

PRODUCT DATA SHEET

RomoCoat HB Coal Tar Epoxy 7260

RomoCoat HB Coal Tar Epoxy 7260 is a **two-component, polyamide-cured, high-build coal tar epoxy** for long-term protection of steel and concrete in immersed and very wet, chemically aggressive environments.

Product description

- Two-pack coal tar-epoxy coating combining epoxy resin with coal tar to give excellent adhesion, abrasion resistance, water impermeability and resistance to dilute acids, alkalis and many industrial chemicals.
- Designed as a high-build barrier coat for submerged, underground and splash-zone exposure on steel (and suitably prepared concrete) where long-term service is required.



Typical applications

1) Hydropower & water infrastructure

- Hydro-electric units: penstocks, draft tubes, spiral casings, water passages and gates carrying raw water to turbines.
- Dam and canal structures: steel liners, sluice gates, guide vanes and steel parts permanently or intermittently immersed in fresh water.

2) Marine & harbour installations

- Harbour and jetty steel: piles, dolphins, fenders, sheet piles, quay structures and submerged/splash-zone steel exposed to sea water, tidal action and abrasion.
- Underwater hull exterior (in conjunction with cathodic protection): outer hull below waterline, bilge areas and other immersed steel, where coal tar epoxy provides an excellent acid/alkali and water barrier under CP systems.

3) Cooling towers & water treatment

- Cooling-tower basins, channels, inside/outside of riser pipes and structural members exposed to continuous wetting and mildly aggressive circulating water.
- Water and effluent treatment facilities: clarifier bridges, tanks, contact chambers, sewage and effluent lines where resistance to sewage, salt, dilute acids/alkalis and microorganisms is required.

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Mfg. Of Anti-Corrosive Primers, Epoxy – PU Paints, Rebar Protective Coat, Marine-Industrial Paints

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4) Underground & buried structures

- Underground pipelines, external surfaces of buried steel, foundations, piles and other below-ground steel/concrete exposed to moist, acidic or alkaline soils.
- Crude-oil and fuel storage tanks (external below-grade portions or internal where coal tar is allowed by spec) and bund walls subject to chemical and water attack.

Product data

- Colour : black.
- Finish : egg-shell to semi-glossy.
- Mixing ratio : 3 : 1 by volume (Base : Hardener).
- Pot life : 1–2 hours at 30 °C
- Volume solids : approx. 58 ± 2%.
- Recommended DFT/coat : 75–100 µm.
- Theoretical spreading rate : 7.73–5.80 m²/L at 75–100 µm DFT
- Drying & curing (30 °C) : Surface dry: ~1–2 hours.
Touch dry: ~6 hours.
Hard/handle dry: ~16 hours.
- Fully cured : ~7 days.
- Minimum : 16 hours at 30 °C.
- Maximum : 4 weeks
- Flash point : above 25 °C.
- Thinner : epoxy thinner

Surface preparation & system

- Substrate:
 - Steel surfaces must be properly cleaned and pre-primed with a **suitable epoxy primer/intercoat** as specified (e.g. epoxy zinc phosphate or epoxy mastic primer) before applying RomoCoat HB Coal Tar Epoxy 7260.
 - Surface should be dry and free from oil, grease, dust, salts and other contamination.
- Preparation level:
 - For new steel in immersion/soil contact: abrasive blast cleaning to Sa 2½ with suitable profile is strongly recommended.
 - For maintenance: remove rust, scale and loose/unsound coatings by blast or power-tool cleaning; feather edges of sound coatings and ensure firm adhesion before overcoating.

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- Old primed/inter-coated surfaces:
 - Clean thoroughly; any gloss or chalk must be removed and surface **roughened** (sweep blast or coarse sanding) prior to coal tar epoxy application.

Typical systems:

- Immersion / hydro & cooling water:
 - Epoxy primer → 2 × RomoCoat HB Coal Tar Epoxy 7260 (total 150–200 µm) as per project spec.
- Underground pipelines / buried steel:
 - Epoxy primer → 2–3 × HB Coal Tar Epoxy (total 200–300 µm) depending on soil aggressiveness and standard (IS/ISO/owner spec).
- Harbour/marine steel:
 - Epoxy or zinc-rich primer → 1–2 × Coal Tar Epoxy → (optional) antifouling or tie-coat where required by marine system design.

Application guidance

- Mix base and hardener at 3:1 by volume with mechanical stirring until uniform; due to short pot life, prepare small batches that can be applied within 1–2 hours at 30 °C.
- Adjust viscosity with epoxy thinner only if necessary for spray; excessive thinning reduces film build and barrier performance.
- Apply by air spray or brush; for large areas and immersion service, airless spray is usually preferred to achieve specified DFT in fewer coats (you can align your internal nozzle/pressure recommendations with typical coal tar epoxy practice).
- Avoid applying in strong direct sunlight on hot steel or in very high humidity/condensation conditions, which can cause defects or amine blush.

Health & safety

- Avoid inhalation of solvent vapour and paint mist and avoid skin and eye contact; use appropriate PPE (organic vapour respirator, gloves, goggles, protective clothing) as per local regulations.
- Provide forced ventilation when working in confined or poorly ventilated spaces (tanks, penstocks, pits, below-ground structures).

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