



### DEP 302 ERC121

DEP302 ERC121 is a high performance one to one mix ratio epoxy repair compound and is ideal for applications where only minimal surface preparation can be carried out. The material is ideal for rebuilding corrosion pitting on metallic structures and in particular as a fairing compound on pipework prior to wrapping with the DEP RH221 pipe repair system. The product has been designed for use on a wide range of metallic surfaces and once mixed and cured is readily machinable.

#### Surface Preparation

All oil and grease must be removed from the surface of the repair using an appropriate cleaner such as MEK. For optimum performance, the surface should be abrasive blasted to Swedish Standard SA2.5 and a minimum blast profile of 75 microns using an angular abrasive. Once blast cleaned, the surface must be degreased and cleaned using MEK and all prepared surfaces must be repaired before rusting or oxidation occur.

NOTE: For salt contaminated surfaces the area must be repeatedly water washed, preferably by power washing, until ingrained salts no longer come to the surface on drying. The surface should then be abrasive blast cleaned as above prior to cleaning and degreasing with MEK.

In the case of cracked surfaces, the cracks should be stabilised by drilling the termination points and the cracks veed out and drilled, tapped and bolted every 75-100 mm.

Where abrasive blast cleaning is not possible the surface should be roughened by bristle blaster, needle gun or grinding. Under these conditions adhesion levels will not be optimal although still satisfactory for most applications.

Where the product should not adhere, a thin layer of a suitable release agent should be applied taking care not to contaminate other areas.

#### Mixing and Application

***Warm the Base to 15-25°C before mixing and do not apply when the ambient or substrate temperature is less than 5°C or less than 3 degrees above the dew point.***

Mixing of the product can be on full units or by part-mixing. If mixing the whole unit please ensure as much of the base and activator is dispensed from the plastic container onto a clean plastic mixing surface and mix using a spatula until a uniform material free of any streakiness is achieved while ensuring no unmixed material is left on the spatula or the mixing surface. From the commencement of mixing the whole of the material should be used within 25 minutes at 20°C.

For part mixing, using a spatula place equal measures of the Base and Activator onto a clean plastic mixing surface, cleaning the spatula thoroughly between the taking of each measure. Mix as above.

Using a spatula or applicator tool, apply the material to the prepared surface, ensuring the product is pressed into any pitting or other defects and profile the repair to a smooth finish.

Where the material is to be over-coated, this can be done as soon as it is touch dry and at any time up to 24 hours. Where the maximum over-coating time is exceeded, the material should be allowed to harden before being abraded or flash blasted to remove surface contamination.



## Technical Data Sheet

### Cure Times

At 20°C the applied materials should be allowed to harden for the times indicated below before being subjected to the conditions indicated. These times will be extended at lower temperatures and reduced at higher temperatures:

Movement without load or immersion	2 hours
Light loading	6 hours
Full loading	2 days
Immersion	3 days

### For Optimum Performance

After an initial curing period of at least 4 hours at 20°C, raising the cure temperature progressively to 60 - 100°C for up to 8 hours will result in improved mechanical, thermal and chemical resistance properties

### Storage Life

5 years if unopened and store in normal dry conditions (15-30°C)

### Technical data and Performance

Volume Capacity	625cc/Kg
Compressive Strength ASTM D695	735kg/cm <sup>2</sup> (10,450psi)
Tensile Shear Adhesion ASTM D1002	1865kg/cm <sup>2</sup> (2650psi) - blasted 129kg/cm <sup>2</sup> (1834psi) – manually prepared
Flexural Strength ASTM D790	298kg/cm <sup>2</sup> (4250psi)
Hardness Rockwell R ASTM D785	100
Corrosion Resistance (ASTM B117)	5000 hours

### Health and Safety

Please ensure good practice is observed at all times during the mixing and application of this product. Protective gloves must be worn during the mixing and application of this product. Before mixing and applying the material please ensure you have read the fully detailed Material Safety Data Sheet.

The data contained within this Technical Data Sheet is furnished for information only and is believed to be reliable at the time of issue. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the responsibility of the customer to determine the products suitability for use. DE Polymers Limited accepts no liability arising out of the use of this information or the product described herein.

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