

STOP JOINT

Medium density polyurethane filling mass

NATURE AND USE

Medium density, two component solvent free filling product, with polyurethane fast drying resins. The fillers included in the base component are already pre-dosed to reach the wished density: consequently, the field operations are easier and faster than when using three components products. StopJoint is formulated for coating of welding joints on-off shore of steel pipelines or as anticorrosion and shock absorbent coating of risers, spacer, used during pipelines laying, filler for anodes etc. The product fully cured has a water permeability extremely low and good resistance to cathodic disbonding; for this reason it is recommended for application in oceanic environment (sea-lines, etc.). Moreover, it has high resistance to abrasion, impact, chemical agents, sea water, etc., further to a good dimensional stability, keeping its properties unaltered even if exposed to thermal excursions. Excellent the adhesion on metal properly prepared. The product is compatible with other kind of protective coatings normally used on pipelines.

**Product qualified ENI in accordance with specification 20550.ENG.CPI.STD – Filler mass
on welded joints areas of offshore pipelines
Qualified SNAM for welded Joints filling on concrete weighted pipelines**

Higher Properties of the fully cured polymer

TEST DESCRIPTION AND REFERENCE	VALUE / RESULT
Compression (ASTM D 695):	≥ 45 Mpa
Sea water immersion for 1000h @ +18°C/+40°C:	no loss of properties; water absorption of irrelevant evidence (≤ 1%).
Corrosion resistance (ASTM B 117):	No attack
Impact resistance according to ENI 20550 PIP.COR.FUN. Specification Appendix "G "	No breaks, no cracks.
Resistance to temperatures changes according to ENI 20550 PIP.COR.FUN. Appendix "G "Specification:	No variation in any one dimension, No loss in properties.
Tensile Strenght (ASTM D 638):	≥ 11 Mpa (Average).
Thermal resistance / Dimensional stability according to ENI 20550 PIP.COR.FUN. Specification Appendix "G": (4h @ +135°C):	No variation in any of the 3 dimensions
Adhesion on sandblasted steel minimum RZ DIN roughness profile of 70 µm (ASTM D 4541):	≥ 10 Mpa
Adhesion on Polyethylene duly prepared (ASTM D 4541):	≥ 1,5 Mpa
Adhesion on Polypropylene duly prepared (ASTM D 4541):	≥ 1,5 Mpa
Adhesion on concrete (ASTM D 4541):	> 5 Mpa

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./ TEST DESCRIPTION AND REFERENCE	./ VALUE / RESULT
Cathodic disbonding for 28 days @ +23°C (ASTM G 8):	≤ 9 mm
Cathodic disbonding for 2 days @ +65°C (ASTM G 8):	≤ 9 mm
Thermal conductivity (UNI EN 12667:2002):	0,26 W/mK
Thermal resistance (UNI EN 12667:2002):	0,155 m2 K/W
Corrosion resistance to bacterial attacks according to ENI 20550 PIP.COR.FUN. Specification Appendix "G":	Pass.

TECHNICAL DATA



Specific Gravity A+B	kg/l	1,50 ± 0,02 @ +20°C
Solids by Weight and Volume:	%	100 ±- 2% A+B
Mixing Ratio by Weight:		100 parts of Base / 22 parts of Hardener
**Pot life @ +20°C:		30 seconds - 20 minutes on request
Exercise Temperature Range:		-20°C ÷ +120°C (Exposed in dry air and without Simultaneous mechanical stress)
Colour:		Greyish (other colours on request)*

* **Note:** Like all materials of the same nature and type also StopJoint polymerized film, when exposed in air in external ambient, due to the action of atmospheric agents (sun, rain etcetera) may undergo colour changing with chalking and tarnishing. These phenomena are only aesthetic ones and do not indicate a loss of the corrosion protection property from the coating as the characteristic of the film is not altered.

SUBSTRATE PREPARATION

Steel: Substrate clean, free from oils, greases and any contaminants. Minimum sandblasting of the Surface according to ISO 8501/1 to SA 2.5 for steel. Surface roughness must be RZ DIN ≥ 70 µm up to 200 µm according to ISO 8503

Remove dust with dry air jetting: final cleaning degree <Class 2 according to ISO 8502-3. Substrate always perfectly dry, free from traces of humidity.

Concrete: Seasoned, cleaned, free from oils, greases and any contaminant. Perform a light sandblasting to roughen the substrate, remove dust with dry air, substrate dry, free from traces of humidity.

Other substrates: Clean, free from oils, greases and pollutants and roughened.

PRODUCT PREPARATION

Homogenize separately the Base and the Hardener in their own supply container. The preparation of the mix for the application can be done by means of an automatic mixing equipment of the components or manually.
Application by injection/extrusion or by fall of the product, previously dosed and mixed, from the container.

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** The "POT LIFE" time of two components products (time within which it is possible to apply the paint mix of Base and Hardener), is exponentially dropped by the increase of product temperature.
Note: The use of a mix of paint (Base + Hardener) over the POT LIFE time is irreparably compromising all the properties of the coating film.**

APPLICATION DETAILS

Application:	Extrusion or casting in work forms of anti-adherent material placed around the welding joint
Thinning:	Do not Thin
Cleaning:	Wash the whole equipment immediately after use with Thinner PUR11
Hardening/De-moulding time @ 25°C:	≤ 5 minutes ÷ 3 – 4 hours on request
Full curing @ +25°C:	5-7 days
Ambient Temperature:	+5°C / +40 °C
Temperature of the product (suggested):	Base: +30°C/+35°C Hardener: +20°C/+45°C (Depending on the used application system: i.e. by manual pouring or automatic extrusion)
Temperature of the substrate:	>+5° / +10°C and always at least +3/+5°C above dew point
Humidity:	≤ 80 %
Obtainable thickness:	~ 10 – 500 mm
Theoretical use:	Kg/sqm ~ 15,0 at a dry film thickness of 10 mm

More info by writing to sales@industribrunostoppainipaints.com or by calling +39 030 9745116

HANDLING STORAGE AND SAFETY PRECAUTIONS

Warning: All handling and/or use activities of the material and its components must strictly refer to the given indications in the Safety Data Sheet (Base and Hardener). The following advices are stated by common sense and in good faith, they are uncompleted and do not substitute the content of each specific safety data sheet of the product.

Handling: The material must be used only by professional and qualified applicators suitably trained. All the operations involving the use of the product, must be carried on in compliance with all the relevant National Health, Safety & Environmental standards and regulations.

Precautions: When the product is used in enclosed areas (rooms, containers, vessels, etc.) it is imperative to use adequate means providing the necessary air circulation, to be granted during the whole application and coating polymerization time, also to avoid conditions open to potential explosion danger.

All electrical installations must always be grounded. Where explosion hazards exist, the workmen should be required to use only non-ferrous tools and wear conductive non-sparking shoes and clothing. Explosion and flame-proof equipment too are required.

Storage and transport: Keep far from flames, sparks or heat sources. Do not leave exposed under direct solar action. Store under shelter in original unopened packaging, in cool, dry and ventilated areas, at temperatures between +5°C and +35°C.

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Shelf life:

Base 12 months in the suggested storage conditions (original unopened packaging)
Hardener 6 months in the suggested storage conditions (original unopened packaging)

N.B.: Product for professional use only
and exclusively for the uses not regulated under CE Directive 2004/42/CE.

From August 24, 2023 the industrial or professional use of diisocyanates taken individually or in combination, in a concentration greater than 0.1% is allowed only after having received adequate training.

Refer to Material Safety Data Sheet



Access catalogues, data sheets and company presentations

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