGS

UL Water Quality Certified in accordance with NSF/ANSI Standard 61.



TECHNICAL INFORMATION

PROPERTY	TEST DESCRIPTION	RESULTS
Application Temperatures	N/A	0°C (32°F) to 65°C (150°F)
Pot Life	@ 20°C/70°F	90 minutes (brush/trowel) 30 minutes (spray)
Dry to Touch Time	@ 20°C/70°F	12 to 15 hours
Curing Time Before Handling	@ 20°C/70°F	48 hours
Ultimate Cure	@ 20°C/70°F	7 to 10 days
Recoat Time*	@ 20°C/70°F	Up to 48 hours
Solids Content	ASTM D-1259	100%
Volatile Organic Compounds (VOCs)	ASTM D-2369	0 grams/litre
Theoretical coverage	N/A	1016m ² /litre/micron (1604 ft ² /US gallon/mil)
Adhesion to steel	ASTM D-4541 (SSPC 5)	Greater than 1500 p.s.i.
Adhesion to concrete	ASTM D-4541	Greater than cohesive strength on concrete
Hardness	ASTM D-2240 Shore D	75 to 80
Abrasion Resistance	ASTM D-4060 (CS-17 wheels, 1 kgs weights, 1000 revolutions)	Less than 70 mg loss
Resistance to Cathodic Disbondment	CSA-Z245 (65°C 48 hours, 20 mils)	10 mm radius
Impact Resistance	ASTM D-2794 (20 mils)	40 in. lbs.
Temperature Resistance	ASTM D-870	-40°C (-40°F) to 70°C (158°F) Wet

*However, recoat window varies depending on the spray equipment temperature setting, the ambient conditions, product temperature/thickness, and the temperature of the substrate being coated.

NOTE: All statements, technical information and recommendations contained herein are typical of results obtained under laboratory conditions and are not intended to be used as contract specifications. For specification guidelines please contact Madison Chemical.

APPLICATION INSTRUCTIONS

CONTACT MADISON FOR DETAILED APPLICATION INSTRUCTIONS.

A. SURFACE PREPARATION

- 1) Ensure that surface is clean, dry and uncontaminated. Proceed only if the substrate temperature is more than 3°C(5°F) above the dew point temperature during surface preparation and coating application.
- 2) Abrasive blast clean with sand or grit (G40 or coarser). **DO NOT USE** steel shot or non-angular media. For **steel** surfaces, blast to a Near White Blast (SSPC-SP10; NACE 2; SA 2.5):
 - minimum 3.0 mil (75 microns) profile for immersion;
 - minimum 2.5 mil (65 microns) profile for buried;
 - minimum 2.0 mil (50 microns) profile for atmospheric service.When this is not feasible for field application, we recommend the pipe is preblasted in the shop. Once in the field, the surface is reblasted or cleaned with a power hand tool to achieve an angular pattern with a minimum depth profile of 2.5 mil (65 microns) for immersion service. For **ductile iron** surfaces, abrasive blast to achieve a surface anchor profile of 2.5 mils or greater. Remove all rust and loose oxides. For **concrete** surfaces, abrasive blast to remove any laticence. Ensure there are no visible bug holes on the surface. If so, patch to fill the holes using suitable materials. For **previously coated** surfaces, use 40 grit or coarser sandpaper or brush-off blast to roughen surface.
- 3) See Madison Application Instructions for details.

B. APPLICATION OF COATING

- 1) Mix two parts 'A' component with one part 'B' component by adding the premeasured amount of 'B' into the 'A' container provided.
- 2) Stir the mixture until uniform colour is obtained.
- 3) Apply the coating using a brush, spatula, trowel or 45:1 Graco King spray pump. Contact Madison for detailed instructions.
- 4) **DO NOT THIN.** Thinner will reduce the performance properties of the coating. Should the mixture become too thick to apply, discard and mix a new batch.

C. CLEAN-UP AND STORAGE

- 1) This material will react with humidity and moisture. Keep containers tightly sealed and store upside down. For clean-up, use Madison VR-1 Viscosity Reducer, M.E.K. or a 50:50 blend of M.E.K. and Xylol. Other solvents may react with product.
- 2) Store between 10°C(50°F) and 27°C(80°F). **DO NOT FREEZE.** Use product within 6 months of receiving.

HEALTH AND SAFETY

CorroPipe II Joint Coating (E) is intended for industrial use only. It contains no monomeric isocyanates but may nevertheless cause respiratory distress in some people. Provide ample ventilation. Wear a fresh air respirator when using in confined areas or when spraying. Wear rubber gloves, safety goggles and protective clothing. If swallowed, **DO NOT** induce vomiting as this will cause additional throat irritation; contact physician. If splashed on skin, remove immediately with rubbing alcohol and then wash with soap and water. If splashed in eyes, wash liberally with clean water and contact physician; temporary irritation of eyes may last several days. Contains trace amounts of ingredients which may cause skin cancer following prolonged direct skin contact. Therefore, commonly used skin protection is recommended. See MSDS for more information. The finished product is completely inert and harmless.

LIMITED TWO YEAR WARRANTY

Madison will replace any product which, in service for which it is suitable, fails to meet specifications within two years of sale and which is proven to be defective when applied according to instructions by a Madison Approved Applicator or Certified OEM Applicator. Madison accepts no responsibility or liability for any other loss, claim, damage, injury or expense, direct or consequential, in contract or negligence. This product replacement warranty is in lieu of any other right, warranty, guarantee or condition, statutory or otherwise, expressed or implied, whether as to fitness for a particular purpose or as to merchantable quality or otherwise.

The information contained herein is believed to be accurate as of the date of publication. Madison reserves the right to change product specifications without notice.

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