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PRODUCT DATA SHEET

SP-9800

DESCRIPTION: **SP-9800** is a two component ambient cure epoxy Gas Transmission Pipe Flow Efficiency coating. **SP-9800** meets the requirements of API Specification RP 5L2.

ADVANTAGES:

- 100% Solids – No VOCs.
- Good flexibility.
- Excellent water resistance.
- Excellent anti-corrosion protection during storage life.

USES:

- Coating for Internal Gas Transmission Pipelines to improve gas flow and corrosion protection.

APPLICATION:

- Graco Hydra-Cat Airless Spray, tip size .015-.021 and/or Spinning Head.
- Application method and equipment may vary from plant to plant; contact an SPC Technical Representative for assistance.

CLEANING MATERIALS: SP-100 Equipment Wash

SURFACE PREPARATION:

(Steel Substrate)

- The degree of surface preparation will affect the performance of the coating. Prior to application of the coating, ensure that the steel surface is free of oil, grease, and any other surface contaminants.
- Abrasive blast cleaning is the preferred method.
- **Cleanliness** : Near White
- **Standards** : NACE 2, Sa 2½ (Swedish Scale, ISO 8501-1)
: SSPC SP-10 (Steel Structures Painting Council)
- **Profile** : 25 microns minimum to 50 microns maximum.
(1.0 mils to 2.0 mils)



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MIXING RATIO: By Volume: 2 Parts Base to 1 Part Hardener.

RECOMMENDED DRY FILM THICKNESS: 75 microns minimum to 125 microns maximum.
(3.0 mils to 5.0 mils.)

HANDLING PROPERTIES:

Pot Life [100 gm (3.5 oz) mass @ 25°C (77°F) Ambient Temperature] 45 minutes

Dry Time (ASTM D1640) [25°C (77°F) Ambient Temperature]

Touch Dry Time 2 Hours

Hard Dry Time..... 7 Hours

Substrate Temperature..... The acceptable substrate (metal surface) temperature range for the application of **SP-9800** is 10°C (50°F) – 50°C (122°F). The substrate temperature must be a minimum of 3°C (5°F) above the dew point temperature before proceeding with the coating operation.

Storage Shelf Life..... Store in a cool, dry, well-ventilated area at temperatures between 5°C (41°F) and 40°C (104°F). Keep the lids sealed. The Shelf Life is a maximum of 24 months in unopened containers.

LIQUID PROPERTIES:

BASE

ACTIVATOR

Appearance	Red Liquid	Beige Liquid
Solids Content (%)	100	100
Specific Gravity (ASTM D1475)	1.55 ± 0.03	1.30 ± 0.03
Specific Gravity (ASTM D1475)	Base & Activator Mixed: 1.47 ± 0.03	
Coverage (Theoretical)	39.0 m ² /Litre/25 microns [1604 ft ² /U.S. Gallon/mil]	



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Performance of SP-9800 as per API RP 5L2 Specification			
Test	Criterion	Test Method	Results
Salt Spray	500 Hrs.	ASTM B117	Pass
Water Immersion	No blistering over 6.3 mm (0.25 in.) from edges.	Saturated CaCO ₃ solution, RT, 21 days	Pass
W/M Immersion	No blistering over 6.3 mm (0.25 in.) from edges.	1:1 by volume, water and methanol, RT, 5 days	Pass
Stripping	Coating should not be removed.	60 degree cut	Pass
Bend	13 mm (0.50 in.) diameter & larger, the panel shall show no flaking, loss of adhesion or cracking of the coating.	180° around conical or cylindrical mandrel. ASTM D522	Pass
Adhesion	No lifting.	225 squares, 1.6 mm (0.06 in.) side length	Pass
Hardness	> 94 Buchholz ~ H pencil hardness.	DIN 53 153	Pass
Gas Blistering	No blistering.	Dry nitrogen gas, 1200 PSI, 25°C (77°F). 24 Hrs., release >5 seconds	Pass
Abrasion	> 23 Coefficient of Abrasion.	ASTM D968, Method A	Pass
Hydraulic Blistering	No blistering.	Saturated CaCO ₃ solution, 2400 PSI, 25°C (77°F) 24 Hrs., quick pressure release	Pass



PRODUCT DATA SHEET

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Performance of SP-9800 After Post Heating to 260°C (500°F) As per API RP 5L2 Specification			
Test	Criterion	Test Method	Results
Salt Spray	500 Hrs.	ASTM B117	Pass
Water Immersion	No blistering over 6.3 mm (0.25 in.) from edges.	Saturated CaCO ₃ solution, RT, 21 days	Pass (No Blistering)
W/M Immersion	No blistering over 6.3 mm (0.25 in.) from edges.	1:1 by volume, water and methanol, RT, 5 days	Pass (No Blistering)
Stripping	Coating should not be removed.	60 degree cut	Pass
Bend	13 mm (0.50 in.) diameter & larger, the panel shall show no flaking, loss of adhesion or cracking of the coating.	180° around conical or Cylindrical mandrel. ASTM D522	Pass
Adhesion	No lifting.	225 squares, 1.6 mm (0.06 in.) side length	Pass
Hardness	> 94 Buchholz ~ H pencil hardness.	DIN 53 153	Pass (Pencil Hardness H-2H)
Gas Blistering	No blistering.	Dry nitrogen gas, 1200 PSI, 25°C (77°F). 24 Hrs., Release >5 seconds	Pass
Abrasion	> 23 Coefficient of Abrasion.	ASTM D968, Method A	Pass (A=38.5)
Hydraulic Blistering	No blistering.	Saturated CaCO ₃ solution, 2400 PSI, 25°C (77°F) 24 Hrs., quick pressure release	Pass

SAFETY: Read the Material Safety Data Sheets before use.

EFFECTIVE DATE: August 5, 2011