

Product Data Sheet

PHOEPOX® 4450

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November 2017



Phoepox® 4450

is a fusion bonded epoxy-modified powder that is designed for the internal lining of line pipe, tubings and fittings. This grade can withstand severe conditions (sour crude, sour gas and brine water). Phoepox® 4450 is suitable for operating temperatures up to 85°C.

			Typical Value	Test Method / Device	
POWDER PROPERTIES	GEL TIME	at 200°C	80-180 seconds	ISO 8130-6	
	THERMAL PROPERTY	Tg1		60 ± 5°C	ISO 21809-1
		Tg2		102 ± 5°C	ISO 21809-1
		ΔH		30-70 J/g	ISO 21809-1
	DENSITY			1.55 ± 0.1 g/cm ³	Gas Pycnometer
	PARTICLE SIZE			99.8% < 250 μm	Laser Scattering
	MOISTURE CONTENT			≤ 0.5%	CSA Z245.20-06
COLOR			Grey		
PHYSICAL TESTS	ADHESION*		Rating 1 at 75°C, 24 hours	CSA Z245.20-06	
	FLEXIBILITY*		Pass, at 2°PPD, -30°C	CSA Z245.20-06	
	IMPACT		≥ 3 J at -30°C	CSA Z245.20-06	



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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

SURFACE PREPARATION Surface must be free from contamination and blasted as defined by swedish Sa 2½

SURFACE ROUGHNESS 50-100 μm

RECOMMENDED FILM THICKNESS 250-600 μm

APPLICATION TEMPERATURE 150-240°C

POST CURE CONDITIONS $\Delta T_g \leq 2$