

Product Data Sheet

PHOEPOX® 4430

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September 2023



Phoepox® 4430

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 condition. Phoepox® 4430 is suitable for operating temperatures up to 140°C.

			Typical Value	Test Method / Device	
POWDER PROPERTIES	GEL TIME	at 200°C	80-140 sec	ISO 8130-6	
	THERMAL PROPERTY	Tg1		60 ± 5°C	ISO 21809-1
		Tg2		143 ± 5°C	ISO 21809-1
		ΔH		110-160 J/g	ISO 21809-1
	DENSITY			1.4 ± 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 95°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	
	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.



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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	$\Delta T_g \leq 2$