

3M™ Scotchkote™ WB Epoxy Coating EA5WB

Data Sheet and Application Guide

Product Description

3M™ Scotchkote™ WB Epoxy Coating EA5WB is a member of the expanding range of 3M™ Scotchkote™ high performance coatings. It has been specifically developed for original equipment manufacture, particularly within the water industry. Scotchkote WB epoxy coating EA5WB is water borne coating for pumps, valves, and fittings providing corrosion resistance for steel, stainless steel and aluminum substitutes.

General Attributes

Color	Blue
Ratio	5:1 By volume
Corrosion Resistance	Excellent corrosion resistance in conjunction with appropriate pre-treatment.
Abrasion	Good resistance to abrasion and mechanical damage.
Adhesion	Excellent on correctly prepared surfaces.
Chemical Resistance	The fully cured coating offers outstanding resistance to aqueous solutions and a wide range of industrial chemicals.
Temperature	Dry service temperature range up to 100°C (212°F)
Potable Water	Approved for contact with potable water in some countries. Check local approvals before use in portable water.

Packaging

Supplied in either 5 liter packs or the Base and Activator supplied separately in 20 liter containers (5 Base to 1 Activator).

Ordering Information/Customer Service

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

Phone: +1 (800) 722-6721

Product Properties

Drying & Cure Times at 20°C (68°F)

Pot (usable) Life	3 hours
Touch Dry	1 hour
Hard Dry	24 hours
Dry for Packing	72 hours
Full Cure	7 days
Shelf Life	Use within 2 years of purchase. Store in original sealed containers at temperatures between 5°C (40°F) and 32°C (90°F).

Physical Constants

Total Solids Content (Average) by volume	45%
Specific Gravity (Average Mixed)	1.24
*V.O.C (As Supplied)	120 g/L, as calculated Note: Thinning for spray application will reduce the applied V.O.C.
Film Thickness (Typical)	Wet 7.2 mils (180 microns)/ Dry 3.2 mils (80 microns). Wet 13.2 mils (330 microns) / Dry 6 mils (150 microns). When product is thinned appropriate adjustment to wet film thickness should be made. Note: The thickness to be applied should be agreed between the specifier and the manufacturer dependant on operational performance requirements.
Theoretical Coverage Rate	5.6 square meters per liter at 80 microns dft. 60.3 square feet per liter at 3 mils dft. 3 square meters per liter at 150 microns dft. 32.3 square feet per liter at 6 mils dft.

*Consult local air quality regulations that may regulate product sale or usage.



Application Procedures for 3M™ Scotchkote™ WB Epoxy Coating EA5WB

Surface Preparation

Steel Surfaces - Coating performance is dependent on the cleanliness of the substrate surface. It must be clean, dry and free of loose rust and scale, paint, etc. Remove all oils, grease, and other contaminants with a suitable solvent. Metal surfaces should be blast cleaned in accordance with NACE No. 2 SSPC-SP 10 ISO 8501:1, Grade SA 2 ½, near white finish using suitable abrasive to a medium profile of 1.3 mils (35 microns).

Aluminum Surfaces - Abrade with fine abrasive paper or 3M™ Scotch-Brite™ Pads.

Application

Conditions for Application

- Do not apply when relative humidity exceeds 85% or when the surface to be coated is less than 5°F (3°C) above the dew point.
- For optimum results a minimum material and substrate temperature of 59°F (15°C) is necessary.
- Primed surfaces should be clean, dry and free from oil and grease.

General Application Steps

1. Remove oil, grease and loosely adhering deposits.
2. Abrasive blast clean steel surfaces to NACE No.2/SSPC-SP10 near white metal, ISO 8501:1, Grade SA2 ½ to a medium profile of 1.3mils (35 microns). Lightly abrade aluminium.
3. Apply Scotchkote WB epoxy coating EA5WB at the specified thickness.
4. Allow to cure.
5. Visually or electrically inspect the coating for defects.
6. Repair all defects.

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Methods

Scotchkote WB epoxy coating EA5WB can be applied by airless spray equipment. Ideally, dedicated spray equipment should be used for applying water borne coatings. If this is not possible, equipment should be first flushed with solvent related to the previous solvent based coating. This should then be followed by a second flushing using a suitable solvent then by rinsing through with clean water. After use, wash out with clean water followed by flushing with 3M 3000 solvent.

Method of Mixing: Stir the contents of the base component.

Continue stirring while gradually adding the total contents of the activator container. Continue stirring until a homogeneous mix is obtained.

Note: When mixing complete units of the product, the use of the slow variable speed mechanical mixer is beneficial in terms of ease and complete mixing.

Handling and Safety Precautions

Read all Health Hazard, Precautionary and First Aid, Material Data Sheet, and/or product label prior to handling or use.

Note: Material Data Safety Sheets are available at 3m.com/Water.



3M Water Infrastructure

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