

Product Data Sheet

PHOEPOX® 4460

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Phoepox® 4460

is a fusion-bonded epoxy powder that is used for the internal coating of pipes and fittings that require a combination of corrosion-resistance and abrasion-resistance such as sewage lines and certain types of slurry lines.

Phoepox 4460® can be used as a stand-alone internal layer or as an overcoat of other internal powder coatings such as Phoepox® 4402 or Phoepox®4450.”

			Typical Value	Test Method / Device
POWDER PROPERTIES	GEL TIME	at 200°C	45-75 sec	ISO 8130-6
	THERMAL PROPERTY	Tg1	60 ± 5°C	ISO 21809-2
		Tg2	104 ± 5°C	
		ΔH	40-80 J/g	
	DENSITY		1.55 ± 0.1 g/cm ³	Gas Pycnometer
	PARTICLE SIZE		99.8% < 250 μm	Laser Scattering
	MOISTURE CONTENT		≤ 0.5%	CSA Z245.20-06
COLOR		Green, Red-Brown		
PHYSICAL TESTS	CATHODIC DISBONDING on Phoepox 4402	1-3 mm at -3.5VDC, 65°C, 24 hours 2-5 mm at -1.5VDC, 20°C, 28 days		CSA Z245.20-06
	ADHESION*	Rating 1 at 75°C, 24 hours		CSA Z245.20-06
	FLEXIBILITY*	Pass, at 3°, -30°C		CSA Z245.20-06
	WATER RESISTANCE	No blistering at 38°C, 15 weeks No blistering at 90°C, 5 weeks		ASTM D870
	Gouge test	Pass		R33 TC Burr, 50kg load
	STORAGE STABILITY	12 months from production date in ≤ 23°C and ≤ 65% relative humidity. Cooler temperatures and lower humidity are recommended		



◀ corrosion protection that stays.

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APPLICATION DATA	SUBSTRATE	Mild steel
	SURFACE PREPARATION	Surface must be free from contamination and blasted as defined by Swedish Sa 2½
	SURFACE ROUGHNESS	45-100 µm
	RECOMMENDED FILM THICKNESS	300-800 µm
	APPLICATION TEMPERATURE	190-240°C

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