

# 3M™ Scotchkote™ Fusion Bonded Epoxy Coating 6258/6258 XLG

Data Sheet

August 2015

**Handling and Safety Precautions:** Read all Health Hazard, Precautionary and First Aid, Material Safety Data Sheet, and/or product label prior to handling or use. Personal Protection Equipment (PPE) is recommended during handling.

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## Product Description

3M™ Scotchkote™ Fusion Bonded Epoxy Coating 6258/6258XLG is a one-part, heat curable, thermosetting epoxy coating designed for corrosion protection of steel pipes. Scotchkote coating 6258 utilizes special ingredients that promote superior adhesion to steel and epoxy coatings that significantly raise the glass transition temperature of the coating. These benefits make Scotchkote coating 6258 especially suitable as single component internal lining coating for systems that require high temperature resistance and corrosive environment.

Scotchkote coating 6258 is applied to preheated steel as dry powder which melts and cures to a uniform coating thickness. Scotchkote coating 6258/6258XLG is supplied in standard gel time and extra long gel time (XLG) to accommodate application to all pipe sizes.

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## Product Features

- High temperature resistance operating performance up to 275°F/135°C.
- Enhanced Cathodic Disbondment resistance performance.
- Enhanced chemical resistance under high temperatures and pressures.
- Consistency of application and performance properties.

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## Temperature Operating Range

Scotchkote coating 6258/6258 XLG, when properly applied, should perform in a satisfactory manner on pipelines operating up to 275°F/135°C.

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## Surface Preparation

1. All surfaces should be free from oil, grease and other contamination prior to abrasive blasting.
2. Surfaces should be blast cleaned to NACE No. 2/SSPC- SP10, ISO 8501:1, Grade SA2½ near white metal finish.
3. The blast profile is generally specified by the client; which should not be less than 1.5-4 mils/38-100 microns.
4. Immediately after blast cleaning, all dust residues and debris left on the surface from blasting must be removed.

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## General Application

1. Immediately after blasting, preheat cleaned pipe to minimum of 350°F/177°C.
  2. Apply Scotchkote coating 6258 by flocking the powder onto the hot substrate or dip in fluidized bed to obtain proper coating thickness.
  3. Cure according to "Cure Specification" section.
  4. Visually or electrically inspect the coating for any defects and/or holidays.
  5. Electrical inspection requires 125 volts per mil of coating thickness.
  6. Repair any defects and/or holidays with proper patch repair material.
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## Cure Specification

Scotchkote coating 6258/6258 XLG must be cured in accordance with the Cure Guide below to achieve maximum performance properties. Post bake is required per table below. Cure time is based on the temperature of the steel from application point of the powder deposition to the forced air or water cool down.

Gel Time		
Temperature	6258	6258 XLG
360°F/182°C	26	N/A
400°F/204°C	11	24
450°F/232°C	4	10

Time to Cure (minutes)		
Temperature	6258	6258 XLG
350°F/177°C	10	N/A
400°F/204°C	2.5	7
450°F/232°C	1.5	2.5

*These tables is based on lab data and is a general guideline for proper cure application.*

## Typical Physical and Performance Properties

Property	Result
Color	Green
Specific Gravity (powder)	1.45 g/ml
Hardness (Shore D)	85
Moisture Content (Karl Fisher)	0.25%
Glass Transition Temperature (DSC)	275°F/135°C
Tensile Strength (ASTM D882)	6155 psi/42.4 Mpa
Elongation (ASTM D882)	1.20%
Flexibility (°/PD) at 75°/23C at 32°F/0°C	1.7 1.3
Shelf Life at 77°/25°C	12 months
Chemical Resistance (ASTM G20) 30, 60, 90 days	Pass

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## Autoclave Testing

Test Method – NACE TM0185

Test Conditions – Temperature = 275°F/135°C

Pressure = 110 psi

Gas Phase = 5% Hydrogen Sulfide (H<sub>2</sub>S)

5% Carbon Dioxide (CO<sub>2</sub>)

90% Methane (CH<sub>4</sub>)

Organic Phase – 50% Kerosene/50% Toluene

Aqueous Phase – 5% NaCl

Duration – 4 Days

Depressurization – 4 Hours

Test Results – No Blistering/Excellent Adhesion

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## Packaging

65 Pounds per Box

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## Shelf Life & Storage

This product has a 1-year shelf life from date of manufacture. Store in original sealed containers at temperature 40° - 80°F (5°- 27°C).

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## Availability

For ordering call:

Phone: 800 722 6721

Fax: 877 601 1305

For Data Sheets and SDS inquires please visit:

[www.3m.com/corrosion](http://www.3m.com/corrosion)

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