

## Canusa S Primer

Wet epoxy for superior 3-layer corrosion protection

<b>Description:</b>	Canusa S Primer is a specially formulated 100% volume solids (solventless) two component epoxy.
<b>Recommended use:</b>	As a primer in a 3 layer polyethylene coating system for superior corrosion protection of field welded joints of steel pipes. The primer has extended pot life at high temperatures which allows for longer working time.
<b>Color:</b>	Black
<b>Volume Solids:</b>	100%
<b>Weight Solids:</b>	100%
<b>Mixing Ratio:</b>	(by volume) - 3.0 parts of S Primer base to 1 part of S Primer cure (by weight) - 4.6 parts of S Primer base to 1 part of S Primer cure
<b>Typical Coverage:</b>	20 sq.m./US gallon (215 sq.ft/US gallon) or 5.3 sq.m/litre (57 sq.ft/litre). This coverage is based on 6 mils of thickness & assuming 20% waste factor
<b>Specific Gravity:</b>	S Primer Base - $1.58 \pm 0.03$ S Primer Cure - $1.02 \pm 0.02$
<b>Viscosity:</b>	S Primer Base - $14,000 \pm 2,000$ cps @ 60°C, #7 spindle at 10 rpm S Primer Cure - $250 \pm 50$ cps @ 25°C, #3 spindle at 20 rpm
<b>Typical Thickness:</b>	4-6 mils (100-150 microns)
<b>Number of Coats:</b>	One
<b>Pot Life:</b>	140 minutes @ 23°C (73°F), 30 minutes @ 40°C (104°F)
<b>Shelf Life:</b>	3 years @ 23°C, out of direct sunlight. Shelf life will be lesser at higher temperatures.
<b>Flash Point:</b>	S Primer Base - $>93^{\circ}\text{C}$ (200°F) S Primer Cure - $>93^{\circ}\text{C}$ (200°F)
<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



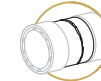
Offshore Pipelines



Repair & Rehab



High Temp



Girth-Weld Joints

### Configurations



Wet Epoxy



Brush Application



Pad Application



3-Layer



Sleeve Compatible

### Temperature Range



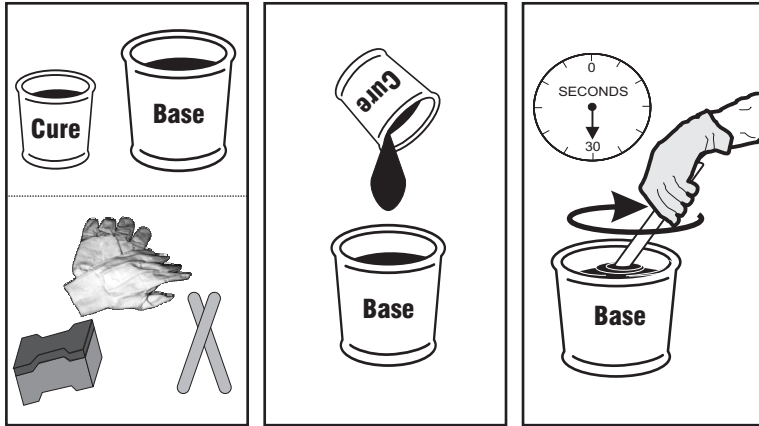
up to 80°C (176°F)

# Canusa S Primer

## 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.

### 2 - Epoxy CB



- 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: 600mm (24") sleeve and 150µm (6mils) epoxy thickness

Outside Pipe Diameter mm	in	Volume (mL) Required		Joints per 400mL	
		Base	Cure	US Gal of Base <sup>1</sup>	Kit <sup>2</sup>
115	4½	57	19	62	10
170	6 ⅝	84	28	42	6
230	8 ⅝	114	38	31	5
280	10¾	138	46	25	3
315	12¾	156	52	23	2
355	14	174	58	20	2
400	16	198	66	18	1½
450	18	222	74	16	1½
500	20	246	82	14	1
610	24	300	100	11	1
760	30	375	125	9	½
915	36	450	150	7	½
1060	42	522	174	6	½
1220	48	600	200	6	½
1420	56	699	233	5	¼
1520	60	744	244	4	¼

Epoxy required for 600 mm (24") sleeve width. For other sleeve widths, divide by 24 and multiply by new sleeve width in inches.

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

**base:** 300 ml x 8/24 = 100 ml base

**cure:** 100 ml x 8/24 = 33 ml cure

<sup>1</sup> Mixing ratio by volume of base to cure is 3.0 : 1. Therefore, for 1 US gallon of Base, 0.33 US gallons of cure will be required.

<sup>2</sup> Due to pot life limitations, it may be impractical to coat multiple joints with the same epoxy kit.

## How to Order

**Epoxy CB Unit:** CB Units include pre-measured quantities of S Primer Base in a metal can and S Primer Cure in a plastic bottle. Application Accessories (gloves, application pad and mixing sticks) must be purchased separately.

**Epoxy CB Kit:** CB Kits include pre-measured quantities of S Primer Base in a metal can, S Primer Cure in a plastic bottle, a pair of latex gloves, an application pad and two mixing sticks.

**Bulk Epoxy:** Bulk epoxy is available in US gallon quantities. The mixing ratio by volume of BASE to CURE is 3.0 : 1.

**Bulk Accessories:** Bulk accessories (i.e. appl. access. kits, dispensing pump, etc.) are available for easier field mixing and preparation.

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

### Package Contents\*

Units	Units	Units	Units	Units	Units	Units	Units
S Primer CB Unit - 400mL	300mL of S Primer Base, 100mL of S Primer Cure						
S Primer CB Kit - 400mL	300mL of S Primer Base, 100mL of S Primer Cure, latex gloves, application pad, mixing sticks						
S Primer Base - 1 US Gal	1 US gallon (3.79 L) of S Primer Base						
S Primer Base - 5 US Gal	5 US gallon (18.9 L) of S Primer Base						
S Primer Cure - 1 US Gal	1 US gallon (3.79 L) of S Primer Cure						
S Primer Cure - 5 US Gal	5 US gallon (18.9 L) of S Primer Cure						
Primer Appl. - CB Units Small Ø	100 application pads, 2 pairs of latex gloves, 100 mixing sticks						
Primer Appl. - CB Units Large Ø	200 application pads, 4 pairs of latex gloves, 200 mixing sticks						
Primer Appl. - BP Units Small Ø	100 application pads, 2 pairs of latex gloves						
Primer Appl. - BP Units Large Ø	200 application pads, 4 pairs of latex gloves						
Primer Appl. Acces. - Bulk Small Ø	100 12oz cups, 100 4oz cups, 2 pairs of latex gloves, 100 application pads, 100 mixing sticks						
Primer Appl. Acces. - Bulk Large Ø	100 26oz cups, 100 12oz cups, 2 pairs of latex gloves, 200 application pads, 100 mixing sticks						
Epoxy Dispensing Pump - 5 US Gal	Dispensing Pump designed for the 5 US gallon container of S Primer Base or S Primer Cure						

<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.

\* Latex gloves associated with Bulk Accessories are heavy duty and can be used for more than one joint.

\*\* For large projects, joint specific pre-measured epoxy quantities (other than standard 400mL) will be considered.



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Canusa warrants that the product conforms to its chemical and physical description and is appropriate for the use stated on the installation guide when used in compliance with Canusa's written instructions. Since many installation factors are beyond our control, the user shall determine the suitability of the products for the intended use and assume all risks and liabilities in connection therewith. Canusa's liability is stated in the standard terms and conditions of sale. Canusa makes no other warranty either expressed or implied. All information contained in this installation guide is to be used as a guide and is subject to change without notice. This installation guide supersedes all previous installation guides on this product. E&OE

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PDS-SPRIMER-rev014