BERGER PROTECTON
PROTECTIVE COATINGS DIVISION

Epilux 555 CTE HB

Two Pack, cured with Polyamide Resin

Issue Date : November 2025

Product Description

A high build coal tar epoxy coating with superior performance in saline, chemical and most severe corrosive environments. The product has excellent water resistance properties, and it is also unaffected by alkalinity or sulphates in soil water.

Usage Areas

Recommended for use on structural steel, pipelines and equipment of fertilizer, refineries, chemical and coastal installations.

Product Data

Composition	Epoxy Coal Tar suitably pigmented
Volume Solids	73 ± 2%
Mixing Ratio	Base: Catalyst :: 55 : 45 by volume
Application Method	Brush or Airless Spray
Recommended DFT	125 - 175 µ per coat
Recommended WFT	150 - 225 µ per coat
Theoretical Spreading Rate	4.5 - 6.4 m^2/ltr
Colour	Black
Finish	Low Sheen

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

Pot Life

10°C	15°C	25°C	40°C
10 hrs	8 hrs	6 hrs	4 hrs

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Typical Coating Systems

Systems compatibility can be provided on request to the Technical Service Team

Coats	Generic Systems	Compatible Products
Primer	Inorganic Zinc, Zinc Rich, Epoxy, Epoxy Mastic	Zinc Anode 304, Epilux 4 ZR, Epilux 610, Epilux 13, Protectomastic
Mid Coat	Epoxy Coal Tar	Epilux 555 CTE HB
Top Coat	Epoxy Coal Tar	Epilux 555 CTE HB

Pack size

	UOM	Part A	Part B	Total
Volume	Lt/Kg	19.25 ltr	15.75 ltr	35 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.

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 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.

Flash Point

Part A	Part B	Mixed Paint
22°C	22°C	22°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 Bison Degreasing Solvent. Blast clean to a minimum Sa 2 1/2 Swedish Standards SIS 05 5900 not exceeding 65 microns. 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 St. 2 Swedish Standard SIS 05 5900. Excessive burnishing of steel is to be avoided. Thoroughly dust down all surfaces. Best results can be achieved if manually cleaned surface is primed with Protectomastic.	
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	Stir the base thoroughly and then mix base to a homogenous mixture and then add recommended part of catalyst to uniform consistency. NOTE : 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 844	

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Application	Stir the base and catalyst thoroughly and then mix the base and catalyst in recommended proportion to uniform consistency. Allow it to mature for 30 minutes and stir again before use and during application. **Brush :** Apply preferably without thinning. However, if required during application, add upto 5% Thinner 844. **Airless Spray :** Apply preferably without thinning. However, upto 5% Thinner 844 may be added if absolutely essential depending on conditions. Use any standard equipment having pump ratio 40:1. **Tip Size :** 0.48 - 0.68 mm. **Tip Pressure :** 110 - 160 Kg/Sq cm.
Work Stoppage	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.
Clean Up	Clean all equipment immediately after use with Thinner 844. 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.

Drying Time

Temperature	Touch Dry	Handle Dry	Hard Dry
10°C	6.5 hrs	28 hrs	32 hrs
23°C	5 hrs	24 hrs	30 hrs
30°C	4 hrs	18 hrs	24 hrs
40°C	3.5 hrs	16 hrs	22 hrs

Over Coating Intervals

MIN	24 hrs
MAX	5 days

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Curing Time	7 days NOTE : Drying and Curing times are determined under controlled temperatures and at relative humidity below 85%, for the NDFT of the product.
Inspection	Refer SSPC PA2 guidelines for measurement of DFT. Do not conduct any destructive test like peel off/ pull off & high voltage Holiday test unless and otherwise mandatory in the specification. Consult Technical Service team for preparation of QAP (Quality Assurance plan).
Repair Methodology	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.
Product Characteristics	• The coating shows good resistance to acids under both splash and mild fume conditions. • It provides very good resistance to alkalis under splash, spillage, and mild fume exposure. • Resistance to solvents is good under both splash and mild fume conditions. • The coating offers excellent resistance to salt in both splash and outdoor environments. • It also provides excellent resistance to water under similar exposure conditions. • The coating withstands continuous temperatures up to 93°C and can tolerate intermittent exposure up to 120°C without loss of performance. • The coating has good weatherability and may develop slight chalking after prolonged outdoor exposure. • The coating maintains good flexibility, allowing it to accommodate normal surface movements without cracking or peeling. • The coating demonstrates very good abrasion resistance, ensuring strong protection against wear and surface damage.
Disclaimer	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.