Hempel's HS Gas Pipe Coating 87831

Product characteristics

Description
Hempel's HS Gas Pipe Coating 87831 is a two-component epoxy polyamine cured coating. Formulated according to the requirements in AMERICAN PETROLEUM INSTITUTE'S STANDARD RP 5L2.

Recommended use
As a one-coat system for internal coating of gas pipes designed for carrying of dry, treated gas. The coating is designed to reduce the drag resistance in the pipeline by making the pipe walls smoother.

Product safety

Flash point 28°C [82°F]

VOC content mixed product

Legislation	Value
EU	159 g/L [1.33 lb/US gal]
US (coatings)	159 g/L [1.33 lb/US gal]
US (regulatory)	159 g/L [1.33 lb/US gal]
China	159 g/L [1.33 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website.

Handling
Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

Product data

Product code
87831

Product components
Base 87838
Curing agent 95830

Standard shade / code
Brownish red 50890 *

Gloss
Glossy

Volume solids
82 ± 2%

Specific gravity
1.4 kg/L [12 lb/US gal]

Reference dry film thickness
70 micron [2.8 mils]

Aluminium shade / code
Dark brown 67120 **

Gloss
Please consult Hempel's Guideline on aluminium pigmented coatings.

Volume solids
81 ± 2%

Specific gravity
1.4 kg/L [12 lb/US gal]

Reference dry film thickness
70 micron [2.8 mils]

* Epoxy coatings may discolour and chalk when exposed to UV light. This does not affect the performance of the coating.
** Appearance of the aluminium pigmented coats will depend on application method, drying conditions, handling etc. Please see the Guideline on Aluminium pigmented coatings at hempel.com or at your local Hempel website.

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Surface preparation

Cleanliness
- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.

New build:
- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

Maintenance and Repair
- According to Hempel's Specification.

Roughness
- Surface profile Fine (S) (ISO 8503-2).

Consult Hempel's separate Surface Preparation Guidelines for more details.

Application

Mixing ratio
Base 87838 : Curing agent 95830
(4 : 1 by volume)

Stir well before use.

Thinner
Hempel's Thinner 08450

Cleaner
Hempel's Thinner 08450

Pot life

Product temperature	20°C [68°F]	60°C [140°F]
Pot life	60 min	9 min

Application method

Tool	Application parameters
Dual feed spray	Nozzle pressure: 150 bar [2200 psi] Nozzle orifice: 0.017-0.027"

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

Film thickness

Specification range	Low	High	Recommended
Dry film thickness	70 micron [2.8 mils]	70 micron [2.8 mils]	70 micron [2.8 mils]
Wet film thickness	90 micron [3.5 mils]	90 micron [3.5 mils]	90 micron [3.5 mils]
Theoretical spreading rate	12 m²/L [490 sq ft/US gal]	12 m²/L [490 sq ft/US gal]	12 m²/L [490 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. For best performance, avoid excessive film thickness.

Application conditions
- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above 10°C [50°F] during application and curing.
- Material temperature should be maximum 60°C [140°F].
- The optimum temperature will depend on the intended DFT, the nozzle size and the spraying pressure.

Relative Humidity:
- Relative humidity must be in the range 30-85% during curing.
- Relative humidity must be in the range 30-85% during application.

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Drying and overcoating

Product compatibility
- Previous coat: None.
- Subsequent coat: None.

Drying time

Surface temperature		10°C [50°F]	20°C [68°F]	30°C [86°F]	40°C [104°F]
Hard dry	hours	10	4½	2	1

Determined for dry film thickness 80 micron [3.1 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Drying conditions
- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

Overcoating details
- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- The surface must be dry and clean prior to application.

Other remarks
- Epoxy coats have an inherent tendency of chalking in outdoor exposure. This does not affect the performance of the coating.
- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Storage

Shelf life

Ambient temperature	25°C [77°F]
Base	12 months
Curing agent	36 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Always check the best before date or expiry date on the label.

Storage conditions
- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.

Additional documents

Additional information is available at the Hempel website hempel.com or at your local Hempel website:

- Explanatory Notes explaining the fields in this Product Data Sheet.
- Surface Preparation Guidelines.
- Application Guidelines for different application methods.
- General Application Guidelines