

PRODUCT SPECIFICATIONS

Product Description

A solvent free epoxy-polyamide mastic corrosion barrier coating designed for use on those areas of marine structures and pipelines where effective maintenance with traditional coatings is very difficult or impossible.

Design Feature

- As a repair coating for underwater pilings and bracings, underwater pipes and the repair of water line structures and retaining walls.
- Outstanding corrosion barrier properties.
- Specially formulated for application & cure underwater in fresh or salt water.
- Excellent water, chemical & solvent resistance.
- Compatible with cathodic protection systems with excellent cathodic disbondment resistance.
- Solvent-free environment friendly coating.

Physical Characteristics

Recommended Application Data	Wet [μm]	Dry [μm]	m ² /l
Theoretical Coverage	6000	6000	0.17

Volume Solids	:	100% (based on ASTM D2697)
Dry Film Thickness Range	:	3000 - 6000 μm
Flash Point	:	>90 °C
Finish	:	Low-gloss
Colour Range	:	Grey
Standard Packing Size	:	7.56 litres set (3.78 litres Base : 3.78 litres Hardener)
Mix Ratio (by volume)	:	1 Part Base : 1 Part Hardener

Application Instructions

Mix both components together until a uniform grey colour is achieved. The coating may be applied by hand smearing to a thickness of 3 – 6mm. The preferred application technique is to apply a “ring” or “doughnut” to the structural members above the water line and then smearing it down uniformly to and below the water line, remembering to ensure the “feather edge” the top and bottom of the coating to the member.

It is recommended that the applicator’s hands should be kept wet at all times to ensure that the coating can be moulded like putty to the substrate.

If the wave action and/or currents make hand smearing difficult, then the coating can be applied by carrying it onto the substrate using a membrane such as fibreglass cloth or canvas ducking. The membrane should be cut in strips 5cm longer than the pipe circumference. Hand smear the mixed coating to the membrane, wrap and tie to the surface. The coated side of the membrane should be pressed carefully against the surface to displace water. When coating small diameter pipes, it is recommended that a 10-15cm fibreglass tape be used as a membrane.

A 2 person crew can apply one 4L unit of mixed coating in approximately 30 minutes.

Drying & Curing Time

Substrate Temperature	Touch Dry	Hard Dry	Overcoating Interval		Pot Life
			Min.	Max.	
15 °C	6 hours	12 hours	48 hours	14 days	2 hours
25 °C	3 hours	5 hours	24 hours	7 days	1 hour
35 °C	2 hours	3 hours	12 hours	3 days	30 minutes

**Useful
Information**

THINNER	:	Do not thin
CLEANER	:	SOLVALUX 7-45 or 7-77
STORAGE	:	Store in a cool dry shaded area.

**Surface
Preparation**

The service life span and the service performance of EPILUX 825 is directly related to the degree of surface preparation.

STEEL

Abrasive blast cleaning is the most effective method of surface preparation and will result in a longer life for this coating. However, wet blasting and power tool cleaning is acceptable as long as a deep profile is created and old rust scale is removed.

- Remove all wax, oil and grease by solvent cleaning in accordance with the guidelines given by SSPC-SP1.
- Where necessities remove weld spatter and round off all rough weld seams and sharp edges to a smooth surface.
- Abrasive blast clean to a minimum standard of Sa2½ (ISO 8501-1:1988) or SSPC-SP6.
- Any surface defects revealed by blast cleaning should be ground, filled or treated in a suitable manner.
- After blasting, remove dust from the surface.
- The surface to be coated must be clean and dry.
- Apply Epilux 825 immediately after blasting to prevent oxidation and recontamination of the steel surface. In case of oxidation or recontamination, re-blast to the required standard.

Notes

- Do not thin this product at any time.
- Do not topcoat this product with any other material other than itself.

**Safety
Precaution**

- Avoid contact with eyes and skin.
- Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Use barrier cream.
- Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe in vapour or spray mist.
- This product is flammable. Keep away from sources of ignition. Do not smoke.
- Take precautionary measures against static discharge.
- In case of fire, blanket flames with foam, carbon dioxide or dry chemicals.

First Aid

Eyes	:	In the event of accidental splashes, flush eyes with warm water immediately and seek medical advice.
Skin	:	Wash skin thoroughly with soap and water or approved industrial cleaner. Do Not Use solvents or thinners.
Inhalation	:	Remove to fresh air, loosen collar and keep patient rested.
Ingestion	:	In case of accidental ingestion, DO NOT INDUCE VOMITING. Obtain immediate medical attention.

For further safety information, please refer to our **Material Safety Data Sheet (MSDS)**

The information provided on this data sheet is not intended to be complete and is provided as general advice only. It is the responsibility of the user to ensure that the product is suitable for the purpose for which he wishes to use it. As we have no control over the treatment of the product, the standard of surface preparation of the substrate, or other factors affecting the use of this product, we are not responsible for its performance nor would we accept any liability whatsoever or howsoever arising from the use of this product unless specifically agreed to in writing by us. The information contained in this data sheet may be modified by us from time to time, and without notice, in the light of our experience and continuous product development.

R1-072025