

### PRODUCT DESCRIPTION

REFLO 2205 HTC is designed to upgrade the performance of conventional materials of construction and in particular to protect equipment operating in contact with water and aqueous/hydrocarbon mixtures against erosion/corrosion at elevated temperatures. The coating once fully cured is capable of withstanding temperatures up to 130°C (265°F) in continuous immersion in water, salt water and crude Oil

### TYPICAL APPLICATIONS

Suitable for coating surfaces suffering from severe erosion, corrosion or abrasion such as:

- Test Separators
- Production Separators
- Scrubber Units
- Knock out Drums
- Distillation Units
- Evaporators
- Condensate Pumps
- Calorifiers

### SURFACE PREPARATION

#### GENERAL

Correct surface preparation is essential for the success of any application. All oil and grease must be removed from the surface of the repair using an appropriate cleaner such as MEK.

#### STEEL SUBSTRATE

For optimum performance, all steel substrates should be abrasive blasted to ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2) and a minimum blast profile of 75 microns using an angular abrasive. Remove all residual blast debris and the surfaces inspected. Profile checks should be taken and recorded. Once blast cleaned, the surface must be degreased and cleaned using MEK or similar type material. All surfaces must be repaired before rusting or oxidation occurs.

PLEASE NOTE: For salt contaminated surfaces the area must be abrasive blast cleaned as mentioned above and left for 24 hours to allow any ingrained salts to come to the surface. After this 24 hour period the surface must be washed with MEK prior to brush blasting to remove the surface salts. This process must be repeated until all ingrained contaminants have been sweated out of the surface.

### MIXING AND APPLICATION

#### PRECAUTIONS

Warm the Base component to 15-25°C (60-77°F) before mixing and do not apply when the ambient or substrate temperature is below 10°C (40°F) or less than 3°C (37°F) above the dew point

#### MIXING

Pour the contents of the Activator unit into the Base container ensuring that as much material is drained from the Activator container as possible. Mix the two components together until they are streak-free using a spatula. *From the commencement of mixing the material should be used within 20-30 minutes at 20°C (68°F).*

Apply the product to radius edges, welds and corners, at a target wet film thickness of 300-500 (10-14mil) microns per coat, using a stiff bristled brush. Allow the stripe coat to cure for 4 hours before applying the first full coat at a target thickness of 500 microns, using a short bristled brush fully wetting out the profiled surface.

As soon as possible after application of the first layer, and after no longer than 12 hours, apply a further coat at a target thickness of 500 microns. If the maximum over-coating time is exceeded, the first layer should be brush blasted or abraded before applying the second coat.

#### Coverage Rates

1kg (2.2lb) of fully mixed product will give the following coverage rates –

1.836m <sup>2</sup> at 250 microns	19.75ft <sup>2</sup> at 10mil
0.918m <sup>2</sup> at 500 microns	9.87ft <sup>2</sup> at 20mil

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

### CURE TIMES

At 20°C (68°F) the applied materials should be allowed to harden for the times indicated below before being subjected to the conditions indicated. These times will be extended at lower temperatures and reduced at higher temperatures:

Temperature	Movement without load or immersion	light loading	Low Temperature Immersion	Hot Water Immersion
10°C/50°F	8 Hours	16 Hrs	7 Days	14 Days
20°C/68°F	5½ Hours	9 Hours	4 Days	7 Days
30°C/86°F	2 Hours	3 Hours	2 Days	3 Days
40°C/104°F	1½ Hours	2 Hours	1½ Hours	2 Days

# TECHNICAL DATA SHEET: REPFLO 2205 HTC

## POST CURING FOR OPTIMAL PERFORMANCE

After an initial curing period of at least 4 hours at 20°C (68°F), raising the cure temperature progressively to 60 - 100°C (140-212°F) for up to 8 hours will result in improved mechanical, thermal and chemical resistance properties. It is also a procedure which can be adopted for applications where a fast turnaround is required exposing the coating to a hot aggressive environment.

## UNIT SIZES

Product is available in the following pack sizes –  
1kg (2.2lb), 3kg (6.6lb)

## OVERCOATING TIMES

Minimum – further material can be applied as soon as the first layer is touch dry or 4 hours.

Maximum – regardless of temperature the over-coating time should not exceed 12 hours.

Where the maximum over-coating time is exceeded, the material should be allowed to harden before being abraded or flash blasted to remove surface contamination, and to expose a frosted appearance.

## COLOUR

Mixed Material	Dark Grey/Light Grey
Base Component	Dark Grey/Light Grey
Activator Component	Amber Liquid

## STORAGE LIFE

The shelf life of the product is typically 5 years if unopened and stored in cool dry conditions (15-30°C/ 60-86°F). Once opened replace the lid firmly and store as above.

## TECHNICAL SUPPORT

Zoom Corrosion Technology offer complete technical support and assistance, from discussing application requirements to training approved local contractors. For further information please contact a REPCO representative or your nearest REPCO authorised dealer.

## TECHNICAL DATA

Volume Capacity	459cc/Kg
Compressive Strength ASTM D695	1046kg/ cm <sup>2</sup> (14,880)
Tensile Shear Adhesion ASTM D1002	245kg/cm <sup>2</sup> (3,480psi)
Flexural Strength ASTM D790	614kg/cm <sup>2</sup> 8,710psi
Hardness Shore D ASTM D2240	88
Corrosion Resistance (ASTM B117)	5000 hours

## ADDITIONAL TECHNICAL DATA

Please see the REPFLO 2205 HTC Product Specification Sheet for further technical and performance data.

## HEALTH AND SAFETY

Please refer to the product safety data sheet for detailed information on handling, storage, shipping and disposal.

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