

# Product Data Sheet

## PHOEPOX® 3305-XLG

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October 2016



### Phoepox® 3305-XLG

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

			Typical Value	Test Method / Device
<b>POWDER PROPERTIES</b>	<b>GEL TIME</b>	at 200°C	47-85 seconds	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>		1.5 ± 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 -3.5VDC, 65°C, 24 hours		CSA Z245.20-06
	<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		ASTM D870
	<b>3LP CATHODIC DISBONDING</b>	2-3 mm at -1.5VDC, 20°C, 28 days		ISO 21809-1
		3-5 mm at -1.5VDC, 80°C, 28 days		
<b>ABRASION (TABER)</b>	≤ 50 mg		ASTM D4060, 1000 g 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
<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