High Build Bituminous Black Pipe Coating High Gloss Product Data Sheet

**Features**
A black bituminous based coating for good protection of steel pipe, tanks, flanges, bolts and other bare metal structures where a higher mil coverage is specified. This bituminous coating is effective for both indoor and outdoor storage. This can be applied to new and reconditioned pipe.

**Typical Uses**
Excellent exterior durability and adhesion over most steel surfaces. This can be used above and below grade.

**Physical Data**
- **Pencil Hardness (ambient cure)**: Soft to 4B
- **Adhesion (ASTM D 4541)**: 300 psi
- **Temperature resistance (non-immersion)**: 250°F Continuous, 300°F Non-continuous

**Theoretical weight solids**: 60%±2%
**Theoretical volume solids of mixed material**: 46%±2%
**Theoretical coverage of mixed gallon (1 mil)**: 738 sq. ft.
**Volatile Organic Content**: Unthinned ready to apply, 3.63 lbs./gal.

**Resistance**
DD-45 is designed for exposures to mild chemical fumes under typical atmospheric conditions.

**Exposure** | **Immersion** | **Spillage** | **Fumes** |
--- | --- | --- | --- |
Acidic | Not recommended | Poor | Fair |
Alkaline | Not recommended | Poor | Fair |
Solvents | Not recommended | fair | Good |
Salt water | Not recommended | Good | Excellent |
Water | Not recommended | Good | Excellent |

**Film Thickness (per coat)**
- Dry film thickness: 2.0 to 4.0 mils
- Wet film thickness: 4.0 to 7.0 mils
- Theoretical coverage: 738 sq. ft.@ 1 mils DFT

**Primer/Substrates**
DD-45 Coating may be applied directly to properly prepared steel substrates, weathered galvanized steel and concrete surfaces. All surfaces should be free of oil or dirt.

**Standard Black High Gloss Sheen**

**Shipping Data**
- **Flash Point: (Setaflash)**: > 100 °F
- **Shelf Life**: 3 years when stored inside at 40°F to 110°F.
- **DOT Classification**: UN1263, PAINT, 3, PG II

**Surface Preparation**
DD-45 Pipe Coating is designed to be used over surfaces that have been prepared in accordance with SSPC-SP2 Hand Tool Clean specification. In many cases High Pressured Water Blast will suffice.

**Mixing**
Mix DD-45 Coating well prior to application.

**Thinning**
Thinning is not required for most applications; however DD-45 may be thinned with up to 1 pint/gal. CC-86 is recommended for applications. For VOC control thin only with thinner #4.

02/18/13
DD-45 Product Data Sheet

Applications Conditions

<table>
<thead>
<tr>
<th>Minimum</th>
<th>Material 40°F</th>
<th>Surface 40°F</th>
<th>Ambient 40°F</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum</td>
<td>120°F</td>
<td>120°F</td>
<td>120°F</td>
</tr>
</tbody>
</table>

Special thinning and application procedures are required outside these temperatures. Surface temperatures should be 5°F above dew point to prevent condensation.

Application Equipment

**Conventional Spray:** Industrial sprayers such as DeVilbiss MBC or JGA and Binks 18 or 62 having double regulated pressure pot, 3/8' I.D. minimum material hose and a .070' I.D. fluid tip and air cap are recommended.

**Airless Spray:** Sprayer such as Graco’s Bulldog with a 30:1 ratio and a .035” to .080” tip is recommended. A 30 mesh inline filter is recommended.

**Brush:** Use medium brush; **Roller:** Application by roller is not recommended.

Drying Time

The following minimum times are based on 1.5 mils DFT and adequate air ventilation. Higher thickness and reduced air circulation increase drying times.

<table>
<thead>
<tr>
<th>Surface Temperature</th>
<th>To Touch</th>
<th>To Handle</th>
<th>To Recoat</th>
</tr>
</thead>
<tbody>
<tr>
<td>77°F</td>
<td>7-10 min.</td>
<td>20 min.</td>
<td>Overnight</td>
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<tr>
<td>Less at higher temperatures</td>
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</tbody>
</table>

Maximum Recoat

DD-45 Pipe Coating can be recoated with itself at any time by simply removing dirt and contamination of the existing coat.

Cleanup

Cleanup spill spatters and equipment using mineral spirits. Lacquer thinner or Thinner #4 for VOC control.

02/18/13

CAUTION: Read and follow all caution statements on this product data sheet and on the Material Safety Data Sheet for this product.

CONTAINS FLAMMABLE MATERIALS.

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6161 Maple Avenue St. Louis, MO. 63130  314.725.3400