

## Hot Spread Epoxy

### PRODUCT DESCRIPTION

A low VOC, surface tolerant, aluminium-pigmented temperature resistant coating designed for application onto high temperature steel, in maintenance environments.

Based on hot spread epoxy technology, Intertherm 2205 is a next generation epoxy phenolic coating for high temperature applications.

Intertherm 2205 provides excellent Corrosion Under Insulation (CUI) and heat resistance, alongside easy application properties when applied directly to high temperature equipment.

### INTENDED USES

For the maintenance and repair of process pipe, valves and vessels in highly corrosive, CX environments, which operate at temperatures up to 230°C (446°F) and in thermal cyclic conditions.

Intertherm 2205 is designed for application to steel surfaces operating at elevated temperatures between 60°C (140°F) and 205°C (401°F), in facilities where it is desirable to reduce downtime by continuing operations during maintenance periods. Intertherm 2205 is ideal for high temperature maintenance in refineries, petrochemical plants and other aggressive environments, such as offshore structures, where dry abrasive blasting is not possible.

Suitable for use on insulated or uninsulated surfaces.

### PRACTICAL INFORMATION FOR INTERTHERM 2205

<b>Colour</b>	Aluminium
<b>Gloss Level</b>	Not applicable
<b>Volume Solids</b>	85%
<b>Typical Thickness</b>	100-200 microns (4-8 mils) dry equivalent to 118-235 microns (4.7-9.4 mils) wet
<b>Theoretical Coverage</b>	8.50 m <sup>2</sup> /litre at 100 microns d.f.t and stated volume solids 341 sq.ft/US gallon at 4 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Brush, Roller

#### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
60°C (140°F)	30 minutes	60 minutes	60 minutes	24 hours
100°C (212°F)	5 minutes	15 minutes	15 minutes	24 hours
205°C (401°F)	4 minutes	4 minutes	4 minutes	24 hours

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 43°C (109°F); Part B 104°C (219°F); Mixed 50°C (122°F)		
<b>Product Weight</b>	1.34 kg/l (11.2 lb/gal)		
<b>VOC</b>	0.80 lb/gal (97 g/l)	EPA Method 24	
	98 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)	

See Product Characteristics section for further details

## Protective Coatings

## Hot Spread Epoxy

### SURFACE PREPARATION

#### Steel Substrates

Intertherm 2205 has been designed specifically with maintenance considerations in mind and so can be applied over a range of surface preparation standards, for hand tooled, power tooled or abrasive blast cleaned methods, including St2, St3, Sa2, Sa2½ (ISO8501-1) and SP2, SP3, SP11, SP6, SP10 (SSPC).

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

For hand or power tool preparation methods: areas which cannot be prepared adequately by chipping or needle gun, or where there is no pre-existing surface profile present, should be spot blasted to a minimum standard of ISO8501-1, Sa2/SSPC-SP6. Typically, this would apply to a C or D grade rusting in this standard.

#### Aged Coatings

Intertherm 2205 is suitable for overlap onto most aged coating systems; remove all loose, flaking or poorly adhering coatings back to a firm edge and prepare the bare steel as above, without polishing the surface. Aged epoxy coatings and any glossy areas should be abraded; all areas to be coated should be clean, dry and free of oil or grease prior to painting.

### APPLICATION

<b>Mixing</b>	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.			
	(1) Agitate Base (Part A) with a power agitator.			
	(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.			
<b>Mix Ratio</b>	3.50 part(s): 1 part(s) by volume			
<b>Working Pot Life</b>	10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
	2 hours	2 hours	90 minutes	60 minutes

<b>Brush</b>	Recommended	Typically 100-150 microns (4.0-6.0 mils) can be achieved
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<b>Roller</b>	Recommended	Typically 100-125 microns (4.0-5.0 mils) can be achieved
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<b>Thinner</b>	Not recommended
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<b>Cleaner</b>	International GTA007
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<b>Work Stoppages</b>	Thoroughly clean all equipment with International GTA007. Once units of material have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.
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<b>Clean Up</b>	Clean all equipment immediately after use with International GTA007. It is good working practice to periodically clean equipment during the course of the working day.
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All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

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### PRODUCT CHARACTERISTICS

Intertherm 2205 is a low VOC, surface tolerant, high build coating which provides excellent corrosion resistance for process pipe, valves and vessels operating continuously at temperatures up to 205°C (401°F), and which can withstand intermittent surges up to 230°C (446°F).

Intertherm 2205 is the preferred product for application to hand and power tool prepared steel operating at elevated temperatures, where it is desirable for operations to continue during coating maintenance. It is designed for use on steel which is either atmospherically exposed or which is thermally insulated.

As Intertherm 2205 is intended for application to steelwork which is in service at temperatures above 60°C (140°F), there will be a rapid release of volatiles from the applied coating and suitable personal protective equipment (PPE) should be worn during application.

In order to ensure good anti-corrosive performance, it is important to achieve a minimum system dry film thickness of 200 microns (8 mils) by application of multiple coats (typically two coats).

The product will thin rapidly on application to hot surfaces above 100°C (212°F). Any runs and sags which form should be worked to form a uniform film prior to full cure occurring. When paint on the brush or roller starts to cure, the brush/roller should be replaced. Thinning is not required or desired.

When applied at temperatures above 100°C (212°F), Intertherm 2205 is suitable for re-insulation after a curing period of 10 minutes.

On exposure to high temperatures, Intertherm 2205 may go through a colour change from aluminium to a faded bronze. This phenomenon is a normal part of the curing process and does not affect coating performance.

Intertherm 2205 is an immersion grade coating, and is suitable for use in situations of continuous intimate contact with wet insulation. However, Intertherm 2205 is not intended for use as an internal tank lining. Intertherm 2205 is not suitable for buried service.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

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### SYSTEMS COMPATIBILITY

Intertherm 2205 will normally be applied direct to metal but is compatible for overlap on the following coatings:

Interbond 2340UPC  
Interplus 256  
Intertherm 228HS

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### ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at [www.international-pc.com](http://www.international-pc.com):

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

### SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	5 litre	3.5 litre	5 litre	1 litre	1 litre

For availability of other pack sizes, contact International Protective Coatings.

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
		5 litre	5.47 kg

STORAGE	Shelf Life	
		6 months at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

### Important Note

*The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.*

*This Technical Data Sheet is available on our website at [www.international-marine.com](http://www.international-marine.com) or [www.international-pc.com](http://www.international-pc.com), and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.*

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