

**3M** Science.  
Applied to Life.™



3M™ Scotchkote™ Coatings Guide

Protecting  
what's  
important.



# 3M™ Scotchkote™ Coatings: Celebrating Over 55 Years of Pipeline Integrity

Since 1960, 3M has achieved an international reputation in the field of high performance corrosion protection coatings with fusion bonded epoxy and liquid epoxy. Focusing on the challenges facing today and tomorrow's infrastructure owners, engineers and contractors, 3M delivers innovation and cost-effective coating solutions for a diversity of operating environments for the following applications:

- Fusion Bonded Epoxy Pipeline Coatings
- Liquid Epoxy Pipeline Coatings
- Liquid Urethane Pipeline Coatings

For more information, visit [www.3M.com/corrosion](http://www.3M.com/corrosion).



## **3M™ Scotchkote™ Fusion Bonded Epoxy, Liquid Epoxy and Urethane Coatings**

Fusion bonded epoxies have extremely low permeability rate and low coefficient of friction. The heat cure causes tight molecular cross linking of the epoxy, thus creating a barrier that resists permeation by both hot and cold liquids.

Liquid epoxy coatings do not require extra heat to achieve cure. On-site field application is therefore simplified because only cleaning and application equipment are needed. Can achieve a high build in a single application.

| 3M™ Scotchkote™ Fusion Bonded Epoxy Coatings |                                                                                                                                                                                                                                                                                                      | Description |
|----------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|
| External                                     |                                                                                                                                                                                                                                                                                                      |             |
| 6233P                                        | This coating incorporates 3M's proprietary advanced adhesion technology. Used as a stand-alone or as a primer coating for a multi-layer systems. Color: Green                                                                                                                                        |             |
| 226N                                         | The advanced adhesion properties make this coating ideally suited for pipeline protection applications. Used as a stand-alone or as a primer coating for a multi-layer systems. Color: Blue-Green                                                                                                    |             |
| 226N+                                        | This coating helps provide exceptional adhesion and damage resistance while also providing a cost-effective alternative to standard coatings. Used as a stand-alone or as a primer coating for a multi-layer systems. Color: Blue-Green                                                              |             |
| High-Temperature                             |                                                                                                                                                                                                                                                                                                      |             |
| 626-120                                      | Designed as a stand-alone or the corrosion coating for a multi-layer system for the corrosion protection of pipe. Operating temperature of < 115°C. Color: Green                                                                                                                                     |             |
| 626-140                                      | Designed as a stand-alone or the corrosion coating for a multi-layer system for the corrosion protection of pipe. Operating temperature of < 135°C. Color: Green                                                                                                                                     |             |
| Abrasion Resistant Overcoat                  |                                                                                                                                                                                                                                                                                                      |             |
| 6352                                         | Well-suited to protect pipe during directional drilling applications, river or road crossings, and installation in rough terrains. Designed as a hard, mechanically strong top coating. Color: Brown                                                                                                 |             |
| 6352HF                                       | Has increased flexibility while retaining properties such as impact strength and gouge resistance. Designed as a hard, mechanically strong top coating. Color: Brown                                                                                                                                 |             |
| 207R                                         | Designed as a rough overcoat to produce a granular finish on all Scotchkote fusion bonded epoxy coating products where increased surface roughness is required. Color: Blue-Green                                                                                                                    |             |
| 328                                          | An abrasion resistant overcoat designed for increased adhesion, enhanced gouge resistance, and improved flexibility. Ideal for situations in which long-term adhesion is critical, where perfect surface preparation is not feasible, and directional drilling applications (HDD). Color: Blue-Green |             |

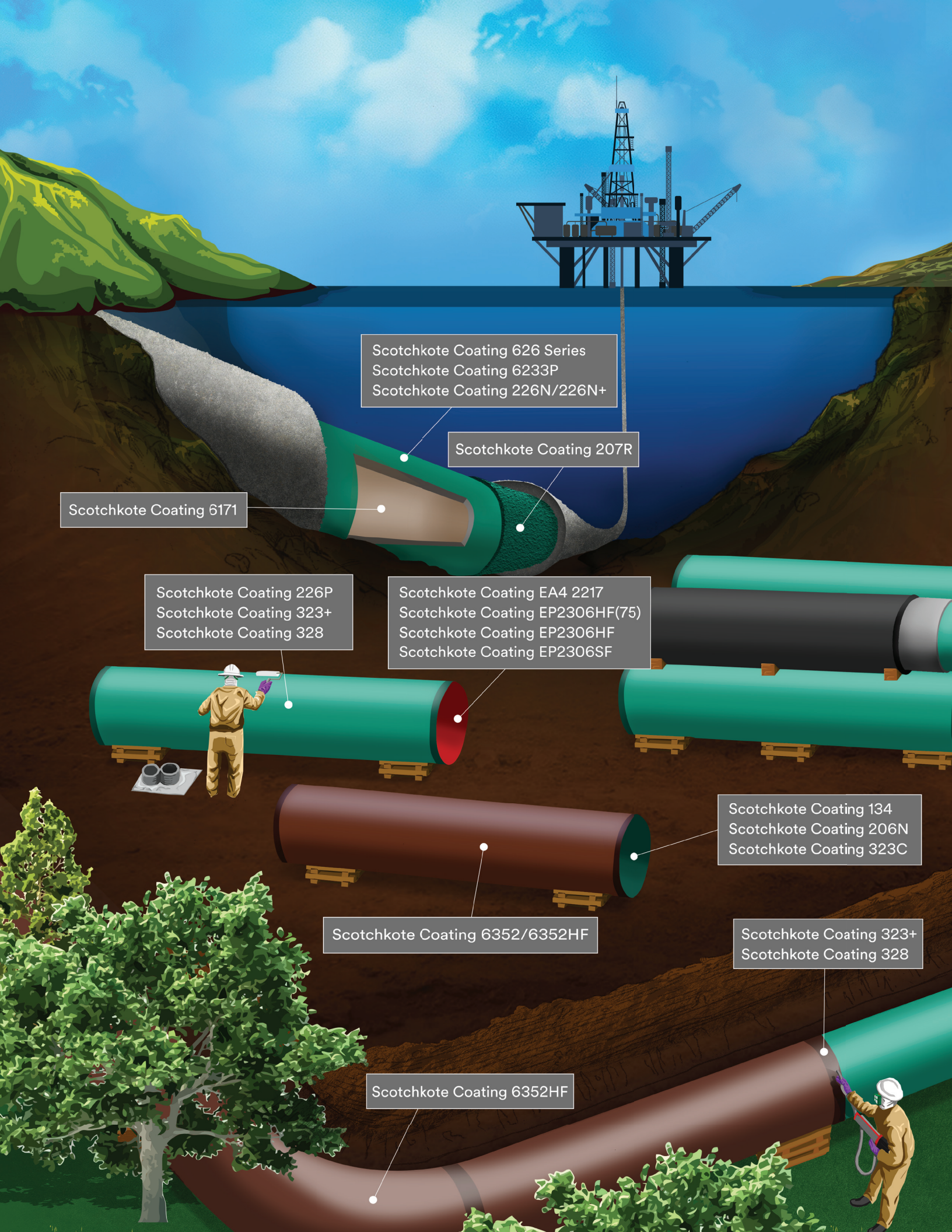
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| 3M™ Scotchkote™ Fusion Bonded Epoxy Coatings |  | Description                                                                                                                                                                                                                                                                                                                   |
|----------------------------------------------|--|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Custom</b>                                |  |                                                                                                                                                                                                                                                                                                                               |
| 134                                          |  | Used for corrosion protection of metal substrates such as valves, pumps, pipe drains, hydrants and porous castings. Resistant to wastewater, corrosive soils, hydrocarbons, harsh chemicals, and sea water. Color: Forest Green. ANSI/NSF61  |
| 135                                          |  | Used for corrosion protection of metal substrates such as valves, pumps, pipe drains, hydrants and porous castings. Resistant to wastewater, corrosive soils, hydrocarbons, harsh chemicals, and sea water. Listed on the QPL for MIL 23236-D. Color: Gray                                                                    |
| 6233W                                        |  | Is a one-part, heat curable, thermosetting epoxy coating powder designed for corrosion protection of drinking water pipes, valves, fittings, and couplers.                                                                                 |
| 726                                          |  | Can be applied at 12% lower temperatures (180-200C) allowing applicators to coat at a lower temperature without sacrificing product performance or causing damage to the steel.                                                                                                                                               |

| 3M™ Scotchkote™ EXTERNAL Liquid Coatings |  | Description                                                                                                                                                                                                                                                                                                     |
|------------------------------------------|--|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 323+                                     |  | In an effort to uphold 3M's commitment to environmental stewardship, we removed nonylphenol from our leading liquid epoxy formulation and enhanced its adhesion, flexibility and impact resistance. Color: Blue-Green                                                                                           |
| 328                                      |  | An abrasion resistant overcoat designed for increased adhesion, enhanced gouge resistance, and improved flexibility. Ideal for situations in which long-term adhesion is critical, where perfect surface preparation is not feasible, and horizontal directional drilling applications (HDD). Color: Blue-Green |
| 352BG                                    |  | A brush grade, cold weather application coating designed to help protect buried steel structures from the harsh effects of corrosion. Color: Gray                                                                                                                                                               |
| 352HT                                    |  | A spray grade with plural component, cold weather application coating designed to help protect buried steel structures from the harsh effects of corrosion. Color: Gray                                                                                                                                         |

| 3M™ Scotchkote™<br>INTERNAL Coatings | Description                                                                                                                                                                                                                                                 |
|--------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 6171                                 | Designed for interior corrosion protection of production tubing, line pipe, and fittings. Can withstand extreme pressures and corrosive environments. Color: Beige                                                                                          |
| 6258                                 | Designed for downhole tube internal coating application. Promotes excellent adhesion to withstand extreme temperatures and pressures in corrosive environments. Color: Green                                                                                |
| 206N                                 | Designed with extended gel for coating the interior of line pipe and fittings, valves, and couplers. NSF 61 approved for contact with potable water. Color: Blue-Green<br> |
| <b>Flow Efficiency</b>               |                                                                                                                                                                                                                                                             |
| 2306HF                               | Contains 48% solids and has been specifically developed as an internal lining for gas pipelines to provide maximum flow efficiency for oil and gas pipelines. Color: Red                                                                                    |
| 2306HF(75)                           | Contains 75% solids and has been specifically developed as an internal lining for gas pipelines to provide maximum flow efficiency for oil and gas pipelines. Color: Red                                                                                    |
| 2306SF                               | Contains 100% solids and has been specifically developed as an internal lining for gas pipelines to provide maximum flow efficiency for oil and gas pipelines. Color: Red                                                                                   |
| EA4 2217                             | Developed as an internal lining of tanks and pipelines holding and transporting aviation fuel and other refined petroleum products. Color: Red Oxide and Gray                                                                                               |

| 3M™ Scotchkote™<br>Pipe Patch | Description                                                                                                                                                                                                                                |
|-------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 323+                          | Because 3M is committed to environmental stewardship, we removed nonylphenol from our leading liquid epoxy formulation and enhanced its adhesion, flexibility and impact resistance. Color: Green (color match to Scotchkote Coating 6233) |
| 226P                          | Heat bondable polymeric coating in stick form designed for minor pinhole repair of Scotchkote Fusion Bonded Epoxy Coatings. Color: Green (color match to Scotchkote Coating 226N and 6233)                                                 |
| 323C                          | Two-part epoxy system designed as a patch material for 3M Scotchkote Coating 134. Color: Green (color match to Scotchkote Coating 134)                                                                                                     |



Scotchkote Coating 626 Series  
Scotchkote Coating 6233P  
Scotchkote Coating 226N/226N+

Scotchkote Coating 207R

Scotchkote Coating 6171

Scotchkote Coating 226P  
Scotchkote Coating 323+  
Scotchkote Coating 328

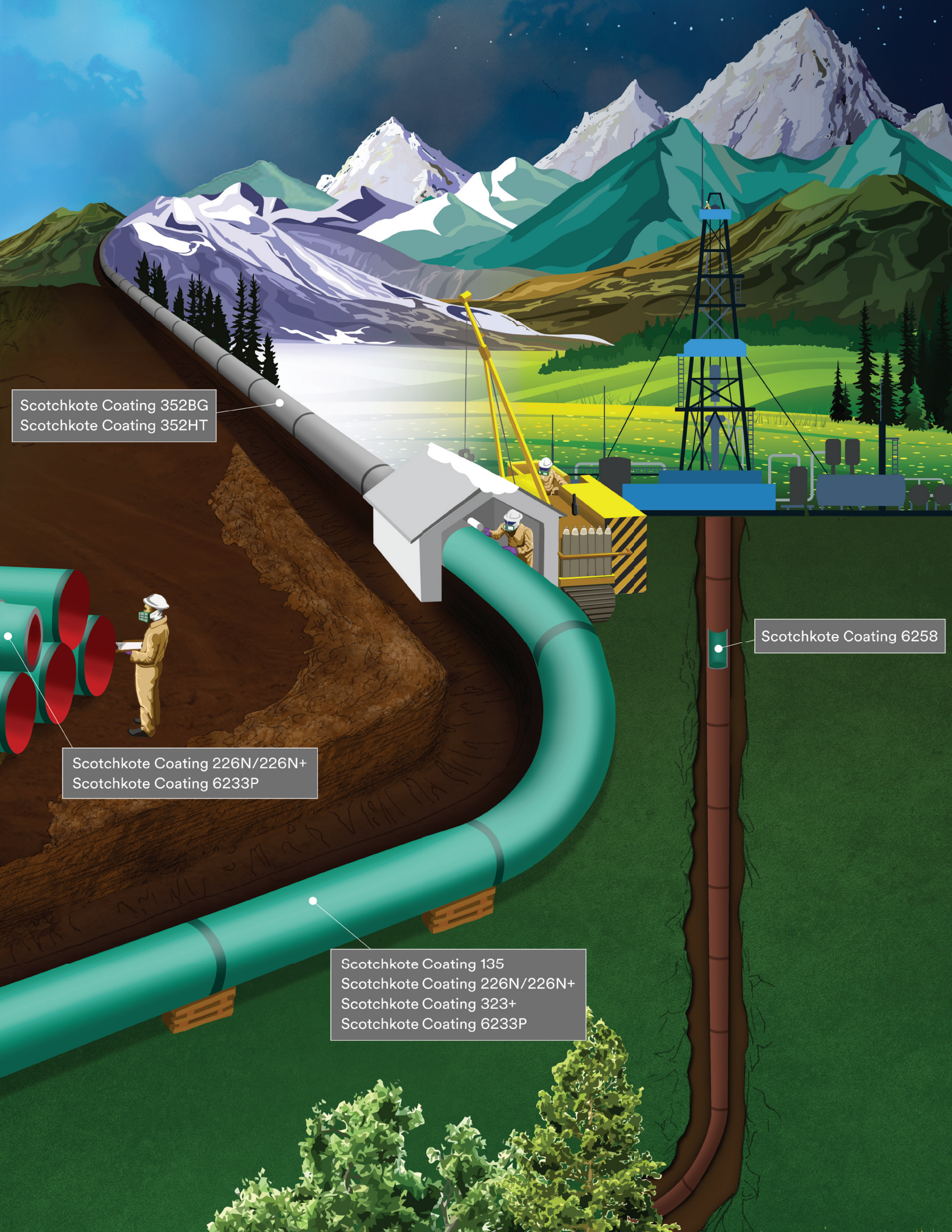
Scotchkote Coating EA4 2217  
Scotchkote Coating EP2306HF(75)  
Scotchkote Coating EP2306HF  
Scotchkote Coating EP2306SF

Scotchkote Coating 134  
Scotchkote Coating 206N  
Scotchkote Coating 323C

Scotchkote Coating 6352/6352HF

Scotchkote Coating 323+  
Scotchkote Coating 328

Scotchkote Coating 6352HF



Scotchkote Coating 352BG  
Scotchkote Coating 352HT

Scotchkote Coating 226N/226N+  
Scotchkote Coating 6233P

Scotchkote Coating 135  
Scotchkote Coating 226N/226N+  
Scotchkote Coating 323+  
Scotchkote Coating 6233P

Scotchkote Coating 6258

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