Technical Data Sheet (TDS)

ARMEPOX ® 2K G DTM 244

DESCRIPTION:

A two-component, high-solids, modified amine-cured epoxy coating. It is used as a standalone coating for long-term protection of the interior surfaces of steel and concrete tanks exposed to continuous immersion. It offers high chemical resistance to crude oil, petroleum products, bottom and seawater, and liquid media in the pH range of 4 to 11.

STANDARD USE:

Designed for corrosion protection of tanks, process sumps, pipelines, and other tank equipment. Recommended for use in new construction and maintenance of oil and gas facilities, the chemical industry, and hydraulic structures.

TECHNICAL SPECIFICATIONS:

Color	gray, beige
Dry residue by volume	80±2%
Gloss level	semi-gloss
Density	1.4 g/cm^3
Theoretical consumption (excluding losses) at TSP 100 μm	170 g/m^2
Drying time to degree 3 (GOST 19007) at a temperature of (20±0.5) °C	8 hours, no more
Pot=life after mixing at a temperature of (20±0.5) °C	6 hours, no less
Thickness of one layer (recommended)	125-200 microns
Viscosity	thixotropic
Adhesion Cross-cut method (GOST 15140) Pull-off method (GOST 32299)	 1 point, no more than 4 MPa, no

APPLICATION METHOD

Airless spraying (ALS)
Recommended thinner: Thinner EP 7, EP 8 up to 10% by weight
Nozzle diameter 0.015" - 0.021" (0.38 - 0.53 mm)
The pressure at the nozzle is not less than 17 MPa (170 bar)
Note: BVR application data may vary depending on equipment configuration.

Air spraying
Recommended thinner: Thinner EP 7, EP 8 Amount
of thinner up to 10% by weight Nozzle diameter
1.8 - 2.5 mm
Pressure 0.3 - 0.4 MPa (3 - 4 bar)

Brush/roller
Recommended thinner: Thinner EP 7, EP 8 up to 10% by weight. Brush application is recommended for stripe coating only. Roller application is not permitted for the first coat.

MIXING PROPORTIONS

Mixing proportions		By weight (g)	By volume (ml)
Component A	2K G DTM 244	100	100
Hardener	Hardener EP 7	20	30

Thinner EP 7, EP 8

SURFACE PREPARATION

Carbon steel

Surface preparation shall be carried out in accordance with GOST 9.402:
-first degree of degreasing
- abrasive blast cleaning to grade 2 according to GOST 9.402
Sa 2½ (ISO 8501-1). Surface profile 60-100 µm.
The treatment of welds, edges and the surface as a whole shall comply with preparation grade P2 (ISO 8501-3).
When performing touch-up painting and local repairs, mechanical or manual cleaning is permitted. Surface preparation must be at least St3 (ISO 8501-1). Ensure the surface is rough. Oil and grease contaminants are not permitted. Surface preparation directly impacts the durability and performance characteristics of the resulting coating.

Primed surface or old coating without traces of corrosion

Thoroughly remove oil and grease stains using an appropriate detergent. Remove salts and other contaminants.
Check the compatibility of the old coating with ARMEPOX® 2K G DTM 244. Roughen the surface if necessary. Remove dust.

APPLICATION CONDITIONS

The coating should be applied only to a dry and clean surface. The surface temperature must be 3°C above the dew point. The minimum application temperature is +10°C. The maximum humidity is 85%.
The material temperature must be at least 15°C. Lower temperatures will increase viscosity, which may require additional thinner, resulting in slower drying and increased risk of drips.
In enclosed spaces, adequate ventilation must be provided during application and drying of the coating.

SHELF LIFE

24 months in unopened original packaging.

SAFETY MEASURES

Contains organic solvents. Perform painting work with local and
Use general ventilation. Wear rubber gloves to protect your hands and personal protective equipment to protect your respiratory system. Store the material in a tightly closed container. Keep away from sources of ignition, heat, sparks, open flames, and static electricity. Do not smoke nearby. Use explosion-proof equipment, lighting, and spark-proof tools. Extinguish with water spray or air-powered foam and powders. In case of skin contact, wash the contaminated area with soap and water, dry, and apply a rich cream.

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