Bergolin Pipe Coating 6E3500

Series 6E3500 · Solvent-free, phenol-free 2K flow coat for friction-reducing internal coating of steel pipes

01 PRODUCT DESCRIPTION

Bergolin Pipe Coating 6E3500 is a pigmented, solvent-free and phenol-free two-component liquid plastic for the internal coating of steel pipes. Used as a friction-reducing flow coat, it forms a highly abrasion-resistant, dense and ultra-smooth surface that reduces friction and turbulence and thereby increases the gas flow rate. Its high area performance allows economical application even for long pipe lengths. The system is short-term temperature-resistant up to 250 °C and is suitable for gas transport and pipeline systems, e.g. for H_2, CO_2 and N_2.

02 PRODUCT PROPERTIES

Binder system	Epoxy resin
Hardener system	Bergolin Hardener 7E3800
Cleaning thinner	EP Thinner 5E403
Characteristics	Solvent-free · Phenol-free · Extremely smooth surface · Very high abrasion resistance · $H_2/CO_2/N_2$ ready · Short-term up to 250 °C
Color shade	Oxide red (further color shades on request)
Gloss	Glossy
Shelf life	12 months in the unopened original container at +4 °C to +40 °C. Protect from frost and moisture.
Approvals and specifications	Tested to ISO 15741:2016-11 (friction-reducing coatings for internal coating of on-/offshore steel pipelines, non-corrosive gases) | API RP 5L2:2002-07 (internal coating of line pipe for non-corrosive gas transmission) | DIN EN 10301 (steel tubes/fittings, internal coating to reduce friction)

Property	Comp. A	Comp. B	Mixture
Density · DIN EN ISO 2811-1 · +20 °C *¹	Approx. 1.41 g/cm³	Approx. 1.07 g/cm³	Approx. 1.34 g/cm³
VOC content · IE Directive 2010/75/EU *¹	Approx. 21.60 g/l	Approx. 1.95 g/l	Approx. 16.08 g/l
Solid content (wt.-%) · SDS *¹	Approx. 98.50 %	Approx. 99.81 %	Approx. 98.80 %
Viscosity · DIN EN ISO 2555 · +20 °C *¹	Approx. 1,400 mPas	Approx. 1,200 mPas	Approx. 1,300 mPas

*¹ *Depending on color shade*

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03 APPLICATION

The following information may vary depending on the application. Please contact your direct contact person for more detailed information.

Substrate	Steel (further substrates on request)
Surface preparation	Ensure sufficient load-bearing capacity before application. Surface preparation to EN ISO 12944-4. Free from weld spatter, pores, overlaps, burrs, grease, oil and dirt. Blast-clean to Sa 2½, mean roughness Rz approx. 30–70 µm (G or working mixture GS).
Mixing ratio	100 : 29 by weight | 100 : 40 by volume
Theoretical consumption	WFT: approx. 67 g/m² (50 µm) | approx. 107 g/m² (80 µm) | approx. 134 g/m² (100 µm) DFT: approx. 68 g/m² (50 µm) | approx. 109 g/m² (80 µm) | approx. 137 g/m² (100 µm)
Film thickness	Min. 50 µm DFT
Application method	2-K airless spray unit
Application conditions	**Air temperature** +8 °C to +40 °C **Relative humidity** max. 90 % **Surface temperature** min. +8 °C **Dew point** min. 3 °C below surface temperature
Pot life[*2]	Approx. 30 min
Working time[*2]	Approx. 16 min | DIN EN ISO 9514
DRYING[*2]	
Forced drying	Tack-free: approx. 50 min at 50 °C

[*2] *Values are based on laboratory measurements at +20 °C. Lower temperatures slow down drying; higher temperatures accelerate it.*

Note on epoxy resin: During curing, epoxy resin is sensitive to moisture. Exposure to moisture may lead to the formation of a carbamate layer (white spots). This has a purely visual effect. Affected areas can be treated with a 10–20 % citric acid solution.

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04 NOTE

This product data sheet supersedes all previously published product data sheets. The information contained herein is based on practical experience under standard conditions and assumes proper storage and processing. Substrates, materials and working conditions may vary. Therefore, no warranty or liability can be derived from the information contained in this document or from verbal consultation. It is the buyer's responsibility to verify the product's suitability for the intended use. Preliminary trials are recommended. The relevant legal regulations, the leaflets of the BG RCI and the accident prevention regulations of the responsible employers' liability insurance association must be observed. In all other respects, our General Terms and Conditions of Sale and Delivery apply.

MODIFIED BY
20.08.2026 – Martin Krull, Head of Laboratory

APPROVED BY
20.08.2026 – Stefan Eisenmenger, Product Management