

SIGMA C200a COAL TAR

3 pages

January 2009
Revision of December 2001

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| DESCRIPTION | two component high build polyamide cured coal tar epoxy coating |
| PRINCIPAL CHARACTERISTICS | <ul style="list-style-type: none"> - outstanding water and crude oil resistance - excellent corrosion resistance - can be used for buried exposure - good resistance against chemically polluted water - can be applied at temperatures down to 10 °C - good abrasion resistance - resistant against temperatures up to 120 °C in dry surroundings - a dft of 400µm can be applied in one operation by airless spray - meets the requirements of Paint Spec 16, Steel Structures Painting Council; C-200a Corps of Engineers |
| COLOURS AND GLOSS | black - eggshell |
| BASIC DATA AT 20°C | (1 g/cm ³ = 8.25 lb/US gal; 1 m ² /l = 40.7 ft ² /US gal) |
| Mass density | 1.3 g/cm ³ |
| Volume solids | 78± 2% |
| Recommended dry film thickness | 200µm |
| Theoretical spreading rate | 3.4 m ² /l for 200 µm* |
| Touch dry after | 4 hours |
| Overcoating interval | min. 6 hours* max. 5 days* |
| Full cure after | 7 days* |
| Shelf life (cool and dry place) | at least 12 months * see additional data |
| RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES | <ul style="list-style-type: none"> - steel; blast cleaned to ISO-Sa2½ - previous coat; (Sigma C200a Coaltar or compatible primer) within overcoating interval, dry and free from any contamination, and sufficiently roughened if necessary - steel, atmospheric conditions; power tool cleaned to SPSS-St3 - substrate temperature should be above 5°C and at least 3°C above dew point |
| INSTRUCTIONS FOR USE | <p>mixing ratio by volume: base to hardener 86 : 14</p> <ul style="list-style-type: none"> - the temperature of the mixed base and hardener should preferably be above 15°C, otherwise extra solvent may be required to obtain application viscosity - too much solvent results in reduced sag resistance - thinner should be added after mixing the components |
| Induction time | 15 minutes at 20°C |
| Pot life | 6 hours at 20°C * |

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APPLICATION METHODS

AIRLESS SPRAY

Recommended thinner Sigma thinner 21-06
 Volume of thinner 0 - 15%, depending on required thickness and application conditions
 Nozzle orifice approx. 0.48 - 0.58 mm (= 0.019 - 0.023 in)
 Nozzle pressure 15-19 MPa (= approx 2130 - 2700 p.s.i.)

AIR SPRAY

Recommended thinner Sigma thinner 21-06
 Volume of thinner 5 - 15%, depending on required thickness and application conditions
 Nozzle orifice 1.5 mm-3mm
 Nozzle pressure 0.3 - 0.4 MPa (= approx. 3 - 4 bar; 43 - 57 p.s.i.)

BRUSH/ROLLER

Recommended thinner Sigma thinner 21-06
 Volume of thinner 0 - 5%

CLEANING SOLVENT

Sigma thinner 90-53

SAFETY PRECAUTIONS

for paint and recommended thinners see safety sheets 1430, 1431 and relevant material safety data sheets

this is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapour as well as contact between the wet paint and exposed skin or eyes

ADDITIONAL DATA

Film thickness and spreading rate

| | | | | |
|----------------------------------|-----|-----|-----|-----|
| theoretical | 6.1 | 5.1 | 3.8 | 3.1 |
| spreading rate m ² /l | | | | |
| dft in µm | 125 | 150 | 200 | 250 |

maximum dft without sagging with airless spray: 400 µm

minimum dft for closed film with airless spray: 75 µm

maximum dft for brush application: 75 µm

Note: maximum dft is for overlap areas only

Overcoating table for DFT up to 250µm

| | | | | |
|-----------------------|----------|---------|---------|---------|
| substrate temperature | 10°C | 20°C | 30°C | 40°C |
| Minimum interval | 24 hours | 8 hours | 6 hours | 4 hours |
| maximum interval | 20 days | 7 days | 4 days | 3 days |

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Curing table

| Substrate temperature | Curing before exposure to water and slightly polluted atmosphere | Full cure for immersion in polluted water or crude oil |
|-----------------------|--|--|
| 10 °C | At least 24 hours | 24 days |
| 20 °C | At least 24 hours | 10 days |
| 30 °C | At least 24 hours | 5 days |
| 40 °C | At least 24 hours | 3 days |

- adequate ventilation must be maintained during application and curing (please refer to sheet 1433 and 1434)
- if overcoating material is not compatible tar bleeding can occur

Pot life (at application viscosity, 5Ltr set)

| | |
|-------|---------|
| 15 °C | 8 hours |
| 20 °C | 6 hours |
| 30 °C | 2 hours |
| 40 °C | 1 hours |

Worldwide availability

Whilst it is always the aim of Sigma Coatings to supply the same product on a worldwide basis, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances. Under these circumstances an alternative product data sheet is used.

This product is not part of the Sigma Coatings global range and availability is depending on location.

REFERENCES

| | |
|---|----------------------------|
| Explanation to product data sheets | see information sheet 1411 |
| Safety indications | see information sheet 1430 |
| Safety in confined spaces and health safety | |
| Explosion hazard - toxic hazard | see information sheet 1431 |
| Safe working in confined spaces | see information sheet 1433 |
| Directives for ventilation practice | see information sheet 1434 |
| Cleaning of steel and removal of rust | see information sheet 1490 |

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PPG Protective & Marine Coatings has no control over either the quality or condition of the substrate, or the many factors affecting the use and application of the product. PPG Protective & Marine Coatings does therefore not accept any liability arising from loss, injury or damage resulting from such use or the contents of this data sheet (unless there are written agreements stating otherwise).

The data contained herein are liable to modification as a result of practical experience and continuous product development. This data sheet replaces and annuls all previous issues and it is therefore the user's responsibility to ensure that this sheet is current prior to using the product.

The English text of this document shall prevail over any translation thereof.

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Sigma Paints Saudi Arabia Ltd