

## STOPAQ® PASTE CZHT

### Product Information

**Product description:** Stopaq® Paste CZHT is a corrosion preventing moulding paste that is especially designed for high temperature applications. It adheres extremely well to steel and factory applied pipeline coatings like PE, PP and FBE.

Stopaq® Paste CZHT is a non-toxic, cold-applied, and visco-elastic moulding paste, based on a compound consisting of non-crystalline, low-viscosity, non-crosslinked (fully amorphous), non-reactive Polyisobutene.

Stopaq® Paste CZHT is viscous at the indicated operating temperatures. Due to its liquid nature it has a set of unique properties like cold-flow into all irregularities of the substrate and self-healing of the complete coating system. The compound does not cure and is unable to build up internal stress. Stopaq® Paste CZHT is fully resistant to water and has a very low gas- and water vapour permeability.

Stopaq® Paste CZHT requires an additional flexible mechanical protective layer like Stopaq® Outerwrap. This improves impact and indentation resistance of the coating system and supports the self-healing ability of small damages like dents and cuts. Optionally a rigid mechanical protective layer can be applied on top like Stopaq® Polyester or Stopaq® Outerglass Shield.

#### Features:

- Controlled cold flow providing permanent inflow into the finest pores of the substrate
- Conforms to irregular shapes
- Low surface tension; adheres on many types of dry substrates at a molecular level
- Adhesion based on vanderWaals forces
- Inert to ageing and weathering
- No osmosis or underfilm migration of moisture
- No cathodic disbondment
- Environmentally friendly, no health and safety hazards to humans
- Resistant to many chemicals like water, salts, acids, alkalis, polar solvents, etc. For additional information, please consult Stopaq B.V.

#### Benefits:

- Easy to apply
- Easy to control application
- Surface tolerant: no blasting techniques required, wire brushing is sufficient (ISO 8501-1: St 2)
- Can be moulded onto various types of irregular shaped objects
- Cathodic Protection (CP) of steel structures is not affected
- Guaranteed performance

### Application examples

**Flanges:** For protection against external corrosion and shaping of connection flanges, insulation flanges and blind flanges.

**Valves:** For protection against external corrosion and shaping of valves.

**Irregular shaped parts:** For protection against external corrosion and shaping of manhole covers, bolts & nuts, etc.

**Cad-welds:** For protection against external corrosion of welded CP-wire connections on underground pipelines (Pin-brazes) and underground steel structures protected by CP.

**Pipe coating repairs:** For protection against external corrosion and as filler for pipeline coating defects of e.g. 3LPE coated pipelines, prior to application of consecutive mechanical protective coating.

### Product properties of Stopaq® Paste CZHT

<b>Colour</b>	Green
<b>Density</b>	1.5 g/cm <sup>3</sup>
<b>Temperature ranges</b>	Service: - 45°C to +95°C Short term max.: +120°C
<b>Water absorption</b>	≤ 0.03% (ASTM D570)
<b>Glass transition temperature</b>	≤ - 65°C *)
<b>Specific electrical insulation resistance</b>	Rs <sub>100</sub> > 10 <sup>8</sup> Ω.m <sup>2</sup> *)
<b>Adhesion test</b>	Tested @+23°C and @+95°C on steel and PP plant coating *). Results on all substrates: – Coating leaves a film of corrosion preventive compound on the substrate
<b>Thermal ageing resistance and hot water immersion</b>	Dry ageing 100 days@+115°C and hot water immersion 100 days@+95°C *): – Results of adhesion test are identical to results obtained with non-aged material.
<b>Salt spray resistance</b>	Tested 720 h, 5% NaCl @ + 85°C (ASTM B117): No corrosion detected

### General order information

<b>Product</b>	Stopaq® Paste CZHT is available in sheets, packed in siliconized foil in cardboard boxes.
<b>Art. Nr.:</b> 6142	<b>Product dimensions and contents:</b> Sheet 2kg, 6 pcs./box, 288 pcs./pallet
<b>Handling</b>	Handle with care. Keep boxes upright.
<b>Storage</b>	Store indoor, clean and dry, away from direct sunlight in a cool place below +45°C. Unlimited shelf life.

Application instruction - Job preparation	
<b>Tools, equipment and auxiliaries</b>	<ul style="list-style-type: none"> <li>– Temperature probe, Dew point tester, High voltage holiday tester</li> <li>– Scissors, Knife, Measuring tape</li> <li>– Abrading pads, Wire brushes</li> <li>– SFL Substrate cleaner or Isopropyl alcohol, cas. nr. 67-63-0</li> <li>– Heating blanket or other suitable heating device</li> <li>– Personal protective gear</li> </ul>
<b>Additional coating materials</b>	Depending on type of application, various additional materials might be needed: <ul style="list-style-type: none"> <li>– Stopaq® Wrappingband CZHT</li> <li>– Stopaq® Outerwrap HTPP</li> <li>– Stopaq® Polyester</li> <li>– Stopaq® Outerglass Shield</li> </ul>
<b>High humidity</b>	Stopaq® Paste CZHT can be applied in a humid atmosphere. The substrate should be free from condensing water which can be reached by keeping the temperature at least 3°C above dew point.
<b>Work area and substrate</b>	The substrate should be dry, clean and protected against negative weather influences.
<b>Product conditions</b>	Stopaq® Paste CZHT should be dry and the temperature should preferably be above +50°C for the ease of application. To achieve this, the sheets can be heated with the heating blanket.

Application instruction - Surface preparation	
<b>General</b>	The area to be coated has to be clean, dry, and free from oil, grease and dust. All contamination including mill-scale has to be removed.
<b>Degreasing</b>	Degrease surfaces with isopropyl alcohol and e.g. a lint-free cloth.
<b>Salts and bacteria</b>	No need for additional cleaning.
<b>Condensation of water</b>	Prior to and during the application, the temperature of the substrate(s) must be at least 3°C above the dew point.
<b>Substrate temperature</b>	Temperature of the substrate should preferably be between +30 and +50°C. Preheating may be required.
<b>Steel</b>	Minimum requirement for surface preparation is St-2 according to ISO 8501-1. Roughness profile is not essential for adhesion.
<b>Other substrates</b>	De-gloss and degrease the surfaces by using an abrasive pad and isopropyl alcohol.
<b>Final check</b>	The substrates prepared for coating, should be clean, dry and free of dust according to ISO 8502-3, grade 3.

Application instruction - Brief version	
See specific Stopaq coating instructions for e.g. flanges, valves, coating repair, etc.	
<b>Boundaries in flange application</b>	Apply wraps of Stopaq® Wrappingband CZHT onto the pipe sections underneath and beyond the planned boundaries of Stopaq® Paste CZHT
<b>Application</b>	Apply lumps of mouldable paste around the shaped objects. Press the paste. Avoid air inclusions. After shaping, the surface should be smooth to enable proper application of additional materials.

Application instruction - Quality control	
<b>Visual inspection</b>	The appearance of Stopaq® Paste CZHT must look smooth and tight. Recommended minimum thickness on all details is 20 mm.
<b>Holiday detection</b>	Immediately after application of Stopaq® Paste CZHT, a holiday test should be carried out with a High voltage holiday tester at ≥15 kV. A brush probe is recommended. No further testing is required.

Application instruction - Mechanical protection	
<b>Mechanical protection</b>	Once applied, Stopaq® Paste CZHT should be protected against impacts, indentations, soil pressure and other influences by wraps of Stopaq® Outerwrap, optionally followed by Stopaq® Polyester or Stopaq® Outerglass Shield. Mechanical protection should overlap the boundaries of applied Paste CZHT.

Handling and commissioning	
<b>Exposure to loads</b>	Objects coated with Stopaq® Paste CZHT should not be exposed to loads e.g. from supports- or lifting equipment.
<b>Immersion or burying</b>	Immersion or burying is possible immediately after completion of the coating application. Consult data sheets for specific instructions of additional materials used. Backfill and compact with clean sand and filling material without sharp stones or hard lumps of soil.

Information	
<b>Documentation</b>	Extensive information is available on our website. Application instructions and other documentation can be obtained by contacting our head office, from our local distributor or by sending email to <a href="mailto:info@stopaq.com">info@stopaq.com</a>
<b>Certified staff</b>	Application of the described coating system should be carried out by certified personnel.



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