



Material Technologies  
Solving Tough Problems

# StackGard™-255SQW

## Sprayable Quick Cure Wide Temperature Range

- Resistant to SO<sub>3</sub>, SO<sub>2</sub>, HCl and NO<sub>x</sub> gases
- Excellent performance up to 255°C (491°F)
- Resistant to dust abrasion
- Simple application by spray
- Easy inspection and maintenance

### Product Description

StackGard™-255SQW is a two component, high temperature corrosion protection system for chimneys of industrial plants.

The flue gases found in cement plants, metal smelters, waste incineration, power generation and oil refineries, contain SO<sub>3</sub>, SO<sub>2</sub>, HCl, NO<sub>x</sub> and dust, they are extremely corrosive and abrasive. StackGard™-255SQW has shown outstanding performance on steel chimneys ducts and fans exposed to this severely aggressive environment.

### Applications

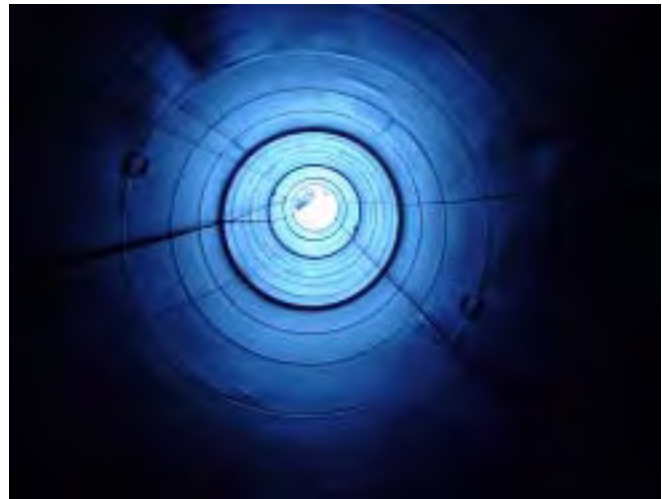
The main areas of application are on the inside surfaces of steel chimneys connected to:

- Bag houses, electrostatic precipitators and ducts in cement plants and waste incinerators.
- Gas scrubbers, ducts and fans in power generation plants and oil refineries.
- Ducts, filters and scrubbers in copper, zinc or lead smelters.

### Performance

StackGard™-255SQW has great performance in the steel areas exposed to the hot flue gases of industrial facilities. It protects the steel from corrosion, abrasion and impact at temperatures ranging from ambient up to 255°C.

StackGard™-255SQW will resist severe chemical and salt corrosion in industrial and marine environments due to its tough impervious thermoset nature and a strong chemical bond to the substrate.



Large Stack Coated With StackGard™-255SQW

### Installation

StackGard™-255SQW is supplied as two components system that is mixed in a 4:1 volume ratio prior to application. Mixed material is applied by air or airless spray, on a sandblasted, dry steel surface. The material cures at room temperature after 12 hours into a dry and tough coating. At this stage it can be inspected for thickness and integrity and any defect can be recoated.

Once the coating inspection is satisfactory, the final cure is performed at 100 to 180°C for few hours (212/356°F). Typically this is done using the hot flue gases during the start up of the process.

### Additional Information

The shelf life of both components of StackGard™-255SQW will be at least one year. The material shall be stored in a cool and dry area.

The material contains solvents, handle with care, keep sealed, avoid excessive exposure to inhalation and body contact. Use in well ventilated areas, for indoor applications use forced ventilation.

See the corresponding MSDS sheets.

## Product Properties

Physical properties (Cured @ 180°C)	Test method	Typical Value
Pencil Hardness	ASTM D-3363	>H
Taber Abrasion, mg. (CS-17, 1Kg., 1000 cycles)	ASTM D-4060	<70
Adhesion to steel, psi.	ASTM D-4541	>1000
Coating Impact, in-lbf	ASTM D-2794	> 28
Heat ageing	ASTM-2485	255°C (491°F)
<b>Chemical properties (weight gain, 1 week immersion)</b>		
HCl 37%	ASTM D-471	< 1.5 %
H <sub>3</sub> PO <sub>4</sub> 54%	ASTM D-471	< 0.5 %
H <sub>2</sub> SO <sub>4</sub> 10%	ASTM D-471	< 0.5 %
H <sub>2</sub> O	ASTM D-471	< 0.5 %

## Application

Application methods	Air or airless spray, short nap roll
Vertical dry film thickness, single coat	20 to 25 mils (0.5 to 0.63 mm)
Coverage at 20 mils thickness	50 sq.ft (4.7 sq.mt)/gallon
Surface preparation (Near white metal)	Sand blast, SSPC SP-10, NACE 2(Near White metal)
Surface profile	> 3 mils (75 microns)
Coating inspection time	After 12 to 24 hours
Recoating interval	Up to 72 hours after initial application
Solvent for dissolving, viscosity adjustment	Xylene or toluene
Maximum dry film thickness	35 mils (0.87 mm)

## Handling Properties

Shelf life	1 year
Shipping and storing temperature	10°C to 40°C (50°F to 104°F)
Mix ratio by volume	4 to 1 (Part B liquid)
Pot life after mixing	1.5 hr. at 25°C (77°F)
Cure time to tack free	<24 hours.
Final cure time	1 hr. at 180°C (356°F) to 24 hrs. at 100°C ( 212°F)
Surface temperature for application	10°C to 50°C (50°F to 122°F)
Air relative humidity for application	<90%, 5°C above dew point

## Ordering Information for StackGard™-255SQW

Product is supplied as two components in 5 gallon kits, clearly identified as Part A (5 gallon pail, color dark grey) and Part B (1 gallon can liquid)

Description	Part A	Part B	Total Volume	Net Weight	Minimum Order
StackGard™-255SQW Kit	Pail 4 Gl(15.2L)	Can 1 Gl(3.8L)	5 gallons(19L)	79 lb(35.9Kg)	10 gallons

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