STEOPOX 248-2 HCB Multicolor 6E248-2

Series 6E248 · Conductive internal coating for steel tanks

01 PRODUCT DESCRIPTION

STEOPOX 248-2 HCB Multicolor 6E248-2 is a highly chemical-resistant, solvent-free and conductive (ESD) two-component liquid plastic for the internal coating and internal preservation of steel tanks in the mineral oil and chemical industry. The system is designed for durable corrosion and chemical protection of storage tanks and can be applied in a single coat directly to steel (DTM) without a primer. It forms a dense, pore-free and firmly adhering film with high resistance to chemical exposure. The conductive properties ensure the controlled dissipation of electrostatic charges and increase operational safety. STEOPOX 248-2 HCB Multicolor 6E248-2 is repairable and recoatable, thus enabling economical maintenance of already coated surfaces. The system is officially approved (DIBt) as an internal coating for steel tanks for the storage of water-hazardous liquids.

02 PRODUCT PROPERTIES

Binder system	Epoxy resin
Hardener system	Bergolin EP Hardener 7E248-2
Cleaning thinner	EP Thinner 5E403
Characteristics	Solvent-free · Highly chemical-resistant · Conductive (ESD) · Direct-toMetal · Repairable & recoatable
Color shade	Black, grey (further color shades on request)
Gloss	Glossy
Shelf life	18 months in the unopened original container at +4 °C to +40 °C. Protect from frost and moisture.
Mechanical resistance	Shore D hardness: 70
Chemical resistance	Crude oils, diesel, petrol, HVO, jet fuel, caustic solutions, alkalis, dilute organic and inorganic acids (further media on request)
Thermal resistance	Up to approx. +100 °C (dry heat), briefly approx. +130 °C | up to approx. +40 °C (moist heat and water)
Electrical resistance	At 1,000 µm: $< 1 \times 10^8$ Ω
Container size comp. A	10 kg (further container sizes on request)
Container size comp. B	2.2 kg (further container sizes on request)
Approvals	General building authority approval / General type approval by DIBt (German Institute for Building Technology) as internal coating for steel tanks for the storage of water-hazardous liquids

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Property	Comp. A	Comp. B	Mixture
Density · DIN EN ISO 2811-1 · +20 °C *1	Approx. 1.460 g/cm³	Approx. 1.030 g/cm³	Approx. 1.30 g/cm³
VOC content · IE Directive 2010/75/EU *1	Approx. 0 g/l	Approx. 140.08 g/l	Approx. 31.49 g/l
Solid content (wt.-%) · SDS *1	Approx. 95 %	Approx. 87 %	Approx. 93.5 %
Viscosity · DIN EN ISO 2555 · +20 °C *1	Approx. 8,000 mPas	Approx. 3,500 mPas	Approx. 5,000 mPas

*1 *Depending on color shade*

03 APPLICATION

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

Substrate	Steel, zinc/aluminium, cement concrete/screed (further substrates on request)
Surface preparation	Ensure sufficient load-bearing capacity before application. **Steel:** 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. 50–70 µm. **Optional** primer: 1 × 30 µm Tenaxon T 569, consumption approx. 100 g/m² at 30 µm DFT. **Zinc/aluminium:** Degrease, mechanically roughen or sweep-blast. Primer: 1 × 30 µm Tenaxon T 569, consumption approx. 100 g/m² at 30 µm DFT. **Cement concrete/screed:** Surfaces must be firm, clean, free from grease, oil, wax, sand, dust and release agents, with good grip, load-bearing and free from standing water. Primer: Steopox 220, consumption approx. 300–500 g/m² depending on absorbency; if required, broadcast with kiln-dried quartz sand 0.1–0.3 mm.
Mixing ratio	100 : 22 by weight | 100 : 31 by volume
Mixing	Stir both components separately and homogenise if necessary. Pour component B into the container of component A and mix with an electric stirrer for at least 3 min at max. 700 rpm. Transfer into a clean container and mix again thoroughly for approx. 1 min.
Theoretical consumption	139 g/m² per 100 µm WFT | 149 g/m² per 100 µm DFT
Film thickness	Max. 500 µm DFT | max. 500 µm WFT per coat
Application method	Brush / block brush · Airless spraying · Trowel
Application conditions	**Air temperature** +8 °C to +30 °C **Relative humidity** max. 85 % **Surface temperature** min. +8 °C **Dew point** min. 3 °C below surface temperature For airless spraying: material and equipment temperature +20 °C to +25 °C.
Pot life*2	Approx. 40 min
Working time*2	Approx. 30 min

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Recoating interval (with itself)	Min. 16 h at +20 °C | min. 48 h at +10 °C | max. 24 h at +20 °C. After the maximum recoating time has elapsed, mechanical surface preparation (e.g. sanding or sweep-blasting) is required.
DRYING	
Dust-dry (TG 1)	Approx. 6 h at +20 °C | approx. 8 h at +10 °C
Walkable / sandable	Approx. 16 h at +20 °C | approx. 48 h at +10 °C
Fully cured (mech. & chem.)	Approx. 3 days at +20 °C | approx. 7 days at +10 °C
Compatible systems	Primer steel and zinc/aluminium: Tenaxon T 569 (3E569) Primer cement concrete/screed: Steopox 220 (2E220) Further applications on request.

[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.

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
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APPROVED BY
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