

PRODUCT DATA SHEET

Sika® Permacor®-3326 EG H

Future name: Dura-Plate® 3326 EG-H

Very high solid epoxy coating for steel and concrete

DESCRIPTION

Sika® Permacor®-3326 EG H is a low solvent containing 2-pack epoxy coating for steel. The coating has high physical strength, with good abrasion and impact resistance.

USES

Sika® Permacor®-3326 EG H may only be used by experienced professionals.

Sika® Permacor®-3326 EG H is ideally suited for the corrosion protection of steel surfaces exposed to various media.

The principal use of Sika® Permacor®-3326 EG H is the internal lining of sludge digesters, composting vessels, and process water-, waste water-, and chemical storage tanks, as well as cooling water pipelines and bio-gas plants.

Sika® Permacor®-3326 EG H is also suitable as a robust anti-corrosive coating for use in industrial environments, e.g. for pipe bridges, bottling plants, and as an external coating for tanks and pipes, machinery and other pieces of apparatus.

CHARACTERISTICS / ADVANTAGES

- High chemical resistance to water, aggressive effluents and waste water and a wide range of chemicals, particularly salt solutions and to acids occurring in biological processes
- High diffusion resistance
- Very good adhesion to steel and mineral surfaces
- Reliable application due to the ability to check for pores in the coating

APPROVALS / CERTIFICATES

- Evidence for chemical resistance against biogenous sulfuric acid (cat. XWW4/XBSK) acc. DIN 19573 and DIN EN 13529.

PRODUCT INFORMATION

Packaging	Sika® Permacor®-3326 EG H	16 kg net.
	Sika® Thinner E+B	25 l and 5 l
	SikaCor® Cleaner	160 l and 25 l
Appearance and colour	Pebble grey approx. RAL 7032 and green approx. DB 601	
Shelf life	2 years	
Storage conditions	In originally sealed containers in a cool and dry environment.	
Density	~1.9 kg/l	
Solid content	~75 % by volume	
	~88 % by weight	

TECHNICAL INFORMATION

Chemical resistance	Upon request
Temperature resistance	Dry heat up to approx. + 100°C

SYSTEM INFORMATION

System	<u>Steel:</u> 2 - 3 x Sika® Permacor®-3326 EG H (250 µm per layer)
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APPLICATION INFORMATION

Mixing ratio	Components A : B		
	By weight	100 : 23	
	By volume	100 : 26	
Thinner	Sika® Thinner E+B If necessary max. 5 % Sika® Thinner E+B may be added to adapt the viscosity.		
Consumption	Theoretical material-consumption/coverage without loss for medium dry film thickness of:		
	Dry film thickness	250 µm	
	Wet film thickness	330 µm	
	Consumption	0.633 kg/m ²	
	Coverage	1.58 m ² /kg	
Material temperature	Min. + 10°C		
Relative air humidity	Max. 85 % Max. 80 % in containers, except the surface temperature is significantly higher than the dew point temperature, it shall be at least 3 K above dew point.		
Surface temperature	Min. + 10°C		
Substrate moisture content	Max. 4 % (CM-measuring)		
Pot Life	At + 20°C	~90 min	
	At + 30°C	~45 min	
Waiting time to overcoating	Waiting time at + 20°C Min. 12 h <u>Coating used as lining:</u> Max. 48 h at + 20°C In case of longer waiting times the surface must be activated by sweepblasting.		
	Overcoating With itself. <u>For exposure to corrosive atmospheric conditions, also:</u> With Sika® Permacor®-2230 VHS or Sika® Permacor®-2330. For other products please refer to Sherwin-Williams.		
	Drying time	Drying time at + 20°C	
		Touch dry	after ~4 h
		Walkable	after ~12 h
	Final drying time Full mechanical and chemical resistance after 7 days at + 20°C.		
Porosity test	With a suitable high-voltage tester, e.g. Fischer-POROSCOPE® with flat electrode (rubber tongue). Test voltage 5 Volt per 1 µm coating thickness. Multiple porosity tests have negative effects on dielectric strength. This is to take into consideration when planning repetition tests.		

BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SURFACE PREPARATION

Steel:

Remove all weld spatter, then grind welds and joints in accordance with EN 14879-1.

Blast-cleaning to Sa 2 ½ according to ISO 12944-4. Free from dirt, oil and grease.

Average roughness depth $R_z \geq 50 \mu\text{m}$.

MIXING

Stir component A and B very thoroughly using an electric mixer (start slowly, then increase up to approx. 300 rpm). Add stirred component B carefully and mix both components very thoroughly (including sides and bottom of the container). Mix for at least 3 minutes until a homogeneous mixture is achieved. Fill mixed material into clean container and mix again shortly as described above. During mixing and handling of the materials always wear protective goggles, suitable gloves and other protective clothings.

APPLICATION

The method of application has a major effect on achieving uniform thickness and appearance. Spray application will give the best results. The indicated dry film thickness is easily achieved by airless spray. Adding solvents reduces the sag resistance and the dry film thickness. In case of application by roller or brush, additional applications may become necessary to achieve the required coating thickness, depending on type of construction, site conditions, colour shade etc. Prior to major coating operations a test application on site may be useful to ensure the selected application method will provide the requested results.

By brush or roller:

- Dry film thickness of approx. 150 μm per layer is achievable
- Possibly an additional layer may become necessary to achieve the total dry film thickness

Airless-spraying:

- Efficient airless equipment
- Pressure min. 180 bar
- Remove sieves
- Nozzle size $\geq 0.38 \text{ mm}$ ($\geq 0.015 \text{ inch}$)
- Spraying angle approx. 50°
- Diameter of hoses min. 10 mm ($\frac{3}{8} \text{ inch}$), hose at spray gun approx. 2 m, min. 6 mm ($\frac{1}{4} \text{ inch}$)
- Temperature of material min. + 15°C

CLEANING OF EQUIPMENT

SikaCor® Cleaner

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sherwin-Williams' products, are given in good faith based on Sherwin-Williams' current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sherwin-Williams' recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sherwin-Williams reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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