

Product Data Sheet

PHOEPOX® 4410

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August 2020



Phoepox® 4410

is a fusion bonded epoxy powder that is used for the internal corrosion protection of line pipes and fittings used for the transport of potable water. Phoepox® 4410 passes AWWA C213-015 and BS 6920 requirements.

			Typical Value	Test Method / Device
POWDER PROPERTIES	GEL TIME	at 200°C	140-250 seconds	ISO 8130-6
	THERMAL PROPERTY	Tg1	60 ± 5°C	ISO 21809-1
		Tg2	101 ± 5°C	ISO 21809-1
		ΔH	30-70 J/g	ISO 21809-1
	DENSITY		1.5 ± 0.1 g/cm ³	Gas Pycnometer
	PARTICLE SIZE		99.8% < 250 μm	Laser Scattering
	MOISTURE CONTENT		≤ 0.5%	CSA Z245.20-06
	COLOR		Red-Brown or Blue	
PHYSICAL TESTS	CATHODIC DISBONDING *	1-3 mm at 3.5 VDC, 65°C, 24 hours		CSA Z245.20-06
		3-5 mm at 1.5 VDC, 20°C, 28 days		
	HOT WATER SOAK*	Rating 1 at 95°C, 24 hours		AWWA C 213-07
	FLEXIBILITY	Pass		AWWA C 213-07
	WATER RESISTANCE*	No blistering at 50° C, 15 weeks		ASTM B117
	IMPACT	≥ 13 J		AWWA C 213-07
	ABRASION (TABER)	≤ 300 mg		ASTM D 1044 CS 17 Wheel 5000 hours and 1000 grams load
	ADHESION	≥ 21 MPa		AWWA C 213-07
PENETRATION	3%, at 60°C		AWWA C 213-07	



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STORAGE STABILITY 12 months from production date in $\leq 23^{\circ}\text{C}$ and $\leq 65\%$ 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	45-100 μm
RECOMMENDED FILM THICKNESS	300-500 μm
APPLICATION TEMPERATURE	190-230°C
POST CURE CONDITIONS	$\Delta T_g \leq 2$