



# Scotchkote™

## 206N XTRA LG

### Product Description

3M™ Scotchkote™ 206N XTRA LG Fusion Bonded Epoxy is a one-part, heat curable, thermosetting, powdered epoxy coating with extended gel for coating the interior of line pipe and fittings. Scotchkote 206N XTRA LG meets the requirements of AWWA Standard C213 and C550.

### Properties

Property	Value
Color	blue green
Specific Gravity (Air Pycnometer)	1.47
Coverage	134 ft <sup>2</sup> /lb/mil 0.694 m <sup>2</sup> /kg/mm
Shelf life 80°F/27°C	12 months
Gel time @ 380°F/193°C	90-115 seconds
Gel time @ 450°F/232°C	40-60 seconds
Modified CSA-Z245.20	
Pill Flow - 300°F/149°C	50-80 mm
Cure Time	18 minutes

### General Application Information

- Remove oil, grease and loosely adhering deposits.
- Abrasive blast-clean the surface to near-white in accordance with SSPC-SP10 or NACE No. 2, ISO 8501-Sa2.5
- Heat pipe to 350°F/177°C–450°F/232°C
- Deposit Scotchkote 206N XTRA LG onto the interior of the pipe at 16-40 mils (406-1016 µm).
- Within 24 hours move coated pipe to a post cure station. Refer to cure guide below for cure time and temperature.
- Electrically inspect for holidays after coating has cooled to 200°F/93°C or lower.
- When Scotchkote 206N XTRA LG is used with 3M primers, contact the 3M representative for application and cure conditions.

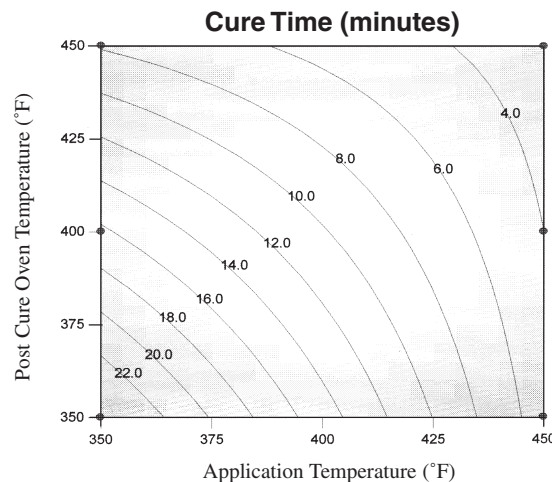
### Coating Test Data

Property	Test Description	Result
Impact	ASTM G14 1/8" x 3" x 3" in steel panel (0.32 cm x 7.6 cm x 7.6 cm) 5/8" (1.6 cm) diameter tup	160 in-lbs. 1,8 kg-m
Bendability	Saudi Aramco 09-SAMSS-091 500-625 µm thickness	10.5 PD (5.5°/PD)
	CSA-Z245.20-M92 3°/PD at -30°C	Passes
Dielectric Strength	ASTM D149-95a	1345 V/mil 53,0 Kv/mm
Water Vapor Transmission	ASTM D 1653	4.05 g/M <sup>2</sup> /day (0,21 grains/ft <sup>2</sup> /hr)
Water Absorption	ASTM D 570-95 23° C (73° F)	1.46 % Wt. gain
Water Resistance	ASTM D 4585-92 Cleveland Test 52°C with 15°C Gradient 3 weeks continuous	*Pass
Abrasion Resistance	Saudi Aramco 09-SAMSS-091 ASTM D 4060	0,11 g loss

\*Pass means excellent adhesion, no blisters and no swelling.



Tested and Certified to ANSI/NSF Standard 61, Drinking Water System Components



## 3M™ Scotchkote™ 206N XTRA LG Properties (continued)

Property	Test Description	Results
Penetration	ASTM G 17 -40° to 200°F (-40° to 93°C)	0%
Tensile Strength	ASTM D 2370	9,330 psi (654 kg/cm <sup>2</sup> )
Elongation	ASTM D 2370	6.9%
Compressive Strength	ASTM D 695	11,600 psi (815 kg/cm <sup>2</sup> )
Thermal Shock	-100°F to 310°F (-73°C to 154°C) 4 in x 4 in (10,2 cm x 10,2 cm) coated panel	no visible effect 10 cycles
Volume Resistivity	ASTM D 257	1.3 x 10 <sup>15</sup> ohm-cm
Salt Fog	ASTM B 117	no blistering, no discoloration, no loss of adhesion
Cathodic Disbondment	90 day, 5 volt, 5% NaCl, 73°F (23°C) 7 day, 5 volt, 5% NaCl, 73°F (23°C) after bending at 3° per diameter length	13 mmr 2, 75 mmr
Hot Water Resistance	212°F (100°C) immersion for 1,000 hrs.	no blistering, good adhesion, slight discoloration, surface roughening and softening

<sup>1</sup>Test conducted on coupons cut from production coated 26 in O.D., 0.406 in wall x 52 pipe 12 mil (0.305 mm) average coating thickness.

### Temperature Operating Range

The Scotchkote 206N coating, when properly applied, should perform in a satisfactory manner on pipelines operating between -76° and +230°F (-60° and +110°C). For temperatures between +170° and 230°F (+77° and +110°C), laboratory tests indicate that thicker coatings may improve the service capability. However, it is difficult to accurately predict field performance from laboratory data due to the wide variation in actual field conditions. Soil types, moisture content, temperatures, coating thicknesses and other factors peculiar to the area all influence the coating performance and the upper temperature operation limit.

### Handling & Safety Precautions

Read all Health Hazard, Precautionary, and First Aid statement found in the Material Safety Data Sheet, and/or product label of chemicals prior to handling or use.

### Ordering Information/Customer Service

For ordering information, technical information, product information or to request a copy of the Material Safety Data Sheet, call:

Phone: 800/722-6721 or 512/984-1038

FAX: 877/601-1305 or 512/984-6296

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