

High Build Bituminous Black Pipe Coating High Gloss Product Data Sheet

Features

A black bituminous based coating for good protection of steel pipe, tanks, flanges, bolts and other bare metal structures where a higher mil coverage is specified. This bituminous coating is effective for both indoor and outdoor storage. This can be applied to new and reconditioned pipe.

Typical Uses

Excellent exterior durability and adhesion over most steel surfaces. This can be used above and below grade.

Physical Data

Pencil Hardness (ambient cure)	Soft to 4B	Theoretical weight solids	60%±2%
Adhesion (ASTM D 4541)	300 psi	Theoretical volume solids of mixed material	46%±2%
Temperature resistance (non-immersion)		Theoretical coverage of mixed gallon (1 mil)	738 sq. ft.
Continuous	250°F	Volatile Organic Content	
Non-continuous	300°F	Unthinned ready to apply	3.63 lbs./gal.

Resistance

DD-45 is designed for exposures to mild chemical fumes under typical atmospheric conditions.

<u>Exposure</u>	<u>Immersion</u>	<u>Splash & Spillage</u>	<u>Fumes</u>
Acidic	Not recommended	Poor	Fair
Alkaline	Not recommended	Poor	Fair
Solvents	Not recommended	fair	Good
Salt water	Not recommended	Good	Excellent
Water	Not recommended	Good	Excellent

Film Thickness (per coat)

Dry film thickness: 2.0 to 4.0 mils
Wet film thickness: 4.0 to 7.0 mils
Theoretical coverage: 738 sq. ft. @ 1 mils DFT

Primer/Substrates

DD-45 Coating may be applied directly to properly prepared steel substrates, weathered galvanized steel and concrete surfaces. All surfaces should be free of oil or dirt.

Colors

Standard Black High Gloss Sheen

Shipping Data

Packaging unit	55 gal.	5 gal.	Flash Point: (Setaflash)	> 100 °F
Shipping weight (approx.)			Shelf Life: 3 years when stored inside at 40°F to 110°F.	
Package unit	445 lbs.	46 lbs.	DOT Classification: UN1263, PAINT, 3, PG II	

Surface Preparation

DD-45 Pipe Coating is designed to be used over surfaces that have been prepared in accordance with SSPC-SP2 Hand Tool Clean specification. In many cases High Pressured Water Blast will suffice.

Mixing

Mix DD-45 Coating well prior to application.

Thinning

Thinning is not required for most applications; however DD-45 may be thinned with up to 1 pint/gal. CC-86 is recommended for applications. For VOC control thin only with thinner #4.

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Applications Conditions

	<u>Material</u>	<u>Surface</u>	<u>Ambient</u>
Minimum	40°F	40°F	40°
Maximum	120°F	120°F	120°F

Special thinning and application procedures are required outside these temperatures. Surface temperatures should be 5°F above dew point to prevent condensation.

Application Equipment

Conventional Spray: Industrial sprayers such as DeVilbiss MBC or JGA and Binks 18 or 62 having double regulated pressure pot, 3/8" I.D. minimum material hose and a .070" I.D. fluid tip and air cap are recommended.

Airless Spray: Sprayer such as Graco's Bulldog with a 30:1 ratio and a .035" to .080" tip is recommended. A 30 mesh inline filter is recommended.

Brush: Use medium brush; Roller: Application by roller is not recommended.

Drying Time

The following minimum times are based on 1.5 mils DFT and adequate air ventilation. Higher thickness and reduced air circulation increase drying times.

Surface

<u>Temperature</u>	<u>To Touch</u>	<u>To Handle</u>	<u>To Recoat</u>
77°F	7-10 min.	20 min.	Overnight
Less at higher temperatures			

Maximum Recoat

DD-45 Pipe Coating can be recoated with itself at any time by simply removing dirt and contamination of the existing coat.

Cleanup

Cleanup spill spatters and equipment using mineral spirits. Lacquer thinner or Thinner #4 for VOC control.

02/18/13

CAUTION: Read and follow all caution statements on this product data sheet and on the Material Safety Data Sheet for this product.

CONTAINS FLAMMABLE MATERIALS.

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