Product Data Sheet
PHOEPOX® 3314 XLG

Maj 2021

Phoepox® 3314 XLG
is a high performance 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. Phoepox® 3314 XLG possesses enhanced corrosion protection properties. Phoepox® 3314 XLG is suitable for standard service temperatures. Phoepox® 3314 XLG can also be used as a primer in multi-layer polyolefin systems.

			Typical Value	Test Method / Device
POWDER PROPERTIES	**GEL TIME**	at 200°C	45-85 seconds	ISO 8130-6
	THERMAL PROPERTY	Tg1	60 ± 5°C	ISO 21809-2
		Tg2	101 ± 5°C	
		ΔH	40-80 J/g	
	DENSITY		1.5 ± 0.1 g/cm^3	Gas Pycnometer
	PARTICLE SIZE		99.8% < 250 µm	Laser Scattering
	MOISTURE CONTENT		≤ 0.5%	CSA Z245.20-14
	COLOR		Grey	
PHYSICAL TESTS	**CATHODIC DISBONDING ***	1-3 mm at -3.5 VDC, 65°C, 24 hours 2-4 mm at -1.5 VDC, 20°C, 28 days 3-4 mm at -1.5 VDC, 65°C, 28 days		CSA Z245.20-14
	ADHESION *	Rating 1 at 75°C, 24 hours		CSA Z245.20-14
	FLEXIBILITY *	Pass, at 3°, -30°C		CSA Z245.20-14
	WATER RESISTANCE	No blistering at 38°C, 15 weeks No blistering at 90°C, 5 weeks		ASTM D870

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	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	**SURFACE PREPARATION**	Surface must be free from contamination
	SURFACE ROUGHNESS	50-100 µm
	RECOMMENDED FILM THICKNESS	200-400 µm
	APPLICATION TEMPERATURE	215-240°C
	TIME TO QUENCH	≥ 125 sec at 225°C metal temperature

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