

# Product Data Sheet

## PHOEPLAST® 2325

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### Phoeplast®2325

is a bimodal, black, high density polyethylene to be used as a top layer in the coating of steel pipes. Phoeplast 2325 contains high quality carbon black that ensures excellent weathering resistant.

Phoeplast 2325 shows excellent resistance to environmental stress cracking (ESCR), superior performance in high and low temperature, and excellent impact properties.

Phoeplast 2325 fulfills the following standards:

ISO 21809-1, DIN 30670, CSA-Z245.21-06 and NFA 49710.

		Typical Value	Unit	Test method
TYPICAL	MFR@190°C, 2.16 KG	0.40-0.47	gr/10min	ISO 1133
	DENSITY of base resin	0.940-0.95	gr/cm <sup>3</sup>	
PROPERTIES	DENSITY of compound	0.950-0.955	gr/cm <sup>3</sup>	ISO 1183
	VICAT SOFTENING POINT	120	°C	ISO 306
	TENSILE STRENGTH @ YIELD	27	MPa	ISO 527-2
	ELONGATION @ BREAK	700	%	ISO 527-2
	Tear Strength	≥ 18.5	MPa	ISO 527
	OIT 210°C	≥ 30	Minute	ISO 11357
	HARDNESS SHORE D	60	-	ISO 868
	MELTING POINT (DSC)	130	°C	ISO 3146
	CARBON BLACK CONTENT	2-2.5	%	ISO 6964
	BRITTLINESS TEMPERATURE	-80°C	°C	ASTM D746
	WATER ABSORPTION	<0.01	%	ISO 15512
	ESCR	5000	Hour	ASTM D1693-A
	DIELECTRIC STRENGTH	>30	kV/mm	IEC 243
	VOLUME RESISTIVITY	10 <sup>16</sup>	Ω cm	IEC 93
INDENTATION RESISTANCE	0.05 at 23°C	mm	DIN 30670	
UV RESISTANCE	≤ 35	%	DIN 30670	



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	<b>CARBON BLACK DISPERSION</b>	Grade 2	-	ISO 18553
	<b>THERMAL AGING AT 100 °C FOR 200 DAYS</b>	$\Delta$ MFR $\leq$ 35	%	DIN 30670
	<b>WATER CONTENT</b>	$\leq$ 0.01	%	ISO 15512
<b>TYPICAL PROPERTIES</b> Of coated pipe with FBE:  PHOEPOX® 3314LG, Adhesive: PHOEPLAST® 2600 Polyethylene: PHOEPLAST® 2325	<b>IMPACT RESISTANCE AT 23°C</b>	7	J/mm	DIN 30670
	<b>IMPACT RESISTANCE AT -40°C</b>			
	<b>PEEL STRENGTH AT 23°C</b>	170		DIN 30670
	<b>PEEL STRENGTH AT 50°C</b>	150	N/cm	
	<b>PEEL STRENGTH AT 70°C</b>	120		
	<b>PEEL STRENGTH AFTER IMMERSION AT 95°C</b>	150	N/cm	ISO 21809-1
	<b>SPECIFIC COATING RESISTANCE AT 23°C AND 80°C</b>	$10^8$	Ohm.m <sup>2</sup>	DIN 30670
	<b>SPECIFIC COATING RESISTANCE RATIO</b>	0.8	---	DIN 30670
	<b>NOTCHED IMPACT STRENGTH</b>	3	J/m <sup>2</sup> K	ISO 179

### PROCESSING PARAMETERS

Preheating and drying prior to extrusion is highly recommended and the extrusion temperature should be according to following data:

<b>PREHEATING TEMPERATURE (MAX.)</b>	90°C
<b>MELT TEMPERATURE</b>	220-250°C

### STORAGE

Phoeplast®2325 should be stored in dry condition and temperature of below 60°C and protect from Sun light.



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