

# Product Data Sheet

## PHOEPOX® 3305

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January 2017



### Phoepox® 3305

is a fusion bonded epoxy powder that is designed as both a stand-alone FBE or as the first layer in a multi-layer FBE anti-corrosion pipe coating system. Phoepox® 3305 is suitable for standard service temperatures. Phoepox® 3305 can also be used as a primer in multi-layer polyolefin systems in thicknesses ranging from 100 to 300 microns.

			Typical Value	Test Method / Device
<b>POWDER PROPERTIES</b>	<b>GEL TIME</b>	at 180°C	35-55 seconds	ISO 8130-6
		at 200°C	20-30 seconds	ISO 8130-6
	<b>THERMAL PROPERTY</b>	Tg1	60 ± 5°C	ISO 21809-1
		Tg2	103 ± 5°C	ISO 21809-1
		ΔH	40-80 J/g	ISO 21809-1
	<b>DENSITY</b>		1.5 ± 0.1 g/cm <sup>3</sup>	Gas Pycnometer
	<b>PARTICLE SIZE</b>		99.8% < 250 μm	Laser Scattering
	<b>MOISTURE CONTENT</b>		≤ 0.5%	CSA Z245.20-06
	<b>COLOR</b>		Grey	
	<b>PHYSICAL TESTS</b>	<b>CATHODIC DISBONDING *</b>	1-3 mm at -3.5 VDC, 65°C, 24 hours	
3-5 mm at -1.5 VDC, 20°C, 28 days				
<b>ADHESION *</b>		Rating 1 at 75°C, 24 hours		CSA Z245.20-06
<b>FLEXIBILITY *</b>		Pass, at 3°, -30°C		CSA Z245.20-06
<b>WATER RESISTANCE</b>		No blistering at 38°C, 15 weeks No blistering at 90°C, 5 weeks		ASTM D870



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<b>3LP CATHODIC DISBONDING *</b>	2-3 mm at -1.5 VDC, 20°C, 28 days 3-5 mm at -1.5 VDC, 80°C, 28 days	ISO 21809-1
<b>STORAGE STABILITY</b>	12 months from production date in ≤ 23°C and ≤ 65% relative humidity. Cooler temperatures and lower humidity are recommended.	

\* The performance will be affected by surface preparation and curing condition.

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### APPLICATION DATA

<b>SURFACE PREPARATION</b>	Surface must be free from contamination and blasted as defined by Swedish Sa 2½
<b>SURFACE ROUGHNESS</b>	50-100 µm
<b>RECOMMENDED FILM THICKNESS</b>	300-500 µm
<b>APPLICATION TEMPERATURE</b>	215-240°C