Transpoxy Tar 212

Product description.

A polyamine cured coal tar epoxy coating designed for use on areas where maximum water resistance , abrasion and chemical resistance is required. Recommended for underwater areas of marine-, offshore- and stationary structures of both steel and concrete. It has the Lloyds approval for corrosion control.

Physical properties.

Colour	Black, Brown
Texture	Semi-gloss
Volume Solids	Approx. 65%
Specific gravity	Approx. 1.45 gr/ml
VOC	Approx. 307 gr/liter
Flashpoint	>25°C

	Dry film thickness per coat (µm)	Wet film thickness per coat (µm)	Theoretical spreading rate (m^2/l)
Range	100 - 200	155 - 310	6.5 - 3.2
Recommended	150	230	4.3

Application data.

Mixing ratio	By weight, base to hardener: 90.0 / 10.0
Potlife	10°C: 8 hours, 23°C: 4 hours, 30°C: 3 hours
Guiding data	Pressure at nozzle: 180 - 250 bar. Nozzle size: 0.48 - 0.78 mm.
Airless spray	Spray angle: 40 - 80 degrees. Volume of thinner: 0 - 5%.
Guiding data	Pressure at nozzle: 4 - 6 bar. Nozzle size: 1.5 - 2.0 mm.
Airspray	Volume of thinner: 0 - 10%.
Brush	Suitable. Multicoats are required to achieve the specified dry film thickness. Volume of thinner: 0 - 5%.
Roller	Suitable. Multicoats are required to achieve the specified dry film thickness. Volume of thinner: 0 - 5%.
Thinner/Cleaner	Transocean Epoxy Thinner 6.03 If thinning is necessary, this should be added after mixing of the two Components. Avoid excessive thinning as it will result in lower sag resistance and slower cure.

Drying and recoating times (1)

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat Minimum	Dry to recoat Max.(2)
10°C	12 Hours	24 Hours	14 Days	16 Hours	5 Days
23°C	6 Hours	18 Hours	7 Days	8 Hours	2 Days
30°C	4 Hours	12 Hours	5 Days	6 Hours	1 Day

(1)The given data are for guidance only as actual drying times may be shorter or longer, depending on film thickness, ventilation, humidity, preceding paint system etc.

(2)The best intercoat adhesion is achieved when the subsequent coat is applied before the preceding coat is fully cured. After prolonged exposure times it may be necessary to roughen the surface to ensure intercoat adhesion. When in doubt, consult your nearest Transocean office.

Surface Preparation

Steel - Blast Cleaning

All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000.
All edges shall be ground to a minimum radius of 2 mm. Remove weld spatter and smooth weld seams by using disc grinders, chipping hammers or other suitable power tools. Sharp edges, weld seams, corners and other areas that are likely to receive less dry film thickness than specified, should be stripe coated.
The surfaces shall be blast-cleaned to min. Sa 2½ (ISO 8501-1:2007). The surface profile and the anchor pattern shall be between 40 µm and 70 µm.
The abrasives shall be free from oil, grease, moisture, chloride contamination etc.

Minor repair / Touch-up

All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000.
Any corroded areas should be prepared by power-tool cleaning or water jetting.

Power-tool cleaning to min. St 2, preferably St 3 (ISO 8501-1:2007). Care shall be taken to ensure that power-tool cleaning does not polish the steel surface. If the surface being prepared lies adjacent to a coated surface, the power tool cleaning shall overlap the coated surface by at least 25 mm and the coated surface shall be feathered.

Water jetting in accordance to ISO 8591-4: 2006 to a cleanliness of Wa 2 or better for atmospheric exposure. Acceptable flash rust degree is M (medium) but degree L (light) is preferred.
A water pressure of at least of 1000 bar (approx. 15.000 psi) is recommended.

Contact your local Transocean office for more information.

Major Repair/ Refurbishment

All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000.
Corroded areas to be prepared by blast cleaning or water jetting.

Blast Cleaning: The surfaces shall be blast-cleaned to min. Sa 2½ (ISO 8501-1:2007). The abrasives shall be free from oil, grease, moisture, chloride contamination etc.

Water jetting: Water jetting in accordance to ISO 8591-4: 2006 to a cleanliness of Wa 2,5.
Acceptable flash rust degree is M (medium) but degree L (light) is preferred.
A water pressure of at least of 1000 bar (approx. 15.000 psi) is recommended.

Alternatively a suitable priming system can used. When recoating zinc primed products, ensure the primer has been fully cured. Zinc salts products shall be removed by high pressure fresh water cleaning. Contact your local Transocean office for more information.

Concrete
All surfaces should be clean, dry and free from contamination. Remove porous and less coherent areas by blast cleaning or by using power tools such as chipping hammers. Remove all dust and debris prior to painting.

Typical paint system

A typical system for this product is shown below and should be taken for guidance only. A full system specification where all details are taken into consideration can be obtained through your local Transocean representative.

Transpoxy Tar 212	Recommended:	150µm DFT
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Application conditions

The temperature of the substrate should be at least 3°C above the dew point of the air.
Temperature and relative humidity should be measured in the vicinity of the substrate.
The maximum recommended surface temperature is approx. 40°C. Higher steel temperatures are acceptable provided dry-spray is avoided by proper spray application and extra thinning if required.
In extreme cases it may be necessary to reduce film thickness in order to avoid sagging.
When applying the paint in confined spaces, provide adequate ventilation during application and drying.
The temperature of the mixed paint should be at least 15°C, otherwise extra solvent may be required to obtain a proper application viscosity.

Storage and shelf life

The product must be stored in accordance with national regulations. The cans are to be kept in a dry, cool, well ventilated space and away from source of heat and ignition. Cans must be kept tightly closed.

Worldwide availability

The product is part of the common Transocean product range but local availability is subject to confirmation. Although we strive to supply the same product through the world, slight modifications of the product in some cases may be necessary in order to comply with local conditions and/or national regulations. In such cases an alternative datasheet will issued.

Health and safety

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators.
As a general rule, avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spraying should be carried out under well-ventilated conditions. This product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

Disclaimer

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factors affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product without notice.

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