

# Product Data Sheet

## PHOEPOX® 3315

1/2

November 2015



### Phoepox® 3315

is a high performance fusion bonded epoxy (FBE) powder that can be applied as a stand-alone coating or as a primer in a multi-layer FBE anti-corrosion pipe coating system. Phoepox 3315 is suitable for standard service temperatures. Phoepox 3315 can be applied in thicknesses ranging from 60 microns to 250 microns.

			Typical Value	Test Method / Device
<b>POWDER PROPERTIES</b>	<b>GEL TIME</b>	at 180°C	65-80 sec	ISO 8130-6
		at 200°C	35-45 sec	ISO 8130-6
	<b>THERMAL PROPERTY</b>	Tg1	60± 5°C	ISO 21809-2
		Tg2	103± 5°C	
		ΔH	40-80 J/g	
	<b>DENSITY</b>		1.4 ± 0.05 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>	1-2.5 mm at -3.5VDC, 65°C, 24 hours		CSA Z245.20-06
		2-4 mm at -1.5VDC, 20°C, 28 days		
	<b>ADHESION</b>	Rating 1 at 75°C, 24 hours		CSA Z245.20-06
	<b>FLEXIBILITY</b>	Pass, at 3°C, -30°C		CSA Z245.20-06
	<b>WATER RESISTANCE</b>	No blistering at 38°C, 15 weeks		ASTM D870
No blistering at 90°C, 5 weeks				
<b>3LP CATHODIC DISBONDING</b>	1-2.5 mm at -1.5VDC, 20°C, 28 days		ISO 21809-1	
	2-4 mm at -1.5VDC, 80°C, 28 days			



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2/2



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<b>ABRASION (TABER)</b>	≤ 50 mg	ASTM D4060, 1000g load, 1000 cycles, C10 wheels
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<b>STORAGE STABILITY</b>	12 months from production date in ≤ 23°C and ≤ 65% relative humidity. Cooler temperatures and lower humidity are recommended.
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### APPLICATION DATA

<b>SUBSTRATE</b>	Mild steel
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<b>SURFACE PREPARATION</b>	Surface must be free from contamination and blasted as defined by Swedish Sa 2½
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<b>SURFACE ROUGHNESS</b>	50-100 µm
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<b>RECOMMENDED FILM THICKNESS</b>	60-250 µm
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<b>APPLICATION TEMPERATURE</b>	215-240°C
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