

Product Data Sheet

PHOEPOX® 6114

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February 2019



Phoepox® 6114

is a fusion bonded epoxy powder that is designed as both a stand-alone FBE or as the first layer in a multi-layer anti corrosion pipe coating system. Phoepox® 6114 is suitable for operating temperatures up to 140°C.

			Typical Value	Test Method / Device
POWDER PROPERTIES	GEL TIME	at 180°C	37-50 seconds	ISO 8130-6
		at 200°C	20-30 seconds	ISO 8130-6
	THERMAL PROPERTY	Tg1	50 ± 5°C	ISO 21809-1
		Tg2	150 ± 5°C	ISO 21809-1
		ΔH	110-160 J/g	ISO 21809-1
	DENSITY		1.4 ± 0.05 g/cm ³	Gas Pycnometer
	PARTICLE SIZE		99.8% < 250 μm	Laser Scattering
MOISTURE CONTENT		≤ 0.5%	CSA Z245.20-06	
COLOR		Yellow or Blue		
PHYSICAL TESTS	CATHODIC DISBONDING *	2-4 mm at -3.5 VDC, 65°C, 24 hours		CSA Z245.20-06
		3-5 mm at -1.5 VDC, 20°C, 28 days		
	ADHESION*	Rating 1 or 2 at 75°C, 24 hours		CSA Z245.20-06
FLEXIBILITY*	Pass, at 3° PPD, -30°C		CSA Z245.20-06	



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CROSS SECTION POROSITY	Rating 1-2	CSA Z245.20-06
INTERFACE POROSITY	Rating 2	CSA Z245.20-06
STORAGE STABILITY	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.

APPLICATION DATA

SUBSTRATE	Mild steel
SURFACE PREPARATION	Surface must be free from contamination and blasted as defined by swedish Sa 2½
SURFACE ROUGHNESS	50-100 µm
RECOMMENDED FILM THICKNESS	300-500 µm
APPLICATION TEMPERATURE	230-245°C
TIME TO QUENCH	≥ 80 second at 230°C metal temperature