







# Canusa P Epoxy/Primer

Force-cure epoxy/primer for high operating temperature pipelines


<b>Description:</b>	Canusa P Epoxy/Primer is a specially formulated 100% volume solids (solventless) two component epoxy.
<b>Recommended use:</b>	Typically used as an epoxy primer in a 3 layer coating system for superior corrosion protection of field welded joints of steel pipes or as an overcoat in multi-layer sleeve systems. Usage of Canusa's proven method of force curing the P Epoxy/Primer to the steel enables the installer to "pre-inspect" the joint prior to field joint application. This provides the assurance that the pipe is fully protected and it will not be displaced and exposed to corrosive contaminants during field joint installation.
<b>Packaging:</b>	Canusa P Epoxy/Primer is supplied in 170mL pre-measured kits. Contact Canusa representative for alternative kit sizes.
<b>Color:</b>	Black
<b>Volume Solids:</b>	100%
<b>Weight Solids:</b>	100%
<b>Mixing Ratio:</b>	(by volume) - 4 parts of base to 1 part of cure (by weight) - 5.3 parts of base to 1 part of cure
<b>Typical Coverage:</b>	see Epoxy Usage table on back page
<b>Specific Gravity:</b>	P Epoxy/Primer Base - 1.40 ± 0.03 (ASTM D 1475) P Epoxy/Primer Cure - 1.06 ± 0.02 (ASTM D 1475)
<b>Viscosity:</b>	P Epoxy/Primer Base - 43,000 ± 12,000 cps at 40°C (ASTM D2196 Brookfield RVT @ 10rpm) P Epoxy/Primer Cure - 750 - 1,200 cps (ASTM D2196 @ 25°C)
<b>Typical Thickness:</b>	6-9 mils (150-230 microns)
<b>Number of Coats:</b>	One
<b>Pot Life:</b>	20 minutes @ 23°C (73°F)
<b>Shelf Life:</b>	3 years @ 23°C, out of direct sunlight. Shelf life will be lesser at higher temperatures.
<b>Thinner:</b>	Do not dilute.
<b>Minimum Curing Temperature:</b>	10°C (50°F)

**Safety:** Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult CANUSA Material Safety Data Sheets and follow all local or national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance if swallowed. Avoid inhalation if possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only in well ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

## Applications

-  Oil & Gas
-  Offshore Pipelines
-  Repair & Rehab
-  High Temp
-  Girth-Weld Joints
-  Polypropylene

## Configurations

-  Brush Application
-  Pad Application
-  3-Layer
-  Sleeve Compatible

## Temperature Range

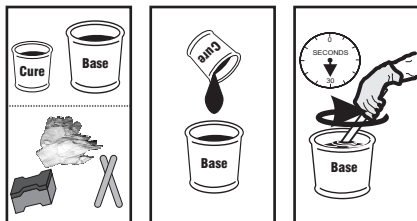
-  up to 140°C (284°F)

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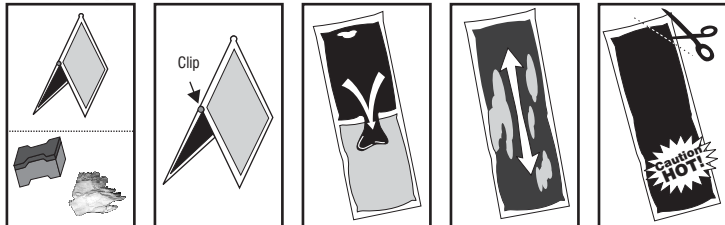
## Application

- 1) Prepare the pipe surface as recommended in the product specific Installation Guide.
- 2) Follow the mixing instructions that are contained within the epoxy packaging.

### 2A - Epoxy Bulk Quantities



### 2B - Epoxy BP



- 3) With a gloved hand, pour the combined mixture onto the pipe...
- 4) ...and begin spreading the epoxy primer (to a uniform thickness) circumferentially around the pipe surface using the applicator pad.
- 5) Use a wet film thickness gauge to ensure a correct, uniform thickness has been achieved all around the pipe.

## Epoxy Usage: 300mm (12") cutback and 150µm (6mils) epoxy thickness

Outside Pipe Diameter mm	in	Volume (mL) Required		Joints per 170mL Kit <sup>1</sup>
		Base	Cure	
115	4½	20	5	7
170	6⅝	28	7	5
230	8⅞	36	9	3
280	10¾	40	10	3
315	12¾	48	12	2
355	14	52	13	2
400	16	60	15	2
450	18	68	17	2
500	20	76	19	1
610	24	92	23	1
760	30	112	28	1
915	36	136	34	1
1060	42	156	39	½
1220	48	180	45	½
1420	56	212	53	½
1520	60	224	56	¼

Epoxy required for 300 mm / 12" cutback. For other cutbacks, divide by 12 and multiply by new cutback in inches

**Example:**  
200 mm (8") cutback on 610 mm diameter pipe

**base:** 92 ml x  $\frac{8}{12}$  = 62 ml base

**cure:** 23 ml x  $\frac{8}{12}$  = 16 ml cure

<sup>1</sup> Due to pot life limitations, it may be impractical to coat multiple joints with the same epoxy kit.

## How to Order

**Epoxy BP Unit:** BP Units include pre-measured quantities of P Epoxy/Primer Base and P Epoxy/Primer Cure in a bubble pak. Application Accessories (gloves and application pad) must be purchased separately.

**Epoxy BP Kit:** BP Kits include pre-measured quantities of P Epoxy/Primer Base and P Epoxy/Primer Cure in a bubble pak, a pair of latex gloves and an application pad.

**Bulk Accessories:** Bulk accessories (i.e. appl. access. kitsetc.) are available for easier field mixing and preparation.

## Product Designation<sup>3</sup>

## Package Contents\*

<b>P Epoxy/Primer BP Unit - 170mL</b>	136mL of P Epoxy/Primer Base, 34mL of P Epoxy/Primer Cure
<b>P Epoxy/Primer BP Kit - 170mL</b>	136mL of P Epoxy/Primer Base, 34mL of P Epoxy/Primer Cure, latex gloves, application pad
<b>Primer Appl. - BP Units Small Ø</b>	100 application pads, 2 pairs of latex gloves
<b>Primer Appl. - BP Units Large Ø</b>	200 application pads, 4 pairs of latex gloves

<sup>3</sup> Small diameter Ø represents joints completed with one installer. As a general rule, only one installer is required up to 18" (450mm) pipe sizes.

\* For large projects, joint specific pre-measured epoxy quantities (other than standard 170mL) will be considered.



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