TENAXON T 245 HS 6E245

Series 6E245 · Solvent-free external thick-film coating for buried steel tanks and pipelines

01 PRODUCT DESCRIPTION

TENAXON T 245 HS 6E245 is a solvent-free two-component liquid plastic for the external thick-film coating of buried steel tanks and pipelines. The system was developed specifically for aggressive environments and provides reliable protection against corrosion and chemical attack. The coating offers high chemical resistance and very good barrier properties, ensuring durable protection even under demanding conditions. It is sprayable, repairable and recoatable and meets the relevant requirements for resistance to cathodic disbonding, electrical insulation and corrosion protection for underground and water applications.

02 PRODUCT PROPERTIES

Binder system	Epoxy resin
Hardener system	Tenaxon T 245 Hardener 7E245
Cleaning thinner	EP Thinner 5E403
Characteristics	Solvent-free · Chemicalresistant · Repairable & recoatable
Color shade	RAL 7009 (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.
Mechanical resistance	Buchholz hardness to ISO 2815: > 90
Chemical resistance	Media on request
Thermal resistance	Up to approx. +80 °C (dry heat), briefly approx. +120 °C
Electrical resistance	> 10^8 Ω
Container size comp. A	30 kg (further container sizes on request)
Container size comp. B	30 kg (further container sizes on request)
Approvals	Tested to DIN EN ISO 12542:2017 Annex J (LPG equipment, stationary welded cylindrical steel vessels) | DIN EN ISO 15711:2005 method A (resistance to cathodic disbonding) | DIN EN 60243-1 (electric strength / dielectric breakdown) | Under testing to DIN EN ISO 12944-6, corrosivity category Im3 (very high)

TENAXON T 245 HS 6E245

Series 6E245 · Solvent-free external thick-film coating for buried steel tanks and pipelines

Property	Comp. A	Comp. B	Mixture
Density · DIN EN ISO 2811-1 · +20 °C *¹	Approx. 1.58 g/cm³	Approx. 1.55 g/cm³	Approx. 1.60 g/cm³
VOC content · IE Directive 2010/75/EU *¹	Approx. 15.91 g/l	Approx. 0 g/l	Approx. 10.61 g/l
Solid content (wt.-%) · SDS *¹	Approx. 99 %	Approx. 85 %	Approx. 94 %
Viscosity · DIN EN ISO 2555 · +20 °C *¹	Approx. 42,000 mPas	Approx. 33,000 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 (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 (G or working mixture GS). Primer: 1 × 30 µm Tenaxon T 569, consumption approx. 100 g/m² at 30 µm DFT.
Mixing ratio	2 : 1 by weight | 2 : 1 by volume
Mixing	Mixing via a 2-component hot-spray unit. For small-area repairs with a spatula, 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	160 g/m² per 100 µm WFT | 160 g/m² per 100 µm DFT
Film thickness	Max. 1,000 µm DFT | max. 1,000 µm WFT per coat
Application method	2K hot spraying
Application conditions	**Air temperature** min. +10 °C **Relative humidity** max. 85 % **Surface temperature** min. +10 °C **Dew point** min. 3 °C below surface temperature
Pot life	Approx. 30 min at +20 °C | approx. 15 min at +30 °C
Working time	Approx. 25 min at +20 °C | approx. 10 min at +30 °C
Recoating interval (with itself)	Min. 4 h at +20 °C | min. 24 h at +10 °C | max. 48 h at +20 °C. After the maximum recoating time has elapsed, mechanical surface preparation (e.g. sanding or sweep-blasting) is required.

TENAXON T 245 HS 6E245

Series 6E245 · Solvent-free external thick-film coating for buried steel tanks and pipelines

DRYING

Dust-dry (TG 1)	Approx. 3 h at +20 °C | approx. 5 h at +10 °C
Walkable / sandable	Approx. 16 h at +20 °C | approx. 24 h at +10 °C
Fully cured (mech. & chem.)	Approx. 7 days
Compatible systems	Primer steel: Tenaxon T 569 (3E569) 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
20.08.2026 – Martin Krull, Head of Laboratory

APPROVED BY
20.08.2026 – Stefan Eisenmenger, Product Management