

PCS200 EPOXY COATINGS SYSTEMS PRODUCT DATA SHEET

- PCS200-ARO - Abrasion Resistant Overcoat

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DESCRIPTION

PCS-200-ARO is a high build solvent-free epoxy coating designed for pipelines and substrates that need additional gouge and abrasion protection from harsh environments such as rocky & aggressive soils. This Abrasion Resistant Overcoat (ARO) is commonly used in application where pipelines are being pulled through horizontally directionally drilled (HDD) holes. The PCS-200-ARO was developed to help protect the mainline coating (FBE) & girth weld coatings from gouge & abrasion damage.

PRODUCT DATA

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VALUES ARE TYPICAL, NOT SPECIFICATIONS	
SOLIDS	100%
MIX RATIO	3 parts Comp. "A" to 1 part Comp."B"
COMPONENT A	
Specific Gravity	1.77g/cc (14.80#/gallon)
Viscosity	270,000 cPs
Color	Light Gray
COMPONENT B	
Specific Gravity	1.42g/cc (11.88#/gal)
Viscosity	30,000 cPs
Color	Dark Green
BLENDED MATERIAL	
Specific Gravity	1.68g/cc
Viscosity	210,000 cPs
Color	Light Green
CURE TIME	
Pot Life @70° F (21° C)	15 Min
Surface Cure @ 70° F (21° C)	1 Hr 30 Min
Surface Cure @ 140° F (60° C)	14 Min
BACKFILL TIME @ 70° F (21° C)	
<small>Determined by the "thumb-nail" test. This is defined by when one can no longer make a permanent indentation in the coating with the thumb nail.</small>	
RECOAT TIME	
@ 70° F (21° C)	2 Hrs
@ 140° F (60° C)	0 Hrs 25 Min
THEORETICAL COVERAGE @ 60 mils	7.06 Sq. Ft./liter
APPLICATION TEMPERATURE	
Maximum Surface Temperature	150° (65° C)
Minimum Surface Temperature	50° F (10° C)
Thickness: Weld Joints & FBE Repairs	
Minimum/Maximum	25-40 mils
Recommended	30 mils
Thickness - Bore Pipe	
Minimum/Maximum	60-80 mils
Recommended	70 mils

Read the Safety Data Sheets before handling.



PIPELINE
COATINGS
SYSTEMS

CHEMICAL
& WATER
RESISTANT
COATINGS
FOR THE
PIPELINE
INDUSTRY

VALUES ARE TYPICAL, NOT SPECIFICATIONS	
HOLIDAY DETECTION	NACE SP0188
CATHODIC DISBONDMENT (CSA)	
28 Days @ 70° F (25° C)	4mm
HARDNESS (Shore "D")	
	83-85 ASTM D-2240
IMPACT RESISTANCE (ASTM- G14)	
	80 Inch/Lbs. (9.0 Joules)
Adhesion to Steel	
	>4000 psi
Adhesion to FBE (ASTM 4541)	
	>3000 psi
CLEAN EQUIPMENT WITH MEK SOLVENT OR LACQUER THINNER	

SURFACE PREPARATIONS on STEEL SUBSTRATE

Surface must be clean, dry and free from oil, grease and dust. All contamination that could hinder adhesion of the coating shall be removed according to SSPC-SP1. Prior and during the surface preparation, the temperature of the substrate must be at least 5° F (3° C) above the dew point. Abrasive Blasting to standards Sa 2.5 (SSPC-SP10/NACE 2). Recommended blast profile minimum 3/4 mils (75-100 microns) angular profile.

SURFACE PREPARATIONS on FBE

Surface must be clean, dry and free from oil, grease and dust. All contamination that could hinder adhesion of the coating shall be removed according to SSPC-SP1. Prior and during the surface preparation, the temperature of the substrate must be at least 5° F (3° C) above the dew point. Abrasive blasting to standard of Sa1 (SSPC-SP7/NACE4), sweep blasting for best performance. Recommended blast profile minimum 2 mils (50 microns) angular profile.

APPLICATION INSTRUCTIONS FOR MATERIAL IN KITS

Mix part "A" Epoxy side and part "B" curative side until uniform in color with no streaks. Application should take place immediately after mixing. Apply coating onto the surface and coat in bands completely surrounding the pipe. Applicators should use a brush or plastic applicator to smooth any obvious sags, rough edges, thin spots, or drips the thickness of PCS200-ARO Coating shall be checked periodically by wet film gauge to achieve the minimum and maximum wet film thickness specified. PCS200-ARO can also be supplied in large quantities for use with plural spray equipment.

STORAGE & SHELF LIFE

Shelf life of unopened containers is 24 months from the date of manufacture. If ambient temperature is maintained (50°-75° F). Do not dispose of uncured materials until product has cooled.

Pipeline Coatings Systems makes no warranty, expressed or implied, regarding the accuracy of this data or the results to be obtained from the use thereof. Pipeline Coatings Systems assumes no responsibility for injury from the improper use of the product described herein.

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