



A/A H/R Bituminous Black IS158

Single Pack Heat-resistant Protective Coating

Issue Date : November 2025

Product Description

A preservative coating for metal surfaces designed primarily as an external coating for boilers. The coating performs well in contact with fresh water at elevated temperature.
Conforms to IS 158 requirements

Usage Areas

Product with long standing performance track in general industrial requirements specifically used in boiler externals, condensers, air coolers, cold water tanks, centrifugal pumps, piping, stoker wind boxes, ducting, etc.

Product Data

Composition	Processed Inert bitumen in non-toxic grade but not recommended for potable water
Volume Solids	38 ± 2%
Application Method	Brush, Roller or Airless Spray
Recommended DFT	30 - 40 µ per coat
Recommended WFT	79 - 105 µ per coat
Theoretical Spreading Rate	9.5 - 12.7 m ² /ltr
Colour	Black
Finish	Glossy

Practical Coverage : Dependent on-site condition and transfer losses due to substrate design, profile, wind, heights, application method, painter's skill etc.





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		Systems compatibility can be provided on request to the Technical Service Team		
		Coats	Generic Systems	Compatible Products
Typical Coating Systems	Primer	Processed Inert Bitumen		A/A H/R Black IS 158 (Thin Coat)
	Mid Coat	Processed Inert Bitumen		A/A H/R Black IS 158
	Top Coat	Processed Inert Bitumen		A/A H/R Black IS 158

Pack size		UOM	Part A	Part B	Total
	Volume	Lt/Kg	4 ltr	-	4 ltr
			20 ltr	-	20 ltr

Storage	The paints must be in its sealed original containers and be kept under cover in a dry place with ambient conditions inside closed room until use. The curing agent is sensitive to moisture and hence relative humidity within the room should be maintained preferably at ≤55%. Stacking should not be more than 3 drums/ cartons one above other. DO NOT expose to direct rain/ sunlight. Any deviation to the defined storage condition shall have a negative effect on the shelf life.
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Shelf life	Up to 12 months as long as the sealed original containers are kept under cover in a dry place under normal temperature conditions until use. Note : 1. Storage life @23°C will be extended up to 24 months. Storage at elevated temperatures may reduce shelf life; and hence never exceed maximum room temperature of 40°C. Storage life, thereafter, subject to re-inspection; consult tech-service. 2. It may be noted that higher volume solid material will tend to soft settling on long term storage, and it can be made to a normal homogeneous consistency by use of a slow speed 200-400 rpm power stirrer particularly in the PART A (BASE) container; and this soft settling is not considered as a failure of keeping properties.
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Flash Point	Part A	Part B	Mixed Paint
	30°C	-	30°C

Health & Safety	Please refer to the separate Safety Data Sheet available with detailed information.
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APPLICATION GUIDELINE

Substrate	Steel	
Surface preparation	Steel : Remove grease, oil and other contaminants preferably by using Solvent cleaning as per SSPC SP 1. Abrasive Blast clean to a minimum of SSPC SP 10 with a surface profile not exceeding 35 - 40 µm for direct application of on mild steel. If blasting is not practical, make full use of mechanical tools along with manual chipping and wire brushing to remove loose rust and scale to SPC SP2. Excessive burnishing of steel is to be avoided. Thoroughly dust down all surfaces from contaminants, debris and dust. Surface should be dry and clean before application of paint.	
Atmospheric Condition	Ventilation	Suitable air engineering systems, which will ensure reduction of air contaminants and thatto further help regulate the temperature and humidity of the working environment.
	Dew Point	Ensure surface temperature to be more than 3°C over the dew point temperature.
	Humidity	Do not apply when relative humidity rises above 90%.
Mixing	DO NOT ADD THINNER beyond recommendation as it will reduce mixed VS calling for revised WFT calculations as well as challenges on flow properties.	
Thinner	Thinner 800	





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Application	<p>Stir thoroughly before and occasionally during use.</p> <p>Brush : Apply without thinning directly on the metal. Work well into the surface and ensure all corners, edges, weds, nuts/bolts are covered.</p> <p>Airless Spray : Apply preferably without thinning. Add upto 5% Thinner 800, if absolutely essential depending on conditions. Use any standard equipment having pump ratio 30:1.</p> <p>Tip Size : 0.38 - 0.43 mm. Tip Pressure : 125-150 Kg/Sq cm.</p>																				
Work Stoppage	<p>Ensure to use the mixed paint within pot life as there are no methods to increase working pot life. Keep the working tools and tips free of drying and clogging. Always use fresh material and never add-up to previous mixed paints.</p>																				
Clean Up	<p>Clean all equipment immediately after use with Thinner 800. It is good working practices to flush or clean all the spray equipment periodically. All the surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations.</p>																				
Drying Time	<table border="1"> <thead> <tr> <th data-bbox="414 1089 636 1170">Temperature</th><th data-bbox="636 1089 827 1170">Touch Dry</th><th data-bbox="827 1089 1017 1170">Handle Dry</th><th data-bbox="1017 1089 1240 1170">Hard Dry</th></tr> </thead> <tbody> <tr> <td data-bbox="414 1170 636 1215">10°C</td><td data-bbox="636 1170 827 1215">2 hrs</td><td data-bbox="827 1170 1017 1215">7.5 hrs</td><td data-bbox="1017 1170 1240 1215">24 hrs</td></tr> <tr> <td data-bbox="414 1215 636 1260">23°C</td><td data-bbox="636 1215 827 1260">1 hr</td><td data-bbox="827 1215 1017 1260">6 hrs</td><td data-bbox="1017 1215 1240 1260">20 hrs</td></tr> <tr> <td data-bbox="414 1260 636 1304">30°C</td><td data-bbox="636 1260 827 1304">45 min</td><td data-bbox="827 1260 1017 1304">4 hrs</td><td data-bbox="1017 1260 1240 1304">18 hrs</td></tr> <tr> <td data-bbox="414 1304 636 1394">40°C</td><td data-bbox="636 1304 827 1394">30 min</td><td data-bbox="827 1304 1017 1394">3 hrs</td><td data-bbox="1017 1304 1240 1394">16 hrs</td></tr> </tbody> </table>	Temperature	Touch Dry	Handle Dry	Hard Dry	10°C	2 hrs	7.5 hrs	24 hrs	23°C	1 hr	6 hrs	20 hrs	30°C	45 min	4 hrs	18 hrs	40°C	30 min	3 hrs	16 hrs
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Curing Time	<p>Extended</p> <p>NOTE : Drying and Curing times are determined under controlled temperatures and at relative humidity below 85%, for the NDFT of the product.</p>
Inspection	<p>Refer SSPC PA2 guidelines for measurement of DFT.</p> <p>Do not conduct any destructive test like peel off/ pull off & high voltage Holiday test unless and otherwise mandatory in the specification.</p> <p>Consult Technical Service team for preparation of QAP (Quality Assurance plan).</p>
Repair Methodology	<p>Clean off loose paints, debris, contaminants and ensure spot repair with available tools as practiced in hand/ power tool cleaning using wire brush/buffing, emery/feathering to smoothen the edges of impaired areas. Use appropriate touch up primer followed by recommended coating system, allowing due over coating interval time to area of 2-3 inches in excess of the spot repaired portion.</p>
Product Characteristics	<ul style="list-style-type: none"> • The coating shows Fair resistance to acids, alkalis under both splash, spillage and mild fume conditions. • It provides good resistance to salt under splash, spillage, and mild fume exposure. • The coating offers excellent resistance to salt in both splash and outdoor environments. • It also provides excellent resistance to water under similar exposure conditions. • It is suitable for salt & fresh water immersion. • The coating withstands continuous temperatures up to 50°C and can tolerate intermittent exposure up to 230°C without loss of performance. • The coating has good weatherability in general industrial. • The coating maintains good flexibility and demonstrates moderate abrasion resistance.
Disclaimer	<p>The information contained within this Data Sheet is based on information believed to be reliable at the time of its preparation. The Company will not be liable for loss or damage howsoever caused including liability for negligence, which may be suffered by the user of the data contained herein. It is the users' responsibility to conduct all necessary tests to confirm the suitability of any product or system for their intended use. No guarantee of results is implied since conditions of use are beyond our control.</p>



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