

Procoat 325W

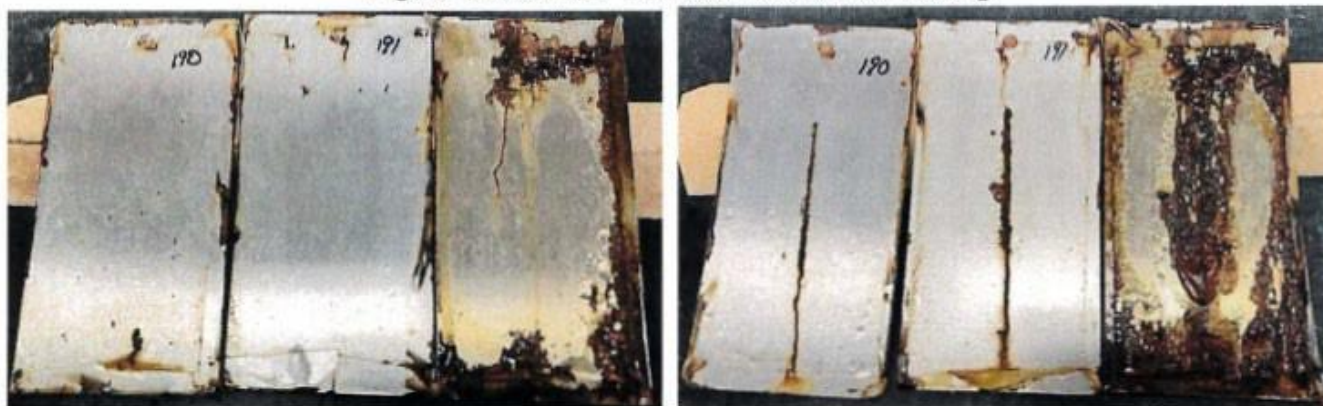
External Water Based Pipe Coating

Description:

Procoat 325W is a low VOC, non-hazardous, water-based pipe coating that dries to a clear, hard finish on oilfield tubulars. It is designed for fast drying and easy application, providing corrosion protection during storage. The clear formula facilitates the inspection of stencils and markings. Procoat 325W effectively prevents rust on metal substrates for over 200 hours in a saline fog environment. Protect from freezing, store above 45 °F. Mix thoroughly after long periods of storage and prior to use or dispensing into sprayers or buckets.

Figure 1: The image shows panels 190 and 191 coated with Procoat 325W, while the far-right panel serves as a control with Amber 325, a leading solvent borne coating. Procoat 325W dried faster than Amber 325. All coatings exhibited a smooth, uniform, defect-free finish when applied to cold rolled steel panels, with Procoat 325W outperforming Amber 325 at the 200-hour mark.

Figure 1, 200 Hour Corrosion Resistance Testing



Features:

- Non-Hazardous
- Fast Dry Time
- Transparent
- Exceptional Corrosion Resistance
- Easy Handling and Application
- Caution – Protect From Freezing
- Store in well-ventilated area out of direct sunlight and maintain temperature above 45 F.

Physical Properties:

- Color White
- Coverage..... 530 sq/ft /gal.
- Consistency Liquid
- Density 8.57 Lbs./gal
- Viscosity Zahn No.2 at 25°C..... 26 Sec.
- Dry Time (3 mil draw down @ 70°F/50% Relative Humidity).....0.7 hr. STT
- Salt Spray Test (ASTM B-117) Passed, 200 hr.
- Shelf Life (Unopened Container) 1 Year
- Volatile Organic Content (VOC).....53.98 gm/L
- Storage temperature.....Above 45°F

Application:**1. Surface Preparation:**

- **Clean the Metal:** Remove dirt, grease, and oils using a degreaser or solvent like isopropyl alcohol. For heavy contamination, use a pressure washer or alkaline cleaner.
- **Remove Rust and Old Coatings:** Sandblast, wire brush, or sand the surface to eliminate rust, scale, or peeling paint. Aim for a clean, slightly rough surface (e.g., SSPC-SP 6 or Sa 2.5 standard for blasting).
- **Phosphating (Optional):** Apply a phosphate conversion coating for enhanced corrosion resistance, especially on steel or iron. This improves adhesion of water-based coatings.
- **Dry Thoroughly:** Ensure the surface is completely dry to prevent flash rusting, as water-based coatings are sensitive to moisture.

2. Application Method:

- **Spraying (Preferred):**
 - Use an HVLP (High Volume Low Pressure) sprayer or airless sprayer for a smooth, even coat. Adjust the nozzle (1.3–1.8 mm tip) and pressure (30–50 psi for HVLP) to minimize overspray.
 - If required, thin the coating with distilled water (5–10%) to improve flow and reduce orange peel.
- **Brushing or Rolling:**
 - Use a synthetic bristle brush or short-nap roller (1/4–3/8 inch) for small areas or touch-ups. Work quickly to avoid lap marks, as water-based coatings dry fast.
 - Apply thin, even coats to prevent runs or sagging.

3. Application Conditions:

- **Temperature and Humidity:** Apply at 50–85°F (10–29°C) with relative humidity below 70%. Avoid application in direct sunlight or on hot surfaces (>100°F/38°C) to prevent blistering or poor film formation.
- **Ventilation:** Ensure good airflow to aid drying and prevent trapping moisture, but avoid strong drafts that cause uneven drying.

4. Curing and Handling:

- Drying times are as follows: touch dry in 0.7 hours, tack free in 1.7 hours, hard dry in 5 hours, and fully cured in 26 hours.

5. Equipment Cleanup:

- Clean tools immediately with warm water and soap before the coating dries. For stubborn residue, use a mild solvent like ammonia or a manufacturer-recommended cleaner.