



FLOWLINER™ 337-96 S

EPOXY FLOW COAT

Revised 07/2023 Issue 1

PRODUCT DESCRIPTION

A 2-pack epoxy coating.

- Provides a very smooth and mechanically robust coating to improve gas flow rates
- Provides excellent corrosion protection during transportation and intermediate storage of the single pipes
- Easy application by airless spray pipe lining equipment

RECOMMENDED USE

Can be used as an internal lining for gas pipelines for conveyance of non-corrosive gas.

PRODUCT TECHNICAL DATA

Volume Solids:	61 ± 2% (ISO 3233-3)
Weight Solids:	76 ± 2%
VOC:	341 g/l determined practically in accordance with Protective Coatings Directive of German Paint Industry Association (VdL-RL 04). 409 g/l calculated from formulation to satisfy EC Solvent Emissions Directive. 288 g/kg calculated from formulation to satisfy EC Solvent Emissions Directive (UK).
Colours:	Redbrown Finish: Glossy (approx. 60 gloss units / 60°-angle according to ISO 2813)
Flash Point:	Base: 23°C, Hardener: 30°C.
Cleaner/Thinner:	Thinner E+B (for cleaning). Thinner E+B for thinning with max. 5% to adapt the viscosity. We recommend not to thin Flowliner™ 337-96 S. Thinning will affect VOC compliance, sag tolerance and dry film thicknesses.
Pack Size:	A two component material supplied in separate containers to be mixed prior to use: 20.7 kg (14.5 litre) unit when mixed. Volume will vary with colours and density.
Mixing Ratio:	100 parts base to 15 parts hardener by weight. 100 parts base to 24 part hardener by volume.
Density:	1.42 kg/l (may vary with colours).
Shelf Life:	2 years from date of manufacture, stored in originally sealed containers in a cool and dry environment.

Recommended Application Methods:

Airless Spray, Brush, Roller

Typical Thickness:

	Recommended Spreading Rate Per Coat	
	Typical	Maximum Sag
Dry	80 µm	150 µm
Wet	131 µm	246 µm
Theoretical Consumption*	0.186 kg/m ² 0.131 l/m ²	
Theoretical Coverage*	5.37 m ² /kg 7.63 m ² /l	

* This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment.

Pot Life:

+ 20°C	+ 30°C
8 hours	3 hours

Pot life is dependent on temperature and volume.



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AVERAGE DRYING TIMES

For 80 µm Dry Film Thickness:

	+ 20°C
Dust dry (Drying Stage 1*)	45 min
Dry to touch	3.5 hours
Dry to handle (Drying Stage 6*)	12 hours

*ISO 9117

Final cure: 1 week, depending on film thickness and temperature. These figures are given as a guide only. Factors such as air movement, film thickness and humidity must also be considered.

APPROVALS & ENDORSEMENTS

Approved and certified according to the standards API RP 5L2, ISO 15741 and EN 10301.

SURFACE PREPARATION

Ensure surfaces to be coated are clean, dry and free from all surface contamination such as oil, grease, dirt and corrosion products to achieve satisfactory adhesion.

Steel surfaces shall be blast-cleaned to Sa 2½ according to ISO 8501-1 (ISO 12944-4).

Average surface profile Rz = 25 - 60 µm.

MIXING

Stir component A very thoroughly using a mechanical paint mixer (start slowly, then increase up to approx. 300 rpm). Add component B carefully and mix both components very thoroughly (including sides and bottom of the container). Mix for at least 3 minutes until a homogeneous mixture is achieved. We recommend to fill the mixed material into a clean container and mix again shortly as described above to avoid incorrect mixing. During mixing and handling of the materials always wear protective goggles, suitable gloves and other protective clothing.

If using plural feed airless equipment (automatic dosage) a dosage control shall be installed to monitor correct mixing ratio.

Note: Mixed material should be stirred once per hour to avoid settling out.

APPLICATION CONDITIONS

Substrate temperature shall be above + 10°C and at least 3°C above the dew point.

Material temperature shall be above + 20°C.

Relative air humidity shall be below 80%.

APPLICATION EQUIPMENT

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

Airless Spray

Unit: Efficient airless equipment (transmission ratio > 45 : 1)

Tip Size: 0.33 – 0.91 mm (0.015 – 0.036 inch)

Fan Angle: ≥ 80°

Operating Pressure: min. 180 bar (2600 psi)

The airless spray details given above are intended as a guide only.

Details such as fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen. However, the operating pressure should be the lowest possible consistent satisfactory atomisation.

As conditions will vary from job to job, it is the applicators responsibility to ensure that the equipment in use has been set up to give the best results.

If in doubt consult Sherwin-Williams customer service.

Brush and Roller

Suitable only for the repair of small areas.

Clean and prepare damaged areas by sanding or light blasting of areas to be coated and ensure thorough removal of dust. Then overcoat as soon as possible. Under special circumstances up to 5% Thinner E+B may be added.



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RECOMMENDED SYSTEMS

Steel

1 x Flowliner™ 337-96 S

ADDITIONAL NOTES

Drying times, curing times and pot life should be considered as a guide only.

Temperature resistance:

Dry heat up to + 120°C, short term up to + 300°C.

In case of higher temperatures consult Sherwin-Williams customer service.

Numerical values quoted for physical data may vary slightly from batch to batch.

HEALTH & SAFETY

Consult Product Health and Safety Data Sheet for information on safe storage, handling and application of this product.

WARRANTY

Whilst all statements made about our products (whether in this data sheet or otherwise) are correct and accurate to the best of our knowledge, we have no control over the quality or the condition of the substrate, the application conditions or the many other factors affecting your use and application of our product.

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