

HEGSEL Coat 112

2-C-Epoxy-based protective coating

Description:

HEGSEL Coat 112 is a 2-component ultra-high solids epoxy amine engineered specifically for immersion service in ballast tanks, oil tanks, and refined fuel storage tanks. The high build, edge-retentive properties of **HEGSEL Coat 112** provide superior protection compared to conventional epoxies.

Application:

- For use over prepared steel or concrete surfaces in industrial and marine exposures
- Oil storage tank interiors, refined fuel storage tanks, potable water tanks, water pipes
- Water and waste treatment plants, buried pipe applications, primary and secondary containment areas
- Where edge protection film build properties are required

Technical data:

Finish	Glossy
Flash Point	>93°C, PMCC, mixed
Volume Solids %	98% ± 2% mixed
Mixing Ratio	4:1 by volume
Colour Availability	Light Gray, White, Light Green
Pot Life	Standard hardener: 30-45 min@13°C / 30-45 min@25°C / 20-30 min@38°C
	Low temp. hardener: 20 min@4.5°C / 20 min@13°C / 10 min@25°C
Sweat-in-time	Standard hardener: 15 min@13°C
	Low temp. hardener: 5 min@4.5°C
VOC	<100 g/L; 0.83 lb/gal (EPA Method 24)
Reducer	Not recommended
Clean Up	MEK or HEGSEL Reducer

*Pot life is dependent upon temperature and mass.

Details for application:

Recommended Spreading Rates-Microns Per Coat				
Type	One-coat system		two-coat system	
	Minimum	Maximum	Minimum	Maximum
Dry (microns)	450	550	250	300
Wet (microns)	450	550	250	300
Coverage (m ² /L) per ct.	1.76	2.2	3.2	3.9
Theoretical coverage (m ² /L) @ 25 microns DFT	38.4			
NOTE: Brush or roll application recommended for stripe coating and repair only. Standard hardener preferred for brush & roll due to pot life.				

Average Drying Time @ 250-550 microns, 50% RH				
With Standard Hardener		At 13°C	At 25°C	At 38°
	To touch	12 hours	5 hours	3 hours
	To handle	48 hours	14 hours	8 hours
	To recoat	Min 48 hrs. /Max 21 days	Min 14 hrs. /Max 14 days	Min 8 hrs. /Max 14 days
	Full cured	10 days	4 days	24 hours
	Heat cure	8 hours @ ambient, then 16 hours @ 60°C		
With low temperature Hardener		At 4.5°C	At 13°C	At 25°
	To touch	24 hours	5 hours	3 hours
	To handle	48 hours	24 hours	8 hours
	To recoat	Min 48 hrs./Max 30 days	Min 24 hrs./Max 21 days	Min 8 hrs./Max 14 days
	Full cured	7 days	5 days	3 days
	Heat cure	8 hours @ ambient, then 16 hours @ 60°C		

*Drying time is temperature, humidity, and film thickness dependent. Material should be at least 10°C for optimal performance. If maximum recoat time is exceeded, abrade surface before recoating.

Packaging:

Pack Size: 10.52 ± 0.2 lb/gal ; 1.26 Kg/L, mixed

Shelf Life:

36 months unopened. Store indoors at 4.5°C to 38°C.

1. Recommended Systems

Steel, Immersion (Potable Water)

1 Ct. / HEGGEL Coat 112 / 400-1250 µm
or
2 Cts. / HEGGEL Coat 112 / 200-625 µm
or
3 Cts. / HEGGEL Coat 112 / 150-400 µm

Steel, Immersion & Atmospheric

2 Cts. / HEGGEL Coat 112 / 150-175 µm
or
1 Ct. / HEGGEL Coat 112 / 450-550 µm
or
2 Cts. / HEGGEL Coat 112 / 250-300 µm

Steel, with Hold Primer

1 Ct./ HEGGEL Pox 485 / 25-37 µm
1 Ct./ HEGGEL Coat 112 / 450-550 µm

The systems listed above are representative of the product's use, other systems may be appropriate.

2. Surface Preparation

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

IRON AND STEEL

Atmospheric: SSPC-SP6/NACE 3/
ISO8501-1:2007 Sa 2, 2 mil (50 micron)
profile or SSPC-SP12/NACE No. 5, WJ-
3/NV-2

Immersion: SSPC-SP10/NACE
2/ISO8501-1:2007 Sa 2.5, 2-3 mil (50-75

micron) profile or SSPC- SP12/NACE No. 5, WJ-2/NV-2 (marine exterior hull only)

CONCRETE AND MASONRY

Atmospheric: SSPC-SP13/NACE 6, or
ICRI No. 310.2R CSP 2-3

Immersion: SSPC-SP13/NACE 6-4.3.1 or
4.3.2, or ICRI No. 310.2R CSP 2-3

3. Application Conditions

Temperature (air & surface):

Standard Hardeners:
10°C min, 43°C max
Low Temp Hardener:
4.5°C min, 77°F 25°C max
(At least 2.8°C above dew point)
Material should be 21°C to 29°C for
optimal performance.
Relative humidity: 85% maximum

4. Application Equipment

Airless spray

Unit: 74:1 pump, minimum
Pressure: 6000 psi minimum (415 bar)
Hose: 3/8" ID (9.5 mm)
Tip: 019"-.021" (0.48-0.53 mm)
Filter: 30 mesh

In order to avoid blockage of airless spray equipment and hose, flush equipment with MEK or HEGGEL Reducer at least once every 30 minutes when using the Standard Hardener and after each kit when using the Low Temperature Hardener, and before periods of extended downtime.

Plural Component: Acceptable

Brush: Nylon/Polyester or Natural Bristle, for stripe coating and repair only.

Roller: Cover 3/8" woven with solvent resistant core, for stripe coating and repair only.

5. Additional Notes:

Do not tint Part A.

Clear Hardeners may be tinted with up to 1½ oz.per gallon with Maxitoner Colorant, Phthalo Green or Black ONLY.

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

Do not mix previously catalyzed material with new.

Guidance on techniques and required equipment to inspect a coating system incorporating Opti-Check OAP Technology can be found in SSPC-TU 11.

Note: Recommended application procedure direct to steel: Apply a 125–150 micron coat to the substrate. Allow material to "wet" the surface. Then apply additional material, to bring total film thickness to the recommended range.

Suitable for use with cathodic protection systems.

6. Health and Safety:

Observe the precautionary notices on the container label, and read the Material Safety Data Sheet before use.

HEGGEL Coat 112; Revision No: 0.00 / Last Revision Date: 20.10.2020

All information contained herein is based on the current state of our knowledge and practical experience at the time of release. Therefore, please make sure that this is the actual edition of the Technical Data Sheet. All data are only intended as a guideline for informational purposes and do not constitute a legally-binding warranty of the suitability for a certain purpose of use, due to its dependence on site conditions and possible processing, use and applications. All information contained in this technical datasheet is subject to change without notice.

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