

# HEGSEL Coat 131

2-C-Chemical resistant coating

**Description:**

2-component Novolac coating  
Solvent-free, free of benzyl alcohol and nonylphenol

**Characteristics:**

- ability to check for pores / pore detection
- excellent corrosion protection
- airless sprayable
- thixotropic
- high chemical resistance
- good thermal resistance
- very good adhesion strength
- suitable for single layer application
- inert and harmless once cured

**Product:**

**HEGSEL Coat 131** is designed for use as high performance chemical and abrasion resistant coating and offers excellent anticorrosion properties combined with good resistance to aggressive, non-flammable and flammable liquids and chemicals.

**HEGSEL Coat 131** must be applied by using airless spray equipment with a flow heater and is suitable as a resistant lining of steel tanks, containers and pipes at the chemical industry.

**Layer thickness:**

Minimum 500 microns DFT; maximum layer thickness approx. 1000 microns

Theoretical: approx. 1.2 kg/m<sup>2</sup> (at 1000 microns DFT)

Practical: approx. 1.6 kg/m<sup>2</sup> (at 1000 microns DFT)

*The information relating to practical consumption / coverage is calculated to include 30 % loss.*

*The practical consumption / coverage depends on the conditions of the substrate. We recommend to apply a test area.*

**Resistant to:**

- crude oil, mineral oil
- water, seawater, brackish water, waste water
- lubricants and fuels
- wet heat up to approx. +90°C
- non-oxidising, diluted acids
- alkalis, lyes
- salt solutions
- dry heat up to approx. +170°C

**Technical Data:**

Mixing ratio A : B	9 : 1 by weight
Density (23°C)	approx. 1.20 g/cm <sup>3</sup>
Volume solids	approx. 100 %

**Details for application:**

Pot life (10°C / 23°C / 30°C)	approx. 40 minutes / 25 minutes / 20 minutes
Substrate temperature	minimum 10°C up to maximum 40°C
Material temperature (flow heater if required)	20°C - 35°C
Maximum relative humidity of air	85 %
Dew point - substrate temperature	minimum +3°C above dew point
Duration to overcoat with itself (in case of longer duration time the surface must be prepared by blasting)	10°C: min. 7 hours      max. 48 hours 23°C: min. 4 hours      max. 24 hours 30°C: min. 2 hours      max. 12 hours
Curing time / foot traffic (10°C / 23°C / 30°C)	24 hours / 12 hours / 6 hours
Curing time / mech. resistance (10°C / 23°C / 30°C)	72 hours / 48 hours / 24 hours
Pot life (10°C / 23°C / 30°C)	approx. 40 minutes / 25 minutes / 20 minutes
Substrate temperature	minimum 10°C up to maximum 40°C

**Clean up machine:**

To clean and flush the spray equipment / machine we recommend to use **HEGSEL Coat 131 SOL** - cleaner with a temperature of approx. 30 - 40°C.

**Packaging:**

15 kg - pails (13.5 kg component A + 1.5 kg component B), other pails are available on request

**Colour:**

Light grey (other colours are available on request)

*- Due to raw material variations and manufacturing techniques, a slight colour / batch difference may occur -*

**Storage:**

12 months, unopened in original drums under dry conditions and a temperature of 15 - 25°C. At temperatures < 10°C crystallisation is possible. Please consult us.

## 1. Surface preparation

The steel surface that is to be coated must be dry and free of mill scale, debris, grease, fat, oil, dust, areas of corrosion / rust as well as other contaminants which may impair the adhesion (see DIN report 28 "corrosion protection for steel constructions by using coating systems – testing the surface regarding to invisible contaminants before application"). Welding beads must be removed, welding seams and welding overlaps must be smooth in accordance with DIN EN 14879-1. Surface preparation by blast cleaning (with tough grit) in accordance with DIN EN 12944-4 (ISO 8501-1/-2), preparation grade Sa 2½. Use only approved blasting abrasives with angular grain. Average roughness  $R_{Vs}$  ( $R_z$ )  $\geq$  50 microns respectively "middle (G)" in accordance with DIN EN ISO 8503-2 (ISO 8503-2). Prior to, during and after surface preparation, application and curing the substrate temperature must be minimum +3°C / 3K above the dew point (see dew point table). In case of doubt the surface cleanliness must be measured regarding soluble contaminants in accordance with EN ISO 8502-6 (Bresle method) and EN ISO 8502-9 prior to coating.

## 2. Preparation of material

### Airless spray resp. brush / roller

The temperature of the components must be at least 20°C. Stir the components thoroughly and mix in the correct ratio using a suitable low speed electric mixer (300 - 400 rpm) for at least 3 minutes or until a completely homogeneous mixture has been achieved. Put the mixed material into a clean container and mix again for at least 1 minute more.

## 3. Application method (use without thinner!)

### **Airless spray**

Efficient airless spray equipment  
Pressure ratio: minimum 1 : 68  
Spray hose: approx. 30 m  $\frac{3}{8}$ " + 2 m  $\frac{1}{4}$ "  
Inlet pressure: 6 - 8 bar  
Nozzle size: 0.43 - 0.48 mm  
Spraying angle: 40 - 70°  
Flow heater: 20 - 35°C

We recommend to remove the high pressure filters and to pump the material directly without a siphon tube.

### **Brush / roller**

Recommended for small areas, repairs or to precoat edges, only. Minor defects and faults can be repaired by hand using the same material. Prior to application the surface must be prepared by grinding or blasting PSa 2 ½ and cleaning. For minor repairs, use a brush and apply **HEGGEL Coat 131**.

**Attention!** To ensure a proper application at low temperatures a hose insulation and a flow heater have to be used.

**N/B:** At low temperatures it is necessary to use insulated hoses and a flow heater! Please use a plural component airless spray equipment, if a longer spray hose distance (> 30 m) and an independent application time / pot life is required.

## 4. Resistance

### **Mechanical**

- impact resistant
- high abrasion resistant

### **Thermal**

- dry heat max. +170°C
- wet heat: depending on the medium and thermal stress, please consult us

## Chemical

### Mineral oil, solvents

- crude oil, diesel / biodiesel, petrol / premium gasoline
- white spirit, toluene, xylene, ethylene glycol

### Salt solutions

- CaCl<sub>2</sub> (saturated), NaCl (saturated)
- KCl (saturated), FeCl<sub>3</sub> (42 %)

Due to the fact that the resistance of the coating can be affected by various factors (medium, temperature, concentration, layer thickness, etc.) we recommend to consult us prior to application.

## 5. Health and safety:

### **GISCODE: RE 1**

While **HEGGEL Coat 131** is a (nearly) solvent free coating, it is common practice when used as a tank lining or in enclosed areas to circulate the air during and after the application until the coating is cured. The ventilation system should be capable of preventing any solvent vapour concentration from reaching the lower explosion limit for any solvents that may be present. Avoid inhalation of the vapours. Wear suitable protective clothing, gloves, eye / face protection and suitable respiratory equipment. Adequate ventilation of the working areas is recommended. After contact with skin, wash immediately with plenty of water and soap. In case of contact with eyes, rinse immediately with plenty of water and seek medical advice. When using do not eat, drink, smoke and keep away from sources of ignition. For additional references to safety-hazard warnings, regulations regarding the transport and waste management please refer to the relevant Safety Data Sheet.

**HEGGEL Coat 131**; Revision No: 1.00 / 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.

**HEGGEL GmbH**

Huttropstr. 60  
45138 Essen  
Germany

Tel: +49 201 17003 270

Fax: +49 201 17003 277

E-Mail: [info@heggel.de](mailto:info@heggel.de)

Web: [www.heggel.de](http://www.heggel.de)