

## PRODUCT INFORMATION

### COROGARD 615

#### General Properties

**COROGARD 615** is a two-component inert flakes filled coating based on a high-grade epoxy resin. The epoxy resin contains additionally active anticorrosive pigments. Hereby an excellent adhesion is ensured when applied on manual derusted surfaces.

#### Fields of application

**COROGARD 615** is especially used as corrosion protection of steel surfaces where a normal abrasive blasting is not possible. The coating can also be applied on concrete, on galvanised metal sheets and on existing and firmly adhering paint coatings. Exceptions are chlorinated rubber and vinyl coatings.

#### Product description

Polymer: Epoxy resin  
Filler: Inert flakes and anticorrosive pigments

#### Properties

- Versatile application
- Applicable on manual derusted steel surfaces
- Easy and fast application
- High layer thickness in one work step
- Excellent adhesion on various substrates

#### Chemical resistance

Information on the chemical resistance properties will be provided on request.

#### Substrate

The parts to be coated must be fabricated according to the EN 14879-1. For concrete structures also refer to DIN 1045.

#### Surface pre-treatment

##### **Carbon steel**

Oil, grease or other contaminations must be removed and a wire brush is required to remove loose rust. The substrate shall be prepared to a preparation degree St 2 as specified in EN ISO 12944-4.

##### **Concrete**

Appropriate actions shall be taken to prepare the concrete surfaces dry and free of dust and free of

contaminants such as oil or grease. The concrete shall have a minimum surface strength of 1.5 MPa.

#### Paint coatings

Existing coatings should be roughened by grinding with sand paper or grinding machine.

#### Coating layers composition

The coating is composed of approximately one coat of the two-component **COROGARD 615** coating system.

#### Consumption

Layer	Thickness	Consumption
<b>COROGARD 615</b> on steel	1 x 200 – 250 microns	300 g/m <sub>2</sub>
<b>COROGARD 615</b> on concrete	approx. 200 microns	400 g/m <sub>2</sub>

The mixing ratio of the two components **COROGARD 615 A** and **COROGARD 615 B** is 1:1 by weight. The components are delivered to the site in prepared application kits so that weighing or measuring of the components is omitted.

#### Application

**COROGARD 615** should be applied with airless or conventional air spray system or by rolling. The following time data shall be observed:

Temperature	10 °C	20 °C	30 °C
Pot life	8 h	4 h	2 h
Time to recoat	24 h	12 h	6 h

Note: In atmospheric exposure epoxy resin coatings have a tendency to chalking with the time. Attention should be paid especially in case of light-coloured coatings. For colour stability a polyurethane top coat is recommended.

Note: During application the coated surface must be shaded from direct or indirect sunlight.

**Cleaning:** Solvent T-100

**Packing units**

The products are supplied in the following standard package sizes:

Description	Package Size	Product No.
<b>COROGARD 615 A</b>	5 kg	590 1049
<b>COROGARD 615 B</b>	5 kg	590 1056

**COROGARD 615** is available in different colours according to the RAL colour matching system.

**Storage**

The materials must be stored in a cool and dry place. At a storage temperature of 20 °C the minimum shelf life is as follows:

<b>COROGARD 615 Component A</b>	1 year
<b>COROGARD 615 Component B</b>	1 year

If the storage time is exceeded the materials must be tested before use. Higher storage and transport temperatures will reduce the shelf life. The containers must be kept tightly closed. Liquid products must be stored frost-proof.

**Safety Measures**

The material safety data sheets of the individual components as well as the legal requirements for handling hazardous materials must be observed.

Technical Data	Testing Standard	Unit	Value
Density	EN ISO 1183	kg/l	1.32 (mixture)
Viscosity	EN ISO 2884-2	mPa·s	2.700 ± 300
Solid Content		%	86 ± 2
Modulus of Elasticity (Bend Test)	EN ISO 178	MPa	3.000 – 3.500
Abrasion	ASTM D 4060	mg	100
Minimum Adhesion Strength	EN ISO 4624	N/mm <sub>2</sub>	steel: 5 concrete: 1.5
Maximum Operation Temperature	ASTM STP 837	°C	dry: 120