

3M™ Scotchkote™ Fusion-Bonded Epoxy Coating 6233P

Data Sheet

Product Description

3M™ Scotchkote™ Fusion-Bonded Epoxy Coating 6233P is a one-part, heat curable, thermosetting epoxy coating powder designed for corrosion protection of pipe.

Scotchkote Fusion Bonded Epoxy 6233P is an advanced thermosetting epoxy coating that incorporates 3M's proprietary advanced adhesion promotion technologies. The patented formula is designed to be more resilient to disbondment when exposed to cathodic protection currents. Resulting in not only less total disbondment during long term testing, but also less variability between test samples. The advanced Scotchkote 6233P 4G, 8G and 11G also incorporates advanced color stabilization technologies. Allowing for a more consistent final product appearance.

Properties

Property	Value
Specific Gravity Powder	1.44
Coverage based on powder	133.47 ft ² /lb/mil (0.694 m ² /kg/mm)
Color	Green
6233P-4G	
Gel Time @ 400°F (205°C)	9.5 seconds ± 20%
Cure Time @ 450°F (232°C)	30 seconds
6233P-8G	
Gel Time @ 400°F (205°C)	17 seconds ± 20%
Cure Time @ 450°F (232°C)	60 seconds
6233P-11G	
Gel Time @ 400°F (205°C)	30 seconds ± 20%
Cure Time @ 450°F (232°C)	90 seconds
Shelf life @ 80°F (27°C)	12 months

3M™ Scotchkote™ Fusion-Bonded Epoxy Coating 6233P Test Data

Property	Test Description	Typical Value
Impact	ASTM G14 (modified) 3/8 in (9.5 mm) thick plate	1.5J Pass
Cathodic Disbondment	CAN/CSA-Z245.20-12.8 24 hour, 3.5 volt, 3% NaCl 149°F (65°C) 28 day, 1.5 volt, 3% NaCl 68°F (20°C) 28 day, 1.5 volt, 3% NaCl 149°F (65°C) 28 day, 1.5 volt, 3% NaCl 203°F (95°C)	1.2 mmr 1.6 mmr 3 mmr 4.75 mmr
Hot Water Resistance	24 hours, CAN/CSA-Z245.20-12.14, 167°F (75°C) 28 day, CAN/CSA-Z245.20-12.14, 167°F (75°C) 28 day, CAN/CSA-Z245.20-12.14, 203°F (95°C)	1 rating 1 rating 2 rating
Bendability (Mandrel Bend)	<u>Temperature</u> -22°F/-30°C	<u>°/PD</u> 3.0
Strained Polarization	CSA Z245.20, 2.5° Strained, 28 day@ 68°F (20°C)	Pass (No cracking)
Porosity	CAN/CSA-Z245.20-12.10 Interface Cross sectional	2 rating 2 rating
Thermal Analysis	CAN/CSA-Z245.20-12.7 Tg (onset) Tg (onset)	57°C 102°C

Note: The typical values in this data sheet are based on lab prepared samples. Values shown are not to be interpreted as product specifications.





B&W Distributors, Inc. | PO Box 21960 Mesa, AZ 85277 | P: 480-924-8883 | F: 480-924-9100
info@bwdist.com | www.bwdist.com

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.

3M and Scotchkote are trademarks of 3M Company.

Important Notice

All statements, technical information and recommendations related to 3M Products are based on information believed to be reliable, but the accuracy or completeness is not guaranteed. Before using the 3M Product, you must evaluate it and determine if it is suitable for your intended application. Because conditions of Product use are outside of our control and vary widely you assume all risks and liability associated with such use. Any Product-related statements not contained in current 3M publications, or any contrary statements contained in your purchase order, shall have no force or effect unless expressly agreed to in writing by an authorized officer of 3M.

Warranty; Limited Remedy; Limited Liability.

3M warrants that Product will conform to 3M published specifications upon shipment. If Product is proven not to have met the specifications your exclusive remedy and 3M's sole obligation will be, at 3M's option, to replace the Product or to refund the purchase price of the Product. **EXCEPT WHERE PROHIBITED BY LAW, THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE OR THOSE ARISING FROM A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE.** Buyer is an expert in its field and is responsible for determining if Products are suitable for a particular purpose or application. 3M has no obligation under this warranty with respect to any Product that has failed due to inadequate or improper storage, handling, surface preparation, application, or maintenance; failure to follow Product instructions; or alteration or damage to the Product caused by accident, neglect, or misuse. **EXCEPT WHERE PROHIBITED BY LAW, IN NO EVENT SHALL 3M BE LIABLE FOR ANY DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL LOSS OR DAMAGES (INCLUDING LOST PROFITS) ARISING FROM THIS PRODUCT, REGARDLESS OF THE LEGAL THEORY ASSERTED.**



Infrastructure Protection Division

6801 River Place Blvd.
Austin, TX 78726-9000
www.3M.com/corrosion

Please recycle. Printed in USA.
© 3M 2012. All rights reserved.
80-6111-8606-7