

Product Data Sheet

PHOEPOX® 3305-LG

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January 2017



Phoepox® 3305-LG

is a 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® 3305-LG is suitable for standard service temperatures.

Phoepox® 3305-LG can also be used as a primer in multi-layer polyolefin systems in thicknesses ranging from of 100 to 300 microns.

			Typical Value	Test Method / Device	
POWDER PROPERTIES	GEL TIME	at 180°C	65-80 seconds	ISO 8130-6	
		at 200°C	35-45 seconds	ISO 8130-6	
	THERMAL PROPERTY	Tg1		60 ± 5°C	
		Tg2		103 ± 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 Z245.20-06
	COLOR			Grey	
	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					
ADHESION *			Rating 1 at 75°C, 24 hours		CSA Z245.20-06
FLEXIBILITY *			Pass, at 3°, -30°C		CSA Z245.20-06
WATER RESISTANCE		No blistering at 38°C, 15 weeks No blistering at 90°C, 5 weeks		ASTM D870	



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3LP CATHODIC DISBONDING *	2-3 mm at -1.5 VDC, 20°C, 28 days 3-5 mm at -1.5 VDC, 80°C, 28 days	ISO 21809-1
ABRASION (TABER)	≤ 50 mg	ASTM D4060, 1000 g load, 1000 cycles, C10 wheels
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

SUBSTRATE	Mild steel
SURFACE PREPARATION	Surface must be free from contamination and blasted as defined by Swedish Sa 2½
SURFACE ROUGHNESS	50-100 µm
RECOMMENDED FILM THICKNESS	300-500 µm
APPLICATION TEMPERATURE	215-240°C