B-TEAM
CORROSION PROTECTION
Coat for Every Industry!

Tel/ Fax :Tel : +40 21 205 30 20
Gsm: +40 747 133 933;
E-mail: protectii@bteam.ro,office@bteam.ro
Web: www.anticoroziv.eu,www.bteam.ro

TECHNICAL BULLETIN

COROFLAKE 18

Product Description:

COROFLAKE 18 is a two component, C-glass flake filled Novolac vinyl ester lining system. This lining system consists of one primer @ 50 µm nominal, one body coat and one topcoat @ 800 –1,000 µm DFT per coat to produce a total DFT of 2,000 µm nominal. The vinyl ester resin provides excellent chemical resistance and firmly bonds the multiple layers of overlapping micron-thick C-glass flakes to achieve an extremely low permeation rate, which greatly reduces water vapour passage through the lining.

Recommended Uses:

COROFLAKE 18 provides the longest lasting, most effective lining system for corrosion prevention in the Chemical Process Industries. It can be used to protect internal surfaces of absorbers in Flue Gas Desulphurisation Systems.

Temperature Resistance:

+ 90 °C wet + 160 °C dry

Generic Type:

Novolac Vinyl Ester

Filler:

C-Glass Flakes

Solvent:

Styrene (reactive)

Design:

The steel construction to be coated must be fabricated according to the DIN EN 14879-1:2005. Further information can be taken from our steel specification documents.

Preparation:

Steel substrates, which have been previously been used in service, require a chemical check for the presence of invisible traces of iron sulphate and or iron chloride. If the check is positive, the total surface area needs to be washed down thoroughly with de-ionised water. In each case, steel substrate shall be prepared by abrasive blasting to obtain a Sa 2˝ surface, as defined in DIN EN ISO 12 944 Part 4 and a minimum surface profile @ 60 µm “Medium (G)” as defined in DIN EN ISO 8503-2.

Build-up of the system:

	Layer Thickness	Coverage
COROFLAKE S PRIMER	1 x 40 - 60 µm	150 g/m¸
COROFLAKE 18 Coating	2 x 800 – 1,000 µm	2 x 1.700 g/m¸

Mixing Ratio:

100:2 COROFLAKE S PRIMER or resin to HARDENER No.1 by weight. Stir hardener always into resin-based component, using a low speed mechanical agitator.

Pot Life:

1 ˝ hrs. (+ 10 °C) 1 hr. (+ 20 °C) ˝ hrs. (+ 30 °C)

Application Equipment:

Trowel and Roller.

Tel/ Fax :Tel : +40 21 205 30 20
Gsm: +40 747 133 933;
E-mail: protectii@bteam.ro, office@bteam.ro
Web: www.anticoroziv.eu, www.bteam.ro

Application:	Primer is normally applied by brush or roller. During application observe pot life limitations. The substrate temperature shall be at + 8 °C to + 36 °C. The air temperature shall be at + 10 °C to + 36 °C (3 K above dew point). The following topcoats should be applied no longer then seven days later. Refer to the application instruction for further details. Note: During application the coated surface must be shaded from direct or indirect sunlight. Intercoat disbondment may otherwise occur.
Cleaning:	Solvent T-100
Shelf Life:	The shelf life is 3 months when stored @ + 20 °C. ***COROFLAKE 18*** Resin, Primer and HARDENER No. 1 should be stored at a cool and dry place.
Density:	1.2 kg/l (mixed)
Viscosity:	semi thixotropic
Flash Point:	***COROFLAKE 18*** + 32 °C and HARDENER No. 1 + 70 °C
Modulus of Elasticity:	5,000 – 8,000 MPa (DIN EN ISO 178) flexural
Tensile Strength:	30 Mpa (DIN EN ISO 527)
Coefficient of Expansion:	25 - 30 x 10^{-6} 1/°C (ASTM D 696-90) linear
Abrasion:	68 mg (ASTM – D 4060)
Permeation:	0.00001 perm-inch (ASTM – E 96 - 90 Procedure E)
Adhesion:	4 N/mm¸ (EN ISO 4624) to grit blasted C-Steel
Hardness:	35 Barcol (DIN EN 59)