

# POLYKEN® 930

## Product Information

**Product description:** The Polyken® 930 is a cold applied tape coating system designed for the corrosion protection of field joints, fittings and specialty piping. The unique adhesive retains conformability over a wide temperature range, yet exhibits an elevated level of shear resistance, which is a key in-ground performance characteristic. Coupled with a very malleable polyethylene backing, this versatile tape system can be applied by hand or with a wrapping machine.

### Features:

- Heavy duty adhesive.
- Conformable to irregular shapes.
- No release liner.
- Worldwide reference lists.
- Complies with AWWA standard C-209, EN12068, DIN30672.
- Compatible with generic plant coatings systems.

### Benefits:

- Ensures a strong bond & impervious seal.
- Offers a solution for nearly every application.
- Makes installation fast and easy.
- Established in-ground history.
- Reliable, high performance corrosion protection.
- Versatile.

## Product selection guide

<b>Max. operating temperature</b>	85°C (185°F)
<b>Recommended primer</b>	1027 ,1033A or 1039
<b>Additional mechanical layer</b>	955 or 954
<b>Compatible line coatings</b>	PE, FBE, Cold Tape, CT, CTE
<b>Recommended pipe preparation</b>	SSA-ST2 (SSPC-SP3) or SSA-SA 2 (SSPC-SP6) 1 – 3 mil anchor profile (25 – 76 micron anchor profile)
<b>Performance</b>	AWWA C209 EN 12068 class B30 DIN 30672 class B30

## Product construction

	930-35	930-50
<b>Backing</b>	6.5 mils (0.165 mm)	10 mils (0.254 mm)
<b>Adhesive</b>	28.5 mils (0.724 mm)	40 mils (1.016 mm)
<b>Backing color</b>	Black, White*	Black*

\* Other colors are available on request.

## Product properties of Polyken® 930

Property	Method	Typical values		Units
		930-35	930-50	
<b>Tensile strength</b>	ASTM D 1000	15 2.6	25 4.4	pli N/mm
<b>Elongation</b>	ASTM D1000	340	300	%
<b>Peel adhesion to primed steel</b>	ASTM D1000	15.6 2.7	18.7 3.3	pli N/mm
<b>Peel adhesion to primed steel</b>	EN12068	1.6		N/mm
<b>Cathodic disbondment</b>	ASTM G 8	0.25 6.4	0.27 6.9	in radius mm
<b>Water vapor transmission</b>	ASTM E 96B	0.07	0.07	perm
<b>Water vapor transmission rate</b>	ASTM F 1249 (100°F, 100% RH)	0.04 0.6	0.04 0.6	g/100in <sup>2</sup> / 24hr g/m <sup>2</sup> /24 hr
<b>Volume resistivity</b>	ASTM D257	2.5x10 <sup>16</sup>	2.5x10 <sup>16</sup>	Ω cm
<b>Dielectric breakdown</b>	ASTM D 1000	650 25.6	650 25.6	V/mil kV/mm
<b>Dielectric strength</b>	ASTM D 149	21	28	kV
<b>Insulation resistivity</b>	ASTM E 257	1.4x10 <sup>7</sup>	2.0x10 <sup>7</sup>	MΩ
<b>Impact resistance</b>	EN 12068*	> 8		J
<b>Indentation resistance</b>	EN 12068 *	Class B30		

\* For 930-35 tape installed with 66% overlap.

## Equation for Pipe Coating Requirements

**Squares\*\* of coating required**  $\frac{(\text{width of coating in inches}) \times (\text{area of pipe in square feet})^*}{(\text{width of coating in inches} - \text{overlap in inches}) \times 100}$

\* Area of pipe in ft<sup>2</sup> = (diameter in inches / 12) x 3.1416 x length in feet  
 \*\* One Square = one hundred square feet = 9.29 square meters

**Square meters of coating required**  $\frac{(\text{width of coating in mm}) \times (\text{area of pipe in square meter})^*}{(\text{width of coating in mm} - \text{overlap in mm})}$

\* Area of pipe in m<sup>2</sup> = (diameter in mm / 1000) x 3.1416 x length in meter

**Squares\*\* per roll**  $\frac{(\text{width of roll in inches}) \times (\text{length of roll in feet})}{(12) \times (100)}$

**Square meters Per roll**  $\frac{(\text{width of roll in mm}) \times (\text{length of roll in m})}{(304.8) \times (30.48)}$

**Rolls Required**  $\frac{(\text{squares of coating required})}{(\text{squares per roll})}$

**Rolls Required**  $\frac{(\text{square meters of coating required})}{(\text{square meters per roll})}$

## Ordering information

Polyken® 930 Tape Coatings are available in roll form.

Example	930-35 BLK 2X50 ft 4.1cm	Standard Ordering options
930	Product type	
35	Total tape thickness in mils	35 mils (0.89 mm) 50 mils (1.27 mm)
BLK	Tape backing color	Black (BLK), White (WHI), Yellow (YEL), Purple (PUR)
2	Tape width in inches	1" (25 mm), 2" (50 mm), 4" (101 mm), 6" (152 mm)
50	Tape roll length in feet	50 ft (15 m)
4.1	Tape inner core diameter	4.1 cm (1.6")

For other ordering options please contact your Seal For Life representative.

Application instruction: Job preparation	
<b>Tools, equipment and auxiliaries</b>	Temperature gauge, DFT/WFT gauge, Primer application equipment/agitator, Tape application equipment, Coating "hot box"
<b>Additional coating materials</b>	931 or 939 filler material, and 905, 954, or 955 mechanical protection layers
<b>High humidity</b>	Polyken® 930 can be applied in a humid atmosphere. The substrate should be free from condensing water which can be reached by keeping the temperature at least 5°F (3°C) above dew point.
<b>Work area and substrate</b>	The substrate surface should be dry, clean and protected against negative weather influences.
<b>Product conditions</b>	The Polyken® 930 shall be stored and/or transported in a dry, ventilated location. Storage temperature shall be a minimum of 60°F (16°C) and a maximum of 120°F (49°C). The minimum primer and roll body temperature for application will be 60°F (16°C).

<b>Step 4</b>	Spirally or circumferentially apply the 930 with a 1% to 2% neckdown. A minimum of two layers of the 930 shall be applied.
<b>Step 5</b>	If a single 930 layer is required, then a mechanical protection outerwrap layer (905, 954, 955) shall be applied over the single layer of 930.
<b>Step 6</b>	Perform holiday detection per NACE SP0274

Handling and commissioning	
<b>Exposure to loads</b>	Objects coated with Polyken® 930 should not be exposed to loads e.g. from supports- or lifting equipment.
<b>Backfill</b>	Backfill is possible immediately after completion of the coating application. Consult application guidelines for specific instructions. Backfill should be clean and not contain any foreign items that can cause damage to the coating system.

Application instruction: Surface preparation	
<b>General</b>	The area to be coated has to be clean, dry, and free from oil, grease and dust. All contamination including mill-scale has to be removed.
<b>Degreasing</b>	Degrease surfaces with Toluene or Heptane and e.g. a lint-free cloth.
<b>Preventing condensation of water</b>	Prior to and during the application, the temperature of the substrate(s) must be at least 5°F (3°C) above the dew point.
<b>Substrate temperature</b>	Temperature of the substrate should preferably be between 68°F and 104°F (20°C / 40°C). Preheating may be required.

Information	
<b>Documentation</b>	Extensive information is available on our website. Application instructions and other documentation can be obtained by contacting our offices, from our local distributor or by sending an email to <a href="mailto:info@sealforlife.com">info@sealforlife.com</a>
<b>Certified staff</b>	Application of the described coating system shall be carried out by certified personnel.

Application instruction: Brief version	
<b>Step 1</b>	Clean substrate to SSA-ST2, SSPC-SP3 (power wire brush) or SSA-SA 2, SSPC-SP6 (commercial blast). Surface (anchor) profile depth shall be no less than 1.0 mils (25 micron) and no greater than 3 mils (76 micron).
<b>Step 2</b>	Uniform primer application achieving 2 to 3 mil WFT. Primer should be "dry to touch" before application of inner layer.
<b>Step 3</b>	If required, apply weld seam filler material

\* For further detailed information, please view the corresponding Application Guideline \*



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