

COROGARD 615 EP Surface Tolerant Epoxy Coating/Primer for Steel

PRODUCT DESCRIPTION

COROGARD 615 EP is a two component, flake filled, surface tolerant epoxy coating system. It is cured with a modified polyamidoamine. The system is designed for use as single coat protection over rusted steel, galvanized metal surfaces and tightly adhered existing coatings.

COROGARD 615 EP is often used as a surface tolerant primer under compatible epoxy and epoxy novolac topcoats from RCC Corrosion Control's COROFLAKE and COROGARD product ranges.

COATING LAYERS COMPOSITION

COROGARD 615 EP is normally applied in one coat at 6-8 mils (150-200 µm) DFT by spray, roller or brush. Depending on actual service conditions and/or project specification requirements, **COROGARD 615 EP** can be over-coated with itself or other compatible topcoat product layer designs. Consult RCC Corrosion Control for specific recommendations.

FIELDS OF APPLICATION

COROGARD 615 EP is ideal for application on metal surfaces where abrasive blast cleaning is either prohibited, undesirable or not practical to carry out. It is designed for application over steel with aged coatings, bare or rusted steel, and existing galvanized surfaces. Typical applications include tank exteriors, structural steel, piping, offshore platforms, waste water treatment plants and floating roofs of crude oil tanks.

Note: **COROGARD 615 EP** is **not recommended** for application over chlorinated rubber and vinyl coatings.

FEATURES

- Surface Tolerant
- Adheres well to existing, well bonded coatings
- Can be applied direct to rusted steel
- Can be applied direct to galvanized metal
- Easy to apply (spray, roll, brush)
- Good chemical resistance
- Provides economical protection

CHEMICAL RESISTANCE

Information on the chemical resistance properties is available upon request.

SURFACE PRE-TREATMENT

Steel Surfaces

Oil, grease and other contaminants must be removed

from the surface before coating. Remove loose rust by wire brushing or other acceptable method. Surfaces should be cleaned to SSPC SP 2 or 3 standards.

Existing Coatings

Oil, grease and other contaminants must be removed prior to coating. For existing, tightly adhered coatings the surface should be roughened by mechanically abrading or sanding prior to application of the coating.

APPLICATION

- The coating should be applied to clean, dry and properly prepared surfaces
- **COROGARD 615 EP** can be applied by airless or conventional air spray, brush or roller at approximately 8-10 mils (200-250 µm) WFT per coat to achieve 6-8 mils (150-200 µm) DFT.

Note: During application the coated surface should be shaded from direct or indirect sunlight whenever possible.

In atmospheric exposure **COROGARD 615 EP** has a tendency to chalking with time.

MIX RATIO

COROGARD 615 EP Resin and **Hardener** has a mix ratio of 1:1 by volume.

CONSUMPTION

Layer	Thickness mils (µm) DFT	Coverage
COROGARD 615 EP	6-8 (150-200)	150-200 ft ² /gal

WORKING TIME & RECOAT TIME

Temperature	Working Time	Min Recoat	Max Recoat
50°F (10°C)	8 hrs	30 hrs	14 days
70°F (21°C)	5 hrs	12 hrs	14 days
90°F (32°C)	4 hrs	6 hrs	7 days

CURE TIME (to place in service)

Temperature	Initial Cure	Final Cure
50°F (10°C)	36 hrs	7 days
70°F (20°C)	16 hrs	3 days
90°F (30°C)	12 hrs	2 days

Generally **COROGARD 615 EP** can be placed in service after the final cure time intervals have been achieved. Shorter or longer intervals may apply depending on service conditions. Consult RCC Corrosion Control for specific recommendations.

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CLEANING: Cleaning Agent T-100

SAFETY MEASURES

The material safety data sheets of the individual components as well as the legal requirements for handling hazardous materials must be observed.

PACKING UNITS

The products are supplied in the following standard package sizes:

Description	Package Size
COROGARD 615 EP	2 gal kits

STORAGE

The materials must be stored in a cool and dry place. At storage temperature of 70°F (21°C) the shelf life is as follows:

COROGARD 615 EP Resin 24 months
COROGARD 615 EP Hardener 24 months

If the storage time is exceeded, the materials must be tested before use. Higher storage and transport temperatures will reduce the shelf life. The containers must be kept tightly closed. Liquid products must be stored frost-proof.

Technical Data	Testing Standard	Unit	Value
Generic Type			Epoxy
Solids Content (By Volume)		%	86
Density	ASTM D1475	lbs/gal kg/l	10.54±0.25 1.27
Viscosity - mixed	ASTM D2393	cps mPa·s	2700 ± 250
Modulus of Elasticity (Bend Test)	ASTM D790	Psi MPa	435 K – 500 K 3000 – 3500
Abrasion Resistance	ASTM D 4060	mg	100
Volatile Organic Compounds	EPA Method 24	g/L lbs/gal	94 0.78
Maximum Operating Temperature* Immersion / Condensing Fumes Continuous Dry		°F °C °F °C	120 49 250 121

*Maximum operating temperature limits may vary depending on actual service conditions

We warrant that our goods will conform to the description contained in the order and that we have good title to all goods sold. This Product Data Sheet is considered accurate and reliable to the best of our knowledge at the date of its publication, but are used as guides only. The user assumes all risks and liabilities in connection therewith regardless of any suggestion, we may give. We assume no liability for performance of the product or for any loss or damage resulting from its use. Our liability, in law and equity, shall be expressly limited to the replacement of non-conforming goods at our factory, or at our sole discretion, to repayment of the purchase price of the non-conforming goods.

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