



# New Guard Coatings Group

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# SIGMALINE™ 403 HS

## DESCRIPTION

Two-component, high-solids polyamine cured epoxy flow coating

## PRINCIPAL CHARACTERISTICS

- Reduces the frictional resistance of the inside of steel pipes for the transportation of purified natural gas
- High volume solids
- Good anticorrosive properties
- Meets API RP 5L2 fourth edition
- Meets the requirements of EN10301

## COLOR AND GLOSS LEVEL

- Redbrown
- Gloss

## BASIC DATA AT 20°C (68°F)

Data for mixed product	
<b>Number of components</b>	Two
<b>Mass density</b>	1.5 kg/l (12.1 lb/US gal)
<b>Volume solids</b>	78 ± 2%
<b>VOC (Supplied)</b>	Directive 1999/13/EC, SED: max. 165.0 g/kg max. 239.0 g/l (approx. 2.0 lb/US gal)
<b>Recommended dry film thickness</b>	50 - 100 µm (2.0 - 4.0 mils) depending on surface preparation
<b>Theoretical spreading rate</b>	15.6 m <sup>2</sup> /l for 50 µm (626 ft <sup>2</sup> /US gal for 2.0 mils)
<b>Dry to touch</b>	3.5 hours
<b>Overcoating Interval</b>	Minimum: 8 hours Maximum: 2 months
<b>Full cure after</b>	7 days
<b>Shelf life</b>	Base: at least 12 months when stored cool and dry Hardener: at least 12 months when stored cool and dry

### Notes:

- See ADDITIONAL DATA - Spreading rate and film thickness
- See ADDITIONAL DATA - Curing time
- See ADDITIONAL DATA - Spreading rate and film thickness

# SIGMALINE™ 403 HS

## RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

### Substrate conditions

- Steel; blast cleaned to ISO Sa 2½ or SSPC-SP-10, blasting profile (Rz) 30 – 80 µm (1.2 – 3.2 mils) (\*)
- During the curing time coated pipes should be protected against adverse weather conditions such as condensation, rain, fog and snow

Note: (\*) It must be noted that the main purpose of a flowcoat is not the anticorrosive protection, but the reduction of friction during the transport of gas. As such it is important to have a smooth finish. The applied DFT needs to be adjusted to the obtained blasting profile. We recommend to apply a nominal DFT which is always at least 20µm higher than the blasting profile (Rz). ISO 19840:2012 shall be used for the determination of DFT.

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### Substrate temperature and application conditions

- Ambient temperature during application should be between 5°C (41°F) and 40°C (104°F)
- Substrate temperature during application and curing should be above 5°C (41°F)
- Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
- Relative humidity during application and curing should not exceed 80%

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## INSTRUCTIONS FOR USE

### Mixing ratio by volume: base to hardener 80:20 (4:1)

- The temperature of the paint should preferably be above 5°C (41°F), otherwise extra thinner may be required to obtain application viscosity
- Adding too much thinner results in reduced sag resistance and slower cure
- Thinner should be added after mixing the components

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### Induction time

None

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### Pot life

3 hours at 20°C (68°F)

Note: See ADDITIONAL DATA – Pot life

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### Application

- Visco base: 5 - 10 Poise
- Visco hardener: 3 - 5 Poise
- Visco set: 4 - 7 Poise
- Weight solids: 79 ± 2%
- Ash content: 37 ± 2%
- Bucholz hardness: 104 ± 10



# SIGMALINE™ 403 HS

## Airless spray

### **Recommended thinner**

THINNER 21-06

### **Volume of thinner**

0 - 3%, depending on required thickness and application conditions

### **Nozzle orifice**

Approx. 0.48 - 0.64 mm (0.019 - 0.025 in)

### **Nozzle pressure**

16.0 - 22.0 MPa (approx. 160 - 220 bar; 2321 - 3191 p.s.i.)

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## Brush/roller

- Only for touch-up and spot repair
- Multicoat roller or brush application is not recommended. Maximum DFT achievable by brush or roller is 50 µm (2.0 mils)

### **Recommended thinner**

THINNER 21-06

### **Volume of thinner**

0 - 3%

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## Cleaning solvent

THINNER 90-53

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## ADDITIONAL DATA

Spreading rate and film thickness	
DFT	Theoretical spreading rate
50 µm (2.0 mils)	15.6 m <sup>2</sup> /l (626 ft <sup>2</sup> /US gal)
75 µm (3.0 mils)	10.4 m <sup>2</sup> /l (417 ft <sup>2</sup> /US gal)
100 µm (4.0 mils)	7.8 m <sup>2</sup> /l (313 ft <sup>2</sup> /US gal)

# SIGMALINE™ 403 HS

## Curing time for DFT up to 75 µm (3.0 mils)

Substrate temperature	Dry to touch	Dry to handle	Full cure
5°C (41°F)	9 hours	16 hours	21 days
10°C (50°F)	7 hours	14 hours	14 days
20°C (68°F)	3.5 hours	8 hours	7 days
25°C (77°F)	2.5 hours	6 hours	6 days
30°C (86°F)	2 hours	5 hours	5 days

### Notes:

- Adequate ventilation must be maintained during application and curing (please refer to INFORMATION SHEETS 1433 and 1434)
- During the curing period precautions must be taken to avoid contact of the coating with moisture, otherwise blushing may occur

## Pot life (at application viscosity)

Mixed product temperature	Pot life
5°C (41°F)	6 hours
10°C (50°F)	4 hours
20°C (68°F)	3 hours
30°C (86°F)	2 hours
40°C (104°F)	1 hour

## Product Qualifications

- SigmaLine 403 HS meets both requirements of API RP 5L2 fourth edition as well as BS EN 10301:2003
- The glass transition temperature (T<sub>g</sub>) of SigmaLine 403 HS is determined as 16°C (DSC according to ISO 11357-2:2013)
- SigmaLine 403 HS is suitable for dry sweet gas cargoes with a maximum service temperature range up to 120°C
- SigmaLine 403 HS is suitable for wet sour gas however at different temperature ranges. In the event of the cargo being wet sour gas, the composition, concentration etc. of the cargo will have to be provided in order for PPG to make a recommendation on the maximum temperature range

## SAFETY PRECAUTIONS

- For paint and recommended thinners see INFORMATION SHEETS 1430, 1431 and relevant Material Safety Data Sheets
- This is a solvent-borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eyes

## WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective and Marine Coatings to supply the same product on a worldwide basis. However, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances. Under these circumstances an alternative product data sheet is used.



# SIGMALINE™ 403 HS

## REFERENCES

• EXPLANATION TO PRODUCT DATA SHEETS	INFORMATION SHEET	1411
• SAFETY INDICATIONS	INFORMATION SHEET	1430
• SAFETY IN CONFINED SPACES AND HEALTH SAFETY, EXPLOSION HAZARD – TOXIC HAZARD	INFORMATION SHEET	1431
• SAFE WORKING IN CONFINED SPACES	INFORMATION SHEET	1433
• DIRECTIVES FOR VENTILATION PRACTICE	INFORMATION SHEET	1434
• SURFACE PREPARATION OF STEEL PIPES AND FITTINGS SHOP APPLICATION	INFORMATION SHEET	1492

## WARRANTY

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