



# Protective & Marine Coatings

# PHENICON™ HS EPOXY PHENOLIC

Revised 04/2021 Issue 4

## PRODUCT INFORMATION

### PRODUCT DESCRIPTION

**PHENICON HIGH SOLIDS** is a VOC-compliant epoxy novolac phenolic coating formulated for use as an internal lining for tanks used to hold crude oil and most refined petroleum products including unleaded gasoline, MTBE, aromatic solvents, and most octane booster blending stocks. Also formulated for secondary containment uses.

- Light Blue contains Opti-Check OAP pigment technology for rapid holiday detection with safe blue light inspection lamps.
- Chemical Resistant
- Low temperature hardener available for applications from 1.6°C (35°F) minimum to 27°C (80°F) maximum

### PRODUCT CHARACTERISTICS

<b>Finish:</b>	Semi-Gloss
<b>Colour:</b>	Off White, Light Grey, Light Blue
<b>Volume Solids:</b>	75% ± 2%, mixed
<b>Weight Solids:</b>	86% ± 2%, mixed
<b>VOC (calculated):</b>	<250 g/L; 2.08 lb/gal, mixed
<b>Mix Ratio:</b>	4:1 by volume

#### Recommended Spreading Rate per coat:

	Minimum	Maximum
<b>Wet microns (mils)</b>	<b>175 (7.0)</b>	<b>200 (8.0)</b>
<b>Dry microns (mils)</b>	<b>125 (5.0)</b>	<b>150 (6.0)</b>
<b>~Coverage m<sup>2</sup>/L (sq ft/gal)</b>	<b>6 (240)</b>	<b>5 (200)</b>

*NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.*

#### Drying Schedule @ 175 microns (7.0 mils wet):

	@ 13°C/55°F	@ 25°C/77°F 50% RH	@ 49°C/120°F
<b>Standard Hardener</b>			
<b>To touch:</b>	7 hours	3 hours	1 hour
<b>To recoat:</b>			
<b>minimum:</b>	48 hours	18 hours	4 hours
<b>maximum:</b>	30 days	30 days	30 days
<b>Cure to service:</b>	14 days	7 days	3 days
<b>Pot Life:</b>	4 hours	2 hours	30 minutes
<b>Induction time:</b>	30 minutes	15 minutes	None

#### Drying Schedule @ 175 microns (7.0 mils wet):

	@ 1.6°C/35°F	@ 13°C/55°F	@ 25°C/77°F 50% RH
<b>Winter Hardener</b>			
<b>To touch:</b>	12 hours	4 hours	2 hours
<b>To recoat:</b>			
<b>minimum:</b>	24 hours	18 hours	12 hours
<b>maximum:</b>	30 days	30 days	30 days
<b>Cure to service:</b>	7 days	5 days	3 days
<i>If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent.</i>			
<b>Pot Life:</b>	4 hours	2 hours	1 hour
<b>Induction time:</b>	15 minutes	None	None

<b>Shelf Life:</b>	36 months Store indoors at 4.5°C (40°F) to 38°C (100°F).
<b>Flash Point:</b>	27°C (80°F), PMCC, mixed
<b>Thinning:</b>	Not recommended
<b>Cleanser:</b>	No. 5

### RECOMMENDED USES

- Internal tank lining for most petroleum products such as: crude oil, unleaded gasoline, most aromatic solvents, motor fuels, alkalis, and brines.
- Secondary containment.
- Heavy duty exterior structural coating
- Low temperature hardener not recommended for use at application temperatures above 27°C (80°F)
- Acceptable for use with cathodic protection systems
- Nuclear Power Plants
- Nuclear fabrication shops
- DOE Nuclear Fuel Facilities
- DOE Nuclear Weapons Facilities
- This product meets specific design requirements for non-safety related nuclear plant applications in Level II, III and Balance of Plant, and DOE nuclear facilities\*.

\* Nuclear qualifications are NRC license specific to the facility. (full compliance with the performance and purity requirements of EI Standard 1541 for Aviation Fuel Storage - replacement for obsolete MIL-PRF-4556F specification) as well as a wide range of solvents.

### PERFORMANCE CHARACTERISTICS

Test Name	Test Method	Results
<b>Fuel Contribution*</b>	NFPA 259	5233 btu/lb
<b>Radiation Tolerance*</b>	ASTM D4082-10 (2017)	Pass at 177.5 microns (7.1 mils) & 247.5 microns (9.9 mils)
<b>Surface Burning*</b>	ASTM E84-18b	Flame Spread Index 15; Smoke Development Index 35 (at 312.5 microns or 12.5 mils)

\*Substrate: Steel

### RESISTANCE GUIDE

#### IMMERSION (Ambient temperature)

- Alkalies..... Recommended
- Crude oil..... Recommended
- Diesel fuel / DEF..... Recommended
- Lubricating oils..... Recommended
- Fuel oils..... Recommended
- Aromatic solvents..... Recommended
- Hi-aromatic gasoline..... Recommended
- Ethanol gasohol..... Recommended
- MTBE, ETBE, TAME..... Recommended
- Ether/fuel blends (reformed gas)..... Recommended
- Acids..... Recommended\*
- Methanol, ethanol, or blends..... Recommended\*\*
- Aviation Gasoline/Jet Fuel..... Recommended

#### SECONDARY CONTAINMENT (Immersion service up to 72 hours)

- Alkalies..... Recommended
- Crude oil..... Recommended
- Diesel fuel / DEF..... Recommended
- Lubricating oils..... Recommended
- Fuel oils..... Recommended
- Aromatic solvents..... Recommended
- Hi-aromatic gasoline..... Recommended
- Ethanol gasohol..... Recommended
- MTBE, ETBE, TAME..... Recommended
- Ether/fuel blends (reformed gas)..... Recommended
- Dilute acids..... Recommended
- Methanol, ethanol, or blends..... Recommended
- Aviation Gasoline/Jet Fuel..... Recommended

Epoxy coatings may darken or yellow following application and curing.

\* Consult your Sherwin-Williams representative for specific application, temperature, concentration, and exposure recommendations.

\*\* Not recommended when using Low Temperature Hardener



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## PRODUCT INFORMATION

### RECOMMENDED SYSTEMS

		Dry Film Thickness / ct.	
		Microns	(Mils)
<b>Steel:</b>			
2 cts.	Phenicon HS Epoxy Phenolic	(125-150)	5.0-6.0
<b>Steel:</b>			
1 ct.	Phenicon HS Flake Filled	(125-150)	5.0-6.0
1-2 cts.	Phenicon HS Epoxy Phenolic	(125-150)	5.0-6.0
<b>Steel, with hold primer:</b>			
1 ct.	Copoxy Shop Primer	(25-40)	1.0-1.5
2 cts.	Phenicon HS Epoxy Phenolic	(125-150)	5.0-6.0
<b>Concrete, smooth:</b>			
2 cts.	Phenicon HS Epoxy Phenolic	(125-150)	5.0-6.0
<b>Concrete, rough:</b>			
1 ct.	Corobond 100 Epoxy Primer/Sealer	(100-150)	4.0-6.0
1-2 cts.	Kem Cati-Coat HS Epoxy Filler/Sealer as required to fill voids and provide a continuous substrate	(250-500)	10.0-20.0
1-2 cts.	Phenicon HS Epoxy Phenolic	(125-150)	5.0-6.0

The systems listed above are representative of the product's use, other systems may be appropriate.

### DISCLAIMER

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

### SURFACE PREPARATION

Minimum recommended surface preparation:

Iron & Steel:	
Immersion	BS EN ISO 8501-1:2007 Sa2½ 50 micron (2 mil) profile
Concrete & Masonry:	
Immersion	SSPC-SP13/NACE 6 or ICRI No. 310.2, CSP 2-3

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Refer to product Application Bulletin for detailed surface preparation information.

#### Surface Preparation Standards

Condition of Surface	BS EN ISO 8501-1:2007	Swedish Std. SIS055900	SSPC	NACE
White Metal	Sa 3	Sa 3	SP 5	1
Near White Metal	Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	Sa 2	SP 6	3
Brush-Off Blast	Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	C St 2	C St 2	SP 2	-
Pitted & Rusted	D St 2	D St 2	SP 2	-
Rusted	C St 3	C St 3	SP 3	-
Power Tool Cleaning	D St 3	D St 3	SP 3	-
Pitted & Rusted	D St 3	D St 3	SP 3	-

### APPLICATION CONDITIONS

Temperature: (air and surface)

Standard Hardener: 13°C (55°F) minimum, 49°C (120°F) maximum

Winter Hardener: 1.6°C (35°F) minimum, 27°C (80°F) maximum

Material must be mixed at 13°C (55°F) minimum

At least 2.8°C (5°F) above dew point

Relative humidity: 85% maximum

Refer to product Application Bulletin for detailed application information.

### ORDERING INFORMATION

Packaging:	18.9L (5 gallons) mixed
Part A:	15.1L (4 gallons) in a 20L (5 gallon) container
Part B:	3.78L (1 gallon)
Weight:	1.5 Kg/L, mixed ; (12.45 ± 0.2 lb/gal)

### SAFETY PRECAUTIONS

Refer to the SDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

### WARRANTY

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.



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## APPLICATION BULLETIN

### SURFACE PREPARATIONS

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

#### Iron & Steel (immersion service)

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Near White Metal Blast Cleaning per BS EN ISO 8501-1:2007 Sa2½. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (50 microns / 2 mils). Remove all weld spatter and round all sharp edges. Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

#### Iron & Steel (atmospheric service)

Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per BS EN ISO 8501-1:2007 Sa2. For better performance, use Near White Metal Blast Cleaning per ISO 8501-1 Sa2½. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (50 microns / 2 mils). Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

#### Concrete and Masonry

For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2, CSP 2-3. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 24°C (75°F). Remove all loose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910. Primer required.

#### Follow the standard methods listed below when applicable:

ASTM D4258-05(2017) Standard Practice for Cleaning Concrete.  
ASTM D4259/18 Standard Practice for Abrading Concrete.  
ASTM D4260/05(2017) Standard Practice for Etching Concrete.  
ASTM F1869-16a Standard Test Method for Measuring Moisture Vapour Emission Rate of Concrete.  
SSPC-SP 13/Nace 6 Surface Preparation of Concrete.  
ICRI No. 310.2 Concrete Surface Preparation.

#### Concrete, Immersion Service:

For surface preparation, refer to SSPC-SP13/NACE 6, Section 4.3.1 or 1.3.2 or ICRI No. 310.2, CSP 2-3.

#### Surface Preparation Standards

Condition of Surface	BS EN ISO			
	8501-1:2007	Swedish Std. SIS055900	SSPC	NACE
White Metal	Sa 3	Sa 3	SP 5	1
Near White Metal	Sa 2.5	Sa 2.5	SP 10	2
Commercial Blast	Sa 2	Sa 2	SP 6	3
Brush-Off Blast	Sa 1	Sa 1	SP 7	4
Hand Tool Cleaning	Rusted C St 2	C St 2	SP 2	-
	Pitted & Rusted D St 2	D St 2	SP 2	-
Power Tool Cleaning	Rusted C St 3	C St 3	SP 3	-
	Pitted & Rusted D St 3	D St 3	SP 3	-

### APPLICATION CONDITIONS

Temperature: (air and surface)

Standard Hardener: 13°C (55°F) minimum, 49°C (120°F) maximum

Winter Hardener: 1.6°C (35°F) minimum, 27°C (80°F) maximum

Material must be mixed at 13°C (55°F) minimum  
At least 2.8°C (5°F) above dew point

Relative humidity: 85% maximum

### APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Thinning .....Not recommended

Cleaner .....No. 5

#### Airless Spray:

Pressure.....3000 psi minimum

Hose.....3/8" - 1/2" ID

Tip .....0.17" - .021"

Filter.....60 mesh

#### Conventional Spray:

Gun .....Binks 95

Tip and Needle.....66/65

Air Cap .....65 PR

Atomization Pressure.....65-75 psi

Fluid Pressure.....15-20 psi

#### Brush:

Brush.....Nylon/Polyester or Natural Bristle

#### Roller:

Cover .....3/8" woven with solvent resistant core

If specific application equipment is not listed above, equivalent equipment may be substituted.



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## APPLICATION BULLETIN

### APPLICATION PROCEDURES

Surface preparation must be completed as indicated.

**Mixing Instructions:** Mix contents of each component thoroughly, by using low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine 4 parts by volume of Part A with 1 part by volume of Part B. Thoroughly agitate the mixture with power agitation. Allow the material an induction time as indicated. Re-stir before use.

Apply paint at the recommended film thickness and spreading rate as indicated below:

#### Recommended Spreading Rate per coat:

	Minimum	Maximum
Wet microns (mils)	175 (7.0)	200 (8.0)
Dry microns (mils)	125 (5.0)	150 (6.0)
~Coverage m <sup>2</sup> /L (sq ft/gal)	6 (240)	5 (200)

*NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.*

#### Drying Schedule @ 175 microns (7.0 mils wet):

Standard Hardener	@ 13°C/55°F	@ 25°C/77°F 50% RH	@ 49°C/120°F
To touch:	7 hours	3 hours	1 hour
To recoat:			
minimum:	48 hours	18 hours	4 hours
maximum:	30 days	30 days	30 days
Cure to service:	14 days	7 days	3 days
Pot Life:	4 hours	2 hours	30 minutes
Induction time:	30 minutes	15 minutes	None

#### Drying Schedule @ 175 microns (7.0 mils wet):

Standard Hardener	@ 1.6°C/35°F	@ 13°C/55°F	@ 25°C/77°F 50% RH
To touch:	12 hours	4 hours	2 hours
To recoat:			
minimum:	24 hours	18 hours	12 hours
maximum:	30 days	30 days	30 days
Cure to service:	7 days	5 days	3 days
<i>If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent.</i>			
Pot Life:	4 hours	2 hours	1 hour
Induction time::	15 minutes	None	None

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

### CLEAN UP INSTRUCTIONS

Clean spills and spatters immediately with Cleanser No. 5. Clean tools immediately after use with Cleanser No. 5. Follow manufacturer's safety recommendations when using any solvent.

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### PERFORMANCE TIPS

Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.

When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.

Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.

Reduction of material will affect film build, appearance, and adhesion.

Do not mix previously catalyzed material with new.

Do not apply the material beyond recommended pot life.

In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with reducer 255-C-005

Low temperature hardener recommended for applications below 13°C (55°F).

Low temperature hardener not recommended for use at application temperatures above 27°C (80°F)

Use of low temperature hardener may cause accelerated yellowing of the coating.

Do not use low temperature hardener for immersion service in methanol, ethanol, or blends.

Excessive film build, poor ventilation, and cool temperatures may cause solvent entrapment and premature coating failure.

**For Immersion Service:** (if required) Holiday test in accordance with ASTM D5162 for steel, or ASTM D4787 for concrete.

Guidance on techniques and required equipment to inspect a coating system incorporating Opti-Check OAP Technology can be found in SSPC-TU 11.

Refer to Product Information sheet for additional performance characteristics and properties.

### SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

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### WARRANTY

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