

# SEPCO TECH

*Epoxy instruction handbook*



English 2026 version 1.1 - Roskilde, Denmark

## About SepcoTech’s epoxy

SepcoTech A/S , based in Roskilde, Denmark - is a trusted partner for the maritime industry, providing advanced solutions and products that enhance safety, efficiency, and compliance at sea worldwide.

Our epoxy products work against corrosion, erosion, and cavitation. Immediate repair and maintenance solutions designed to minimize downtime and ensure operational efficiency. Specialized solutions for dry docking, scrubber systems, and GRE applications. Supplied in cartridges to eliminate mixing errors, reduce waste, and remove the need for preheating. The higher viscosity ensures lower material consumption and improved application control. Customized repair solutions tailored to meet specific operational requirements.

You can find more information about cases and news on our website **www.epoxy-sepcotech.com**

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# Aqua Guard Coating

*A high performance, two-component epoxy coating developed for wet and underwater environments. Bonds to dry, wet or submerged surfaces and gives long-term chemical and corrosion resistance in harsh marine and industrial conditions.*

| 2:1 | 45-55 min | 110 °C | 36 months |
|---|---|---|---|
| MIXING RATIO<br>*Mixed in the nozzle - no manual mixing* | POT LIFE | MAX. TEMPERATURE | SHELF LIFE |

## Key specifications

- Strong adhesion to metallic and non-metallic surfaces, incl. cured GRE and composites
- Resilient bond, suitable for dissimilar materials
- Resists corrosion, chemicals, abrasion and erosion
- High-build coating for demanding environments
- Apply by brush, roller or spray
- 100% solid, no shrinkage, non-conductive, high coverage rate




## Application areas

- Underwater pipeline and tank coating
- Marine structures and offshore platforms
- Swimming pools, spas and water tanks
- Concrete and metal surfaces exposed to moisture
- Repair and protection of submerged surfaces

## Availability

| Item no. | Colour | Pack size |
|---|---|---|
| 10238 | Grey | 9 fl. oz single cartridge (265 ml) |
| 10302 | Black | 9 fl. oz single cartridge (265 ml) |

**Storage**
Dry, frost-free and out of direct sunlight at 5-20 °C. Shelf life 36 months from date of manufacture, minimum one year from date of shipment in original, unopened container.

# Exhaust Repair Compound

*Asbestos-free, high-temperature resistant one-component cold weld paste / putty for repair and sealing of equipment exposed to temperatures up to 1300 °C (2372 °F) - such as cracks and leaks in exhaust pipes, bellows, expansion joints, boilers and chimneys.*

| 1300 °C | 24 h | 5-40 °C | 1.6 kg/dm³ |
|---|---|---|---|
| MAX. TEMPERATURE | CURING TIME | WORKING TEMPERATURE | DENSITY |

## Technical data

- Asbestos-free, non-shrinking and non-crumbling
- Easy to work with - pasty, does not run
- Seals well; adheres to metal, concrete, masonry, firebrick, refractory linings and fiberglass gaskets
- Base of alkaline silicates and water glass
- Curing 24 h - can be carefully heated for quicker curing; keep below boiling point until fully cured
- Overpainting not recommended - risk of discolouration and paint fumes at high temperatures




## Intended use

- Cracks, leaks and surface damage in exhaust systems
- Bellows and expansion joints
- Boilers and chimneys
- Assembly and fitting of boiler systems and chimney installations

## Availability

| Item no. | Product | Contents |
|---|---|---|
| 10242 | Exhaust Repair Kit | 310 ml (10.48 fl. oz) cartridge incl. nozzle + reinforcement steel mesh |

# Fast Steel Putty Stick

*A hand-mixable, fast-setting epoxy putty for quick, permanent repairs to metals, ceramics, concrete, wood and many plastics. Each stick holds pre-measured activator and base - just cut, knead and apply. Cures tough and hard with nearly no shrinkage.*

| Hand-mix | 10-15 min | 150 °C | 36 months |
|---|---|---|---|
| PRE-MEASURED STICK | POT LIFE | MAX. TEMPERATURE | SHELF LIFE |
| *No tools or measuring needed* | | | |

## Key specifications

- Industrial-strength polymer compound after mixing
- Modeling-clay consistency - no drips or runs, easy to shape
- Bonds tenaciously to metals
- Cures tough and hard with nearly no shrinkage
- Outperforms conventional epoxy putties in lap shear tensile strength testing

## Intended use

- Repair of steel pipes, tanks, equipment and castings
- Tools, stripped threads, molds and ductwork
- Bonding metals in industrial maintenance
- Filling cracks and holes




## Availability

| Item no. | Product | Size |
|---|---|---|
| 10243 | DuraFix Fast Steel Putty Stick | 57 g |
| 10244 | DuraFix Fast Steel Putty Stick | 118 g |

**Storage**
Dry, frost-free and out of direct sunlight at 5-20 °C. Shelf life 36 months from date of manufacture, minimum one year from date of shipment.

# QuickFix Pipe Repair Tape

*A tough, durable, anti-corrosion repair bandage for rapid fixes of pipe leaks, cracks and structural damage. Restores integrity to corroded or weakened pipes and protects against corrosion, wear and abrasion in industrial, marine and offshore use.*

| 5 min | 5-10 min | 150 °C | 10 bar |
|---|---|---|---|
| POT LIFE | CURE TIME | CONTINUOUS TEMP. *Peak 190 °C (374 °F)* | PRESSURE, 9 LAYERS *103 bar with 2 x 9 layers + putty* |

## Key specifications

- Excellent adhesion to all metallic surfaces - ideal for corroded pipes
- Pressure resistance 10 bar (145 psi) with 9 layers; 103 bar (1500 psi) with 2 x 9 layers and putty
- Service temperature 150 °C (300 °F) continuous, 190 °C (374 °F) peak
- For metal, plastic and composite pipes
- Resists crude oil, diesel, ketones, alcohols, esters, halocarbons, salt solutions, dilute acids, bases, solvents and alkalis






## Availability

| Item no. | Size | Tape | Pipe diameter |
|---|---|---|---|
| 10247 | Small | 5 cm x 1.8 m | Up to 3" (DN75) |
| 10248 | Medium | 5 cm x 3.6 m | Up to 5" (DN125) |
| 10249 | Large | 10 cm x 4.8 m | Up to 10" (DN250) |
| 10250 | X Large | 15 cm x 10 m | 10" to 24" (DN600) |

**Storage**
Dry, frost-free and out of direct sunlight at 5-20 °C. Shelf life 36 months from date of manufacture, minimum one year from date of shipment in original, unopened container.

## Intended use

- Repair of damaged or leaking pipes
- Reinforcing weakened and corroded pipes, joints and structures

# Super Guard Coating

*A strong and reliable two-component epoxy coating that protects surfaces in harsh and demanding environments - long-lasting protection against corrosion, wear and damage, ideal for marine use.*

| 2:1 | 2000 µm | 180 °C | 15+ years |
|---|---|---|---|
| MIXING RATIO<br>*Mixed in the nozzle - no manual mixing* | IN ONE COAT | MAX. TEMPERATURE | DURABILITY |

## Key specifications

- 100% solid, solvent and filler free for maximum strength
- Extreme high build: up to 2000 µm in one coat
- Outstanding resistance to corrosion, abrasion and chemicals
- Dielectric strength 26.5 kV/mm; pull-off 7.6 N/mm²
- High coverage - apply by brush, roller or spray
- Temperature resistance up to 180 °C (356 °F)

## Application areas

- Storage & containment: steel and cement tanks, silos, warehouses
- Structures: bridges, pipelines, chemical and pulp & paper plants, amusement parks
- Vessels: hulls, bottoms, thruster tunnels, ballast tanks, seawater pipes, filters, exhausts, anchor plates
- Decks and superstructures
- Pools and spas




## Availability

| Item no. | Colour | Pack size |
|---|---|---|
| 10233 | White | 9 fl. oz single cartridge (265 ml) |
| 10234 | Blue | 9 fl. oz single cartridge (265 ml) |
| 10235 | White | 38 fl. oz dual cartridge (1125 ml) |
| 10236 | White | 1.05 gal kit (5 l / 6.3 kg) |
| 10237 | White | 7.3 gal kit (27.75 l / 35 kg) |

## Intended use (not limited to)

Rudders and hulls, steel and concrete storage tanks, separators, evaporators, scrubbers, absorbers, heat exchangers, turbines, pipelines and pumps, vessel propulsion areas, steel and composite pipes and constructions.

# Super Guard Coating in use

*Super Guard is available in blue and white. In pipe repairs the two colours are applied as alternating layers together with Super Wrap Reinforcement Tape, building up a strong repair one coat at a time.*



## Mixed in the nozzle

Base and hardener are mixed inside the static mixing nozzle as the caulking gun pushes the coating out of the cartridge - no manual mixing and no mixing errors.

STATIC MIXING NOZZLE - ITEM NO. 10260
CAULKING GUN - ITEM NO. 10263

## Super Guard Blue

ITEM NO. 10234 - FIRST LAYER



- Apply evenly on the prepared surface by brush or roller
- Wet film thickness 400 µm
- Wrap with Super Wrap tape at 50% overlap while the coating is still tacky

## Super Guard White

ITEM NO. 10233 - SECOND LAYER



- Apply over the semi-cured first layer by brush or roller
- Wet film thickness 400 µm
- Wrap with Super Wrap tape at 50% overlap while the coating is still tacky

## Finished repair



**LAYER BUILD-UP**

The same procedure continues until 4 layers of coating and 3 layers of Super Wrap are obtained, alternating blue and white for each coat.

# Super Metal Filler

*A high performance epoxy repair compound for corrosion protection and damage repair of systems exposed to harsh weather and extreme heat - also works under water.*

| 1:1 | 20-30 min | 110 °C | 36 months |
|---|---|---|---|
| MIXING RATIO *By weight and volume* | POT LIFE | MAX. TEMPERATURE | SHELF LIFE |

## Key specifications

- Solvent-free, 100% solid, no shrinkage, non-conductive
- Fast curing for emergency repairs, minimizing downtime
- High mechanical and compressive strength
- Strong adhesion to metals and epoxy compatible composites, even on wet or humid surfaces
- Resists corrosion, chemicals, abrasion and erosion
- Easy to apply and sand; can be machined, drilled and worked like metal after curing

## Application areas

- Rebuilding worn, pitted, corroded or eroded surfaces to original shape and size
- Bonding dissimilar materials (eliminates bi-metallic corrosion)
- Tanks, pump housings, impellers, valves, pipes, heat exchangers, flange faces, seats, worn shafts, hydraulic rams
- Emergency repairs needing short curing time; also as a filling compound



BASE AND HARDENER MIXED 1:1 ON A BOARD




## Availability

| Item no. | Product | Pack size |
|---|---|---|
| 10240 | Super Metal Filler Compound | 1.0 kg (2.2 lbs) |

**Storage**

Dry, frost-free and out of direct sunlight at 5-20 °C. Shelf life 36 months from date of manufacture, minimum one year from date of shipment in original, unopened container.

# Super Wrap Reinforcement Tape

*A flexible, fiber reinforced fabric gauze for reinforcing repairs made with SepcoTech compounds and coatings - stronger, longer-lasting repairs of piping systems in marine, offshore and industrial environments.*

| 0.5"-24" | 5 / 10 cm | 10 / 20 m |
|---|---|---|
| PIPE DIAMETER | TAPE WIDTH | ROLL LENGTH |

## Key specifications

- Robust, durable repairs under high-stress conditions
- Flexible - adapts to complex shapes, contours and uneven surfaces
- Pressure resistant - for high-pressure pipe repairs and tank reinforcement
- Works with SepcoTech compounds and coatings as one repair system
- Protects repaired areas from moisture and chemicals
- Lightweight - no special tools or training needed

## Application areas

- Cracks, leaks, fractures and corrosion porosity in steel, GRE, fiberglass, FRP and composite piping
- Temporary or permanent pipe repairs
- Reinforcing epoxy coatings on cracks or holes in tanks
- Support for weakened or damaged joints
- Areas exposed to mechanical stress, vibration or pressure

## Availability

| Item no. | Size | Dimensions |
|---|---|---|
| 10251 | Small | 5 cm x 10 m |
| 10252 | Large | 10 cm x 20 m |

**Storage**
Dry, frost-free and out of direct sunlight at 5-20 °C.





WRAPPED OVER WET SUPER GUARD COATING WITH 50% OVERLAP





# Application tools

*A complete set of tools to help apply SepcoTech products. The caulking gun and static mixing nozzles are used for the coatings, while the spatulas and brushes help with spreading and finishing.*

## Set contents

1 x Caulking gun - for the SepcoTech coating cartridges
6 x Static mixing nozzles - mix the coating as it is dispensed
2 x Spatulas - for applying and levelling compounds
2 x Brushes - for stripe coats and coating application



## Availability

| Item no. | Product | Contents |
|---|---|---|
| 10266 | Application tools set | 11 pieces |



**Discover SepcoTech's Epoxy Solutions for Maritime Equipment**

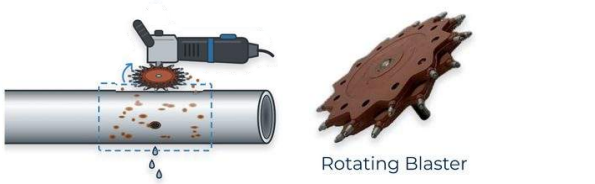
Protecting against:
Corrosion, Erosion & Cavitation

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# Ballast pipes - Repair/sealing leaks











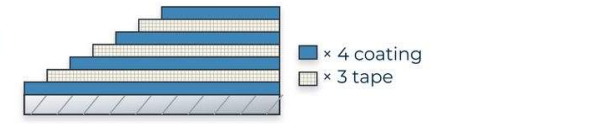


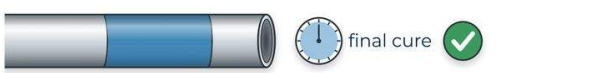









**Repair of leaking Ballast Water pipes using SepcoTech Epoxy & Super Wrap Reinforcement Tape solution.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Apply first layer of SepcoTech Super Guard Coating - approx. 400 µm.

3. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

4. Allow semi-curing.

5. Apply second layer of SepcoTech Super Guard Coating - approx. 400 µm.

6. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

7. Allow semi-curing.

8. Repeat this method until minimum 4 layers of coating and 3 layers of tape are obtained.

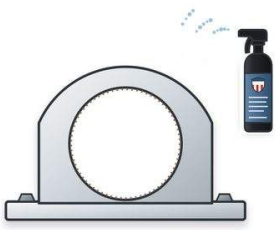
9. Allow final curing.

*Note: Make sure that the coating penetrates the Super Wrap Reinforcement Tape while wrapping. In case of larger holes use SepcoTech Putty stick to preseal the area.*



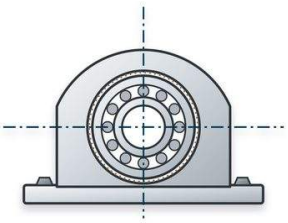
*Includes AI generated images*

# Bearing seat - Cast to fit





Bio Cleaner
remove & degrease

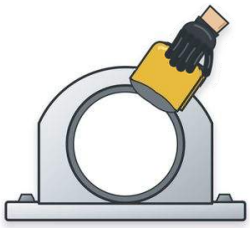


alignment



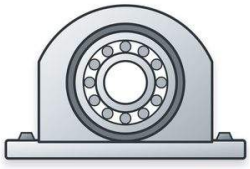


release agent





Super Metal Filler





cure

**Restores oversized bearing seats to proper fit and function.**

1. Remove the old bearing and degrease the seat per SepcoTech surface preparation.

2. Ensure correct alignment, as normal standard mechanical procedure.

3. Apply a thin layer of Release Agent to the new bearing, allow five minutes to dry, then wipe clean until only a film remains.

4. Mix and apply an adequate layer of SepcoTech Super Metal Filler to the bearing seat and the bearing itself.

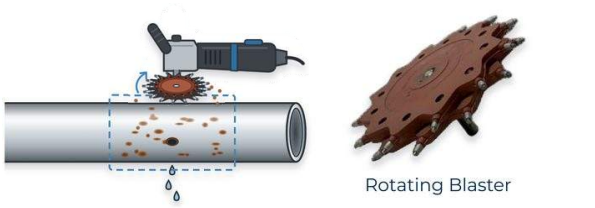
5. Position the bearing correctly in the seat and allow it to cure per the product's directions for use.

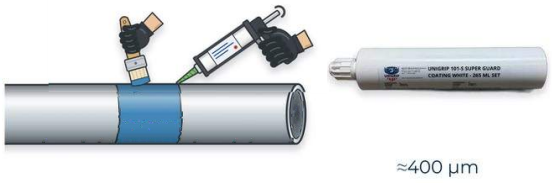
*Note: All SepcoTech products are fully machinable after curing.*

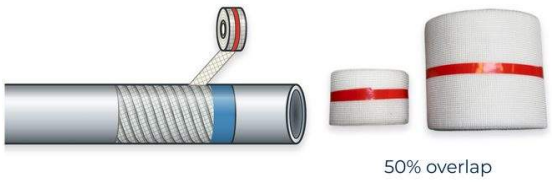


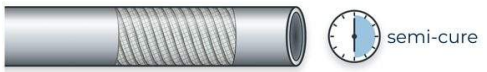
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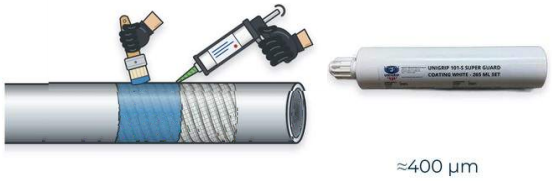
# Cable pipes - Corrosion repair

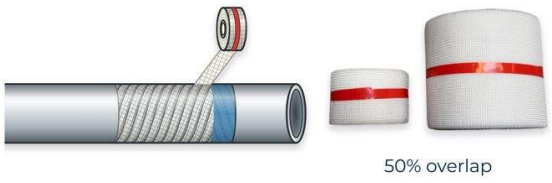






**Repair of Cable Pipes using SepcoTech Epoxy & Super Wrap Reinforcement Tape solution.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Apply first layer of SepcoTech Super Guard Coating - approx. 400 µm.

3. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

4. Allow semi-curing.

5. Apply second layer of SepcoTech Super Guard Coating - approx. 400 µm.

6. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

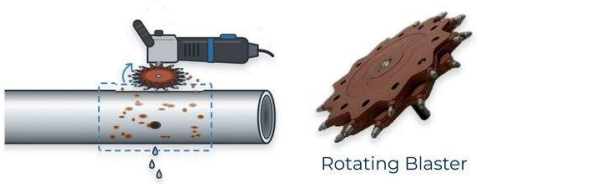
7. Allow final curing.

*Note: Make sure that the coating penetrates the Super Wrap Reinforcement Tape while wrapping. In case of larger holes use SepcoTech Putty stick to preseal the areas or pipe shells.*



*Includes AI generated images*

# Cargo pipes - Repair/sealing leaks











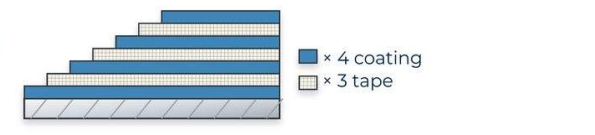


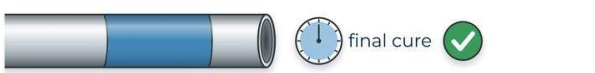









*Includes AI generated images*

**Repair of leaking Cargo pipes using SepcoTech Epoxy & Super Wrap Reinforcement Tape solution.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Apply first layer of SepcoTech Super Guard Coating - approx. 400 µm.

3. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

4. Allow semi-curing.

5. Apply second layer of SepcoTech Super Guard Coating - approx. 400 µm.

6. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

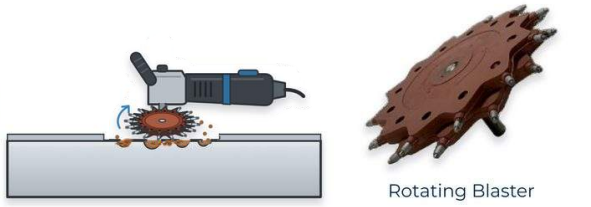
7. Allow semi-curing.

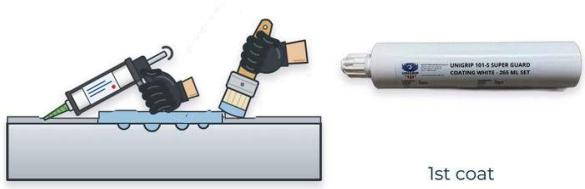
8. Repeat this method until minimum 4 layers of coating and 3 layers of tape are obtained.

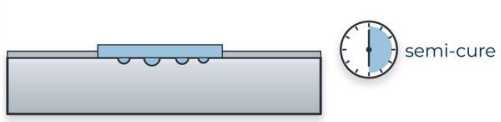
9. Allow final curing.

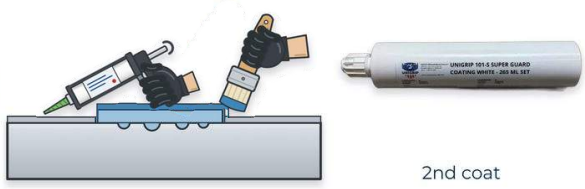
*Note: Make sure that the coating penetrates the Super Wrap Reinforcement Tape while wrapping. In case of larger holes use SepcoTech Putty stick to preseal the area.*

# Coated linings - Touch up







**Damaged linings that require immediate repair to prevent substrate deterioration. We recommend a double layer protective coating.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Apply first layer of SepcoTech Super Guard Coating over the damaged areas.

3. Allow semi-curing.

4. Apply second layer of SepcoTech Super Guard Coating.

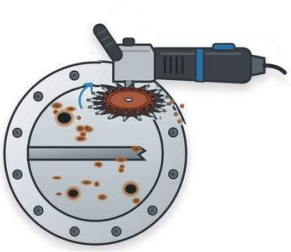
5. Allow curing.

*Note: In case of heavy pitting, use the SepcoTech Super Metal Filler to obtain the original superstructure.*



*Includes AI generated images*

# Cooler end cover



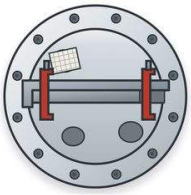


Rotating Blaster



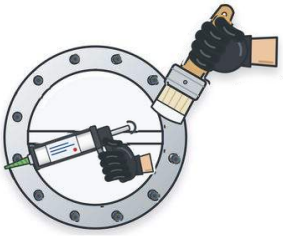


rebuild profile





angle iron
+ release agent





Super Guard white





Super Guard blue

1. Surface preparation. Disassemble the end cover and prepare all surfaces according to SepcoTech's surface preparation guidelines.

2. Rebuild the profile. Restore the original shape using Super Metal Filler. Reinforce any perforations with Super Wrap Reinforcement Tape or, for larger holes, an inlay of metal mesh - its rigidity makes the application easier. Build the filler beyond the damaged edges, then grind back to profile once cured.

3. Reform the division bar. Rebuild the worn edge with the same filler. Before full cure, clamp a piece of angle iron against the flanges as a forming template. Treat the iron with Release Agent first to prevent bonding.

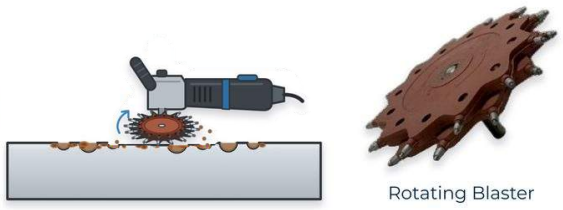
4. First coat. Once the rebuild is semi-cured and back to its original dimensions, apply an even coat of Super Guard White over the entire end cover.

5. Final coat. Allow 1-2 hours' cure, then finish with Super Guard Blue. The contrasting color confirms full coverage of the first coat.



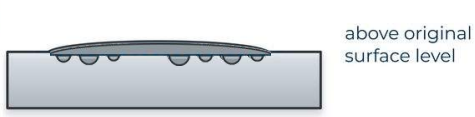
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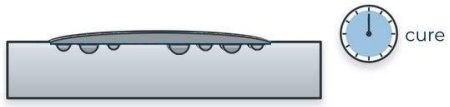
# Cylinder & liners - Pittings













**Repair method to recover superstructure and seal surfaces due to pitting and corrosion damages.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Apply the SepcoTech product. Both Super Metal Filler and the Super Guard Coating can be used depending on the scope of the damaged area.
   a. Heavy deep pitting: use the Super Metal Filler.
   b. Pinhole pittings: use the Super Guard Coating.

3. Rebuild the surface to its original dimensions and structure using SepcoTech products applied above original surface level.

4. Allow curing.

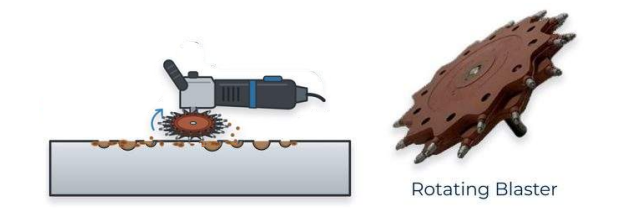
5. Fit to original shape and size by mechanical machining and sanding.

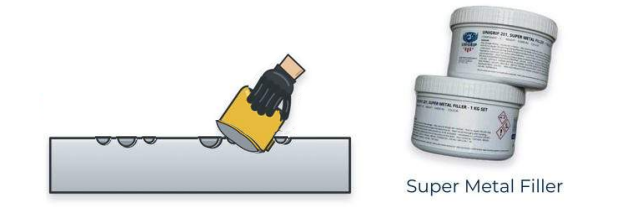
*Note: It is often advantageous to use a custom-shaped sanding tool - for example, one made of putty - to achieve the original surface and dimensions.*

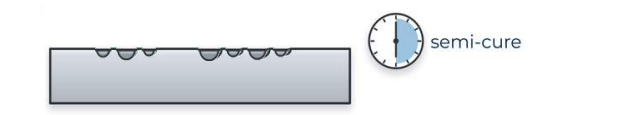


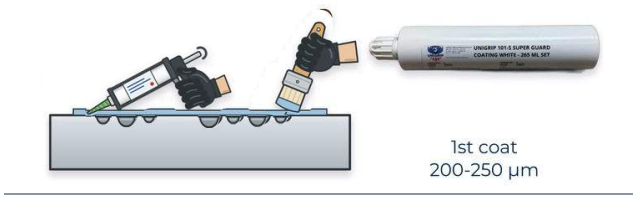
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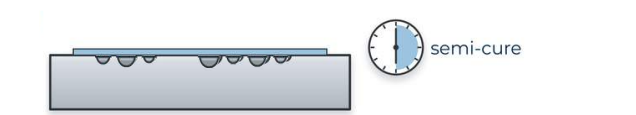
# Deck corrosion

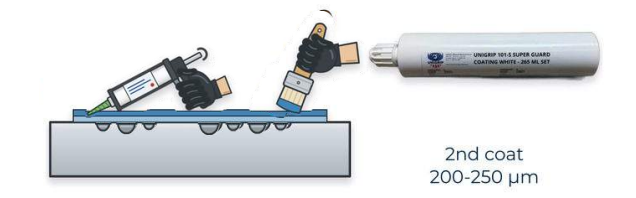


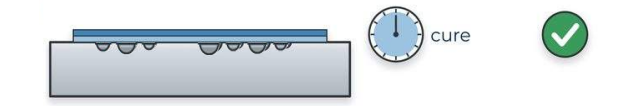




**Deck Pitting due to corrosion, wear & tear often occurs and can be repaired with SepcoTech products.**

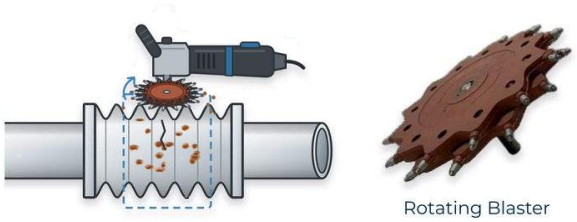
1. Surface preparation acc. to our recommendations.
2. Apply SepcoTech Super Metal Filler to fill out pittings and build up surface.
3. Allow semi-curing.
4. Apply 1st layer of Aqua Guard Coating - 200-250 µm.
5. Allow semi-curing.
6. Apply 2nd layer of Aqua Guard Coating - 200-250 µm.
7. Allow curing.

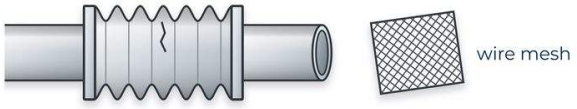
*Note: In cases where there are holes or very limited steel left, we recommend to use a Steel Plate as a "doubler plate" (in between the coating) to reinforce the deck.*

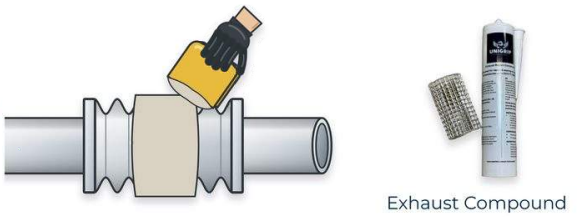


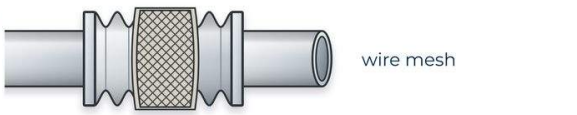
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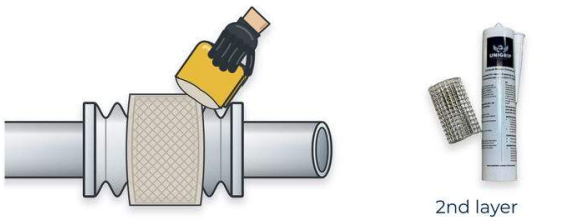
# Exhaust gas bellow repair

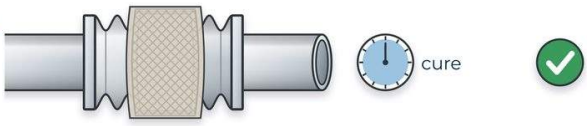



**A temporary, field-applied repair for a leaking exhaust bellow - restoring a gas-tight seal until a replacement bellow can be fitted.**

**Immediate Bellow Repair is considered emergency repair. Using SepcoTech Exhaust Repair Compound the procedure secures the bellow against movement and packs repair compound into the affected grooves.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Prepare wire mesh to support bellow movement in the insertion areas.

3. Apply SepcoTech Exhaust Repair Compound over damaged area.

4. Fit the Wire Mesh into the product immediately after applying the Exhaust Compound.

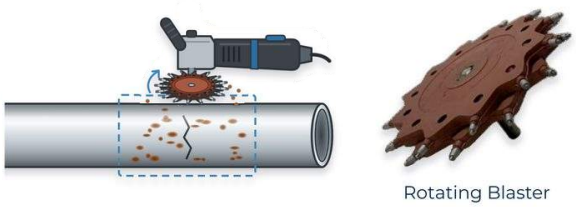
5. Apply a 2nd layer of the Exhaust Repair Compound on top of the wire mesh.

6. Allow curing, let the Exhaust Repair Compound cure for as long as possible.



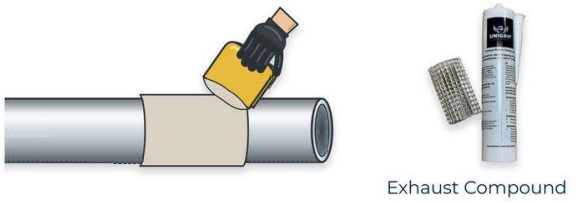
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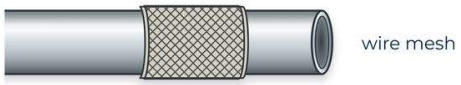
# Exhaust systems - Cracks & leaks

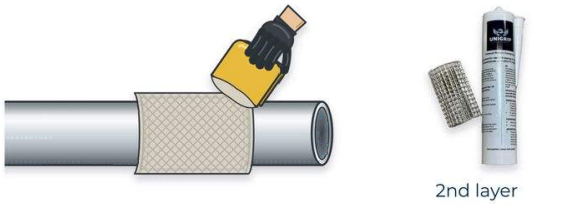












**Cracks and leaks in exhaust systems can be repaired with SepcoTech Exhaust Repair Compound. Temperature resistant up to 1300°C.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Prepare wire mesh to support the compound over the damaged area.

3. Apply SepcoTech Exhaust Repair Compound over damaged area.

4. Fit the Wire Mesh into the product immediately after applying the Exhaust Compound.

5. Apply a 2nd layer of the Exhaust Repair Compound on top of the wire mesh.

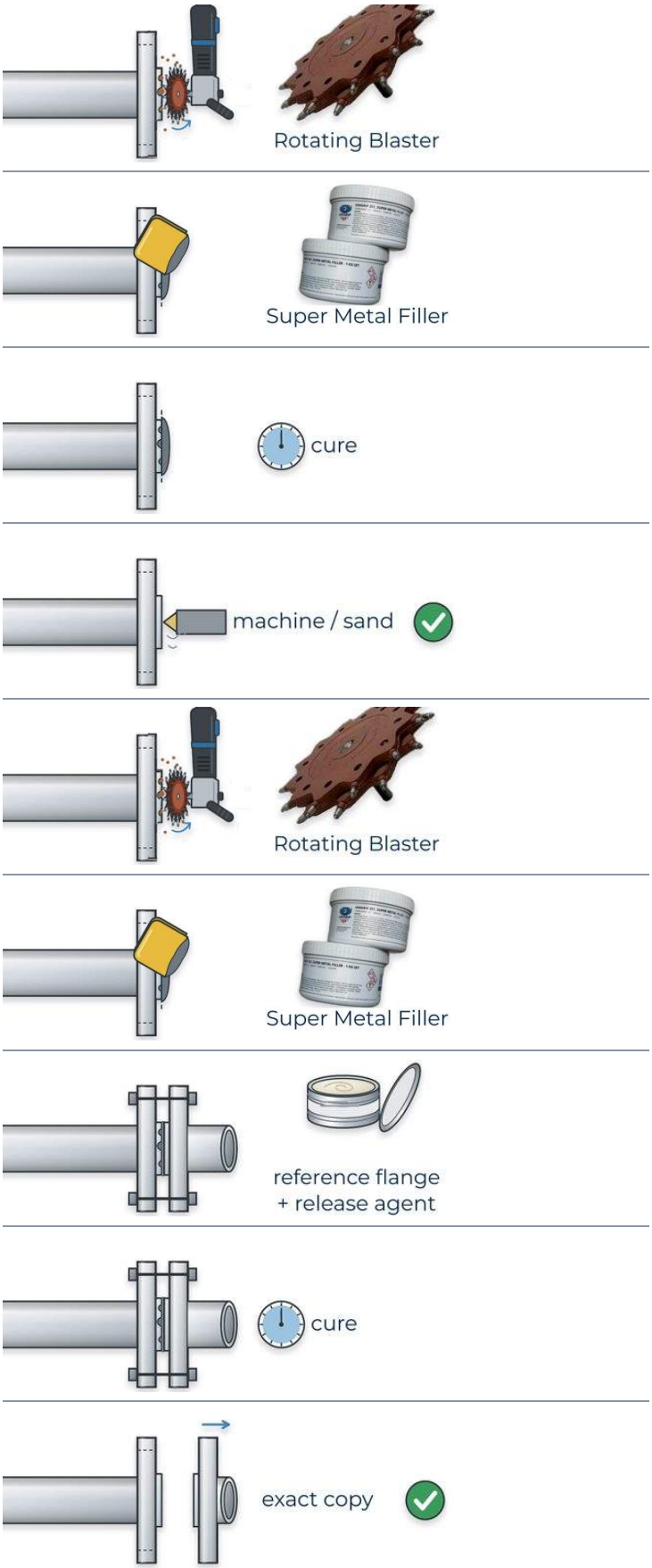
6. Allow curing, let the Exhaust Repair Compound cure for as long as possible.

Note: SepcoTech Exhaust Repair Kit is an immediate temporary repair product.



*Includes AI generated images*

# Flange - Refurbishment




**Recover damaged flange seal surfaces by using SepcoTech Super Metal Filler.**

Option 1

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Rebuild the surface to its original dimensions and structure using SepcoTech Super Metal Filler applied above original surface level.

3. Allow curing.

4. Fit to original shape and size by mechanical machining and sanding.

Option 2

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Rebuild the surface to its original dimensions and structure using SepcoTech Super Metal Filler applied above original surface level.

3. Use a reference flange, apply Release Agent and install it on the repaired flange while the Super Metal Filler is still wet.

4. Allow curing.

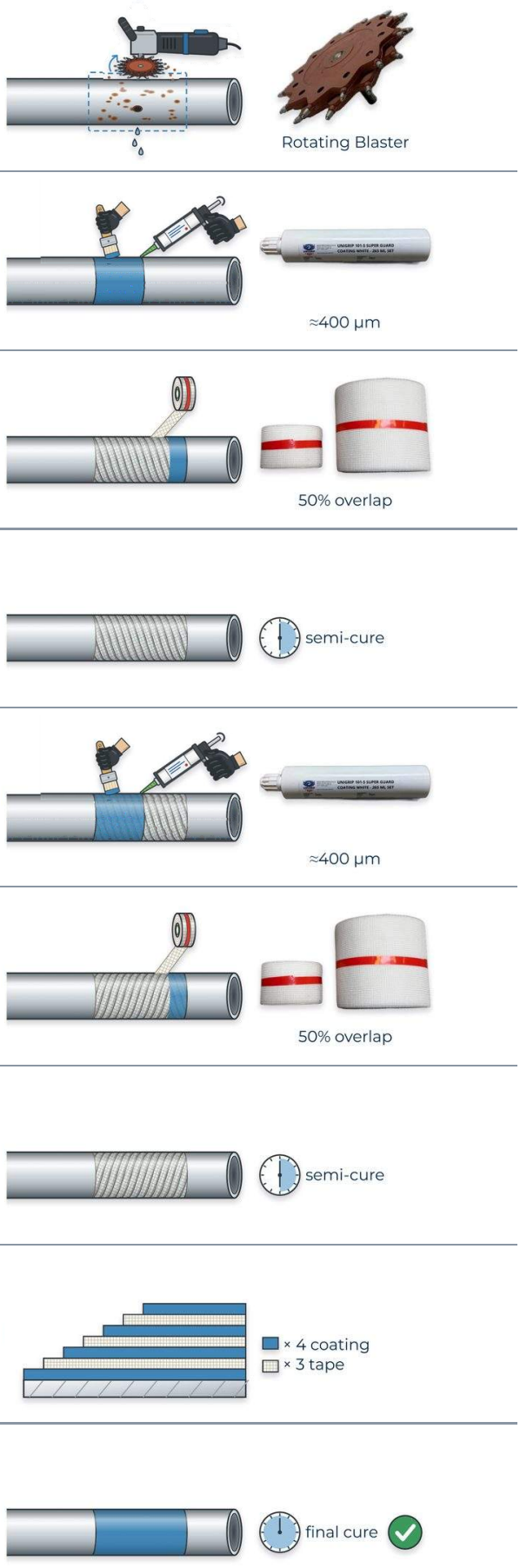
5. Dismantle the reference flange and remove the excess material mechanically. The original shape has now been obtained.

Note: The use of SepcoTech Release Agent will ensure a 100% copy of the reference flange.



*Includes AI generated images*

# GRE Scrubber Pipe




**Repair of cracks and leaking scrubber wash water pipes (GRE or steel) using SepcoTech Epoxy & Super Wrap Reinforcement Tape solution.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Apply first layer of SepcoTech Super Guard Coating - approx. 400 µm.

3. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

4. Allow semi-curing.

5. Apply second layer of SepcoTech Super Guard Coating - approx. 400 µm.

6. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

7. Allow semi-curing.

8. Repeat this method until minimum 4 layers of coating and 3 layers of tape are obtained.

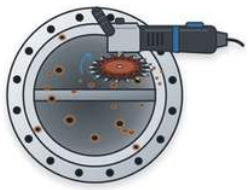
9. Allow final curing.

*Note: Make sure that the coating penetrates the Super Wrap Reinforcement Tape while wrapping. In case of larger holes use SepcoTech Putty stick to preseal the area.*



*Includes AI generated images*

# Heat exchanger cover - Refurbishment



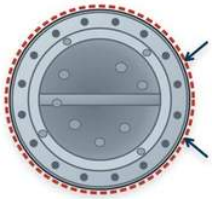


Rotating Blaster





Super Metal Filler



reference plate
cure, machine





1st coat



semi-cure





2nd coat



final cure

**Restore corroded heat exchanger covers, rebuild damaged sealing surfaces and protect them against corrosion.**

1. Remove and inspect the cover. Surface preparation acc. to SepcoTech standards - abrasive blasting is recommended.

2. Rebuild deep damage with SepcoTech Super Metal Filler. Minor pitting can be levelled with Super Guard with the cover positioned horizontally.

3. Apply Release Agent to a flat reference plate and press it against the uncured material on the sealing face. Allow curing, remove the plate and finish by machining.

4. Apply a stripe coat of SepcoTech Super Guard to edges, corners and welds, followed by the first full coat - 200 µm DFT. Keep gasket faces uncoated.

5. Allow semi-curing.

6. Apply a second stripe coat and the second full coat of Super Guard - 200 µm DFT (400 µm in total).

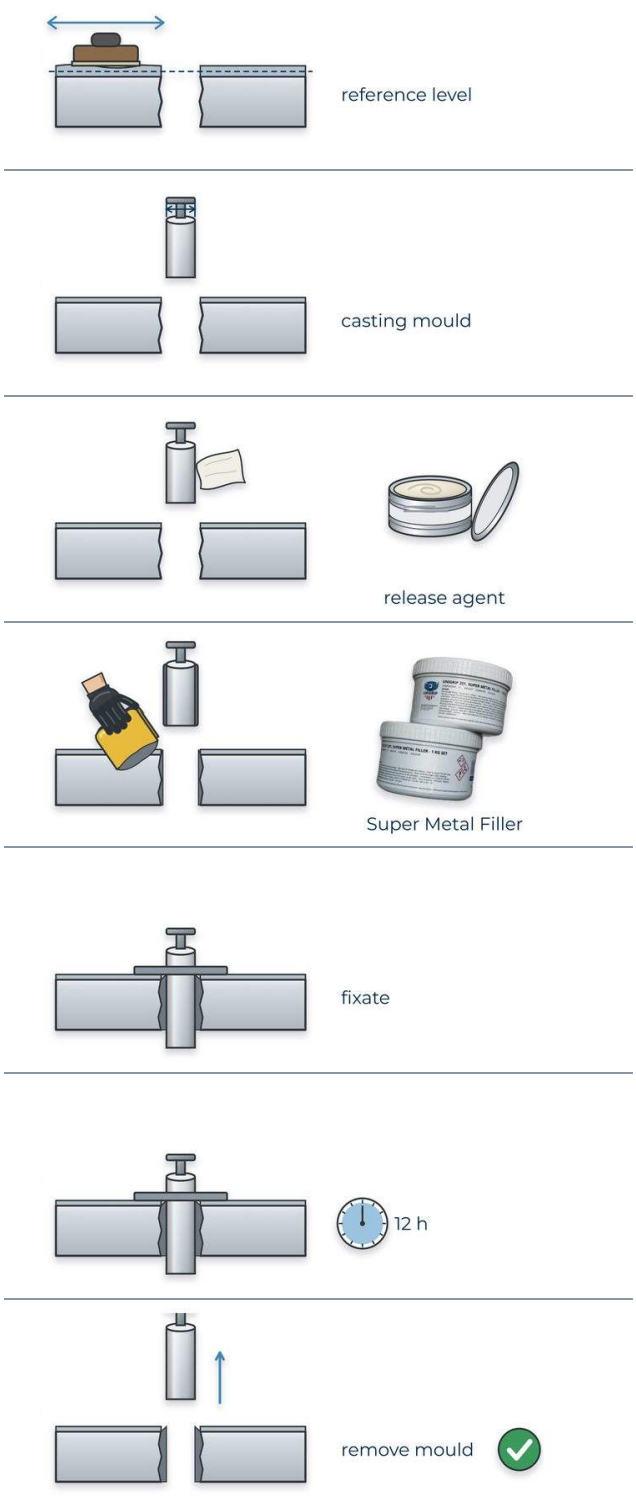
7. Allow final curing. Inspect, reassemble with a new gasket and pressure test.

*Note: Flatness, gasket contact area and tolerances must always be verified. SepcoTech Aqua Guard may be used as an alternative where approved.*



*Includes AI generated images*

# Heat exchanger end plate - Repair




**Repair method for corroded end covers, rebuilding with epoxy compound, and protective coating application.**

1. Sand down the existing epoxy to the reference level according to liner requirements.

2. Create a Casting Mould reference to required liner dimension (hole size).

3. Apply Release Agent on the Casting Mould.

4. Apply Super Metal Filler on the Casting Mould and in the hole.

5. Fixate the Casting Mould in correct position.

6. Await curing time (allow 12 hrs).

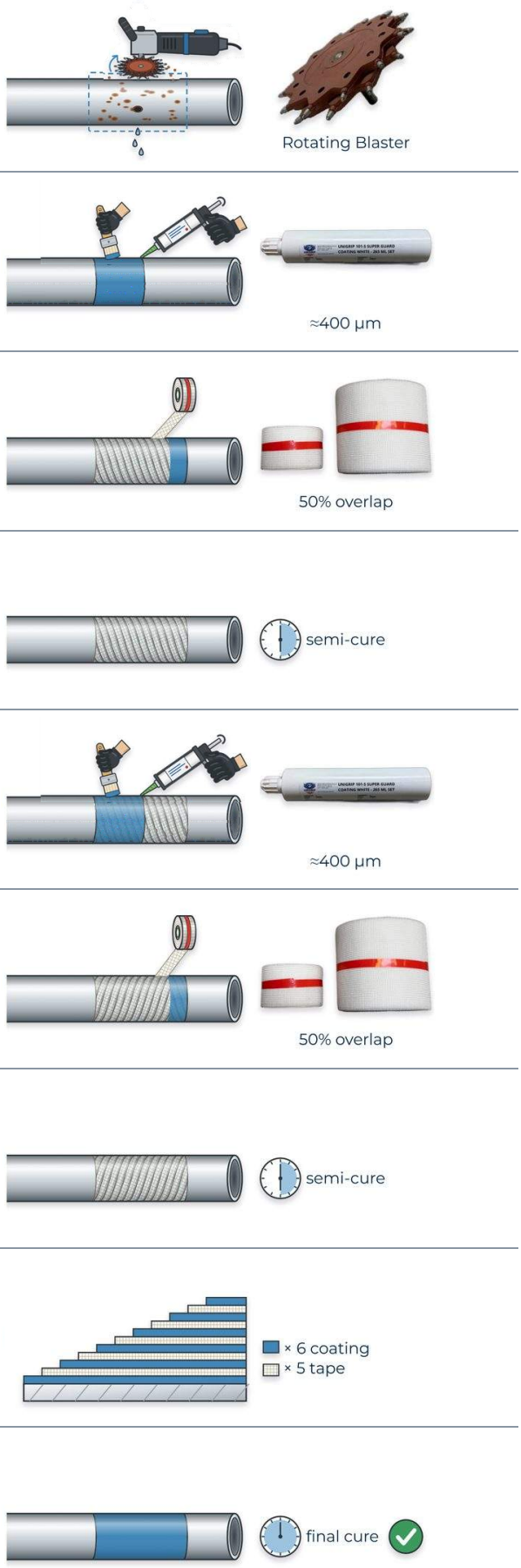
7. Remove the Casting Mould (pull it out). Then you have the exact copy of the mould.

*Note: It is important not to pull out the Casting Mould before the Super Metal Filler is completely cured. If you apply heat with a heating fan, you can reduce the curing time.*



*Includes AI generated images*

# Heating coils - Repair/sealing leaks




**Repair of leaking Heating Coils using SepcoTech Epoxy & Super Wrap Reinforcement Tape solution.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Apply first layer of SepcoTech Super Guard Coating - approx. 400 µm.

3. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

4. Allow semi-curing.

5. Apply second layer of SepcoTech Super Guard Coating - approx. 400 µm.

6. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

7. Allow semi-curing.

8. Repeat this method until minimum 6 layers of coating and 5 layers of tape are obtained.

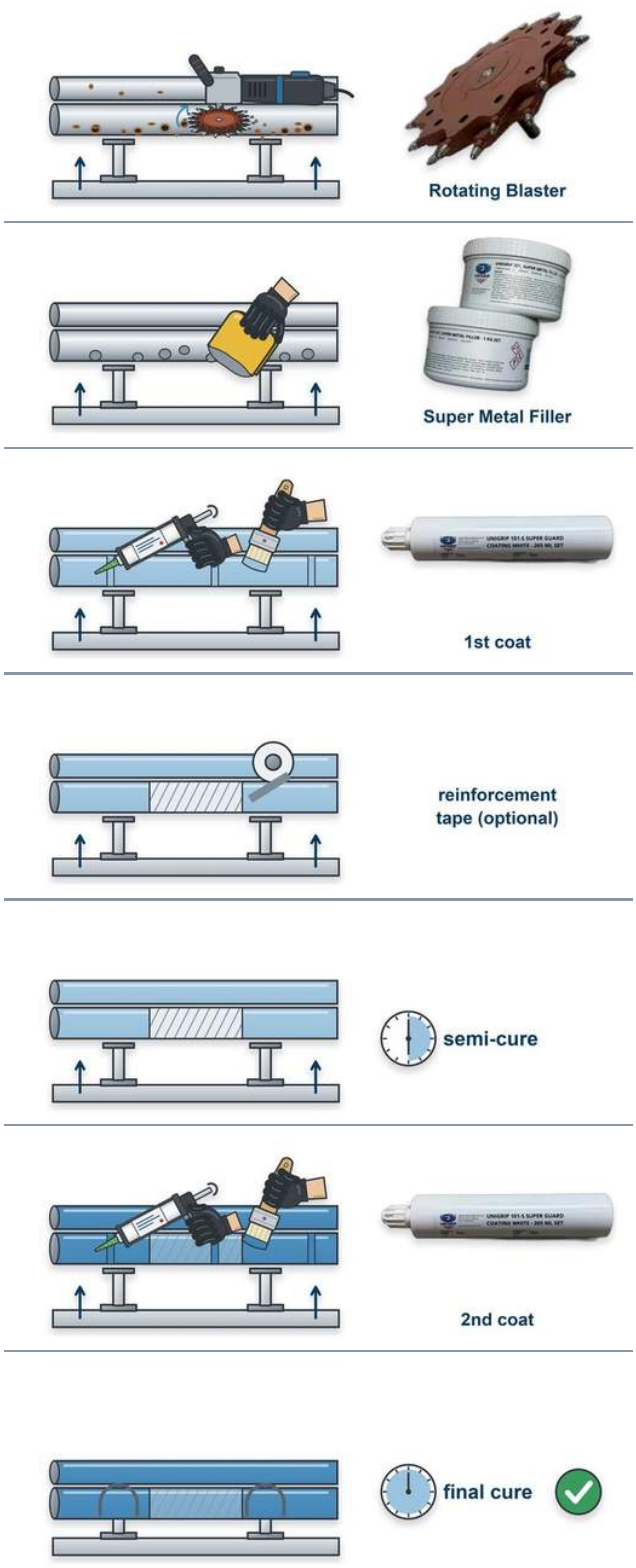
9. Allow final curing.

*Note: Make sure that the coating penetrates the Super Wrap Reinforcement Tape while wrapping.*



*Includes AI generated images*

# Heating coils on deck - Corrosion protection




**Restore corroded heating coil pipework on deck and protect it against external corrosion.**

1. Isolate, drain and cool the system. Loosen the U-bolts and lift the pipes clear of the supports. Surface preparation acc. to SepcoTech standards.

2. Rebuild local pitting with SepcoTech Super Metal Filler to restore a smooth pipe profile.

3. Apply a stripe coat of SepcoTech Super Guard to welds, bends and the pipe undersides, followed by the first full coat - 200 µm DFT.

4. Where specified, wrap reinforcement tape into the wet coating with approx. 50% overlap.

5. Allow semi-curing.

6. Apply a second stripe coat and the second full coat of Super Guard - 200 µm DFT (400 µm in total).

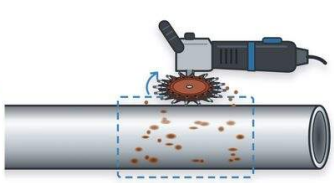
7. Allow final curing. Reinstall the pipes in the supports and return to service.

*Note: The pipe undersides and support points are often the most critical areas. Confirm product suitability for the operating temperature.*



*Includes AI generated images*

# High Pressure Pipes





Sa 2½
min. 40 µm

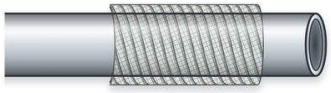


2 pipe shells
gap 4-10 mm





Super Metal Filler
+ pipe clamps





3 layers

**High pressure repair is a demanding task and must be carefully planned. Correct and proper surface preparation is required to achieve a good result.**

1. Surface preparation acc. SepcoTech recommendation Sa 2½ min. 40 µm.

2. Prepare two pipe shells, Illustration 2, dimension half thickness of original pipe or minimum 3mm, allowing a gap of 4-10 mm between the surface of the pipe and the internal surface of the pipe shells. Carry out surface preparation on the internal surfaces of the shells.

3. Apply SepcoTech Super Metal Filler into the areas and mount the shells as shown in illustration 3. Hold the shells in position by the use of pipe clamps or the like.

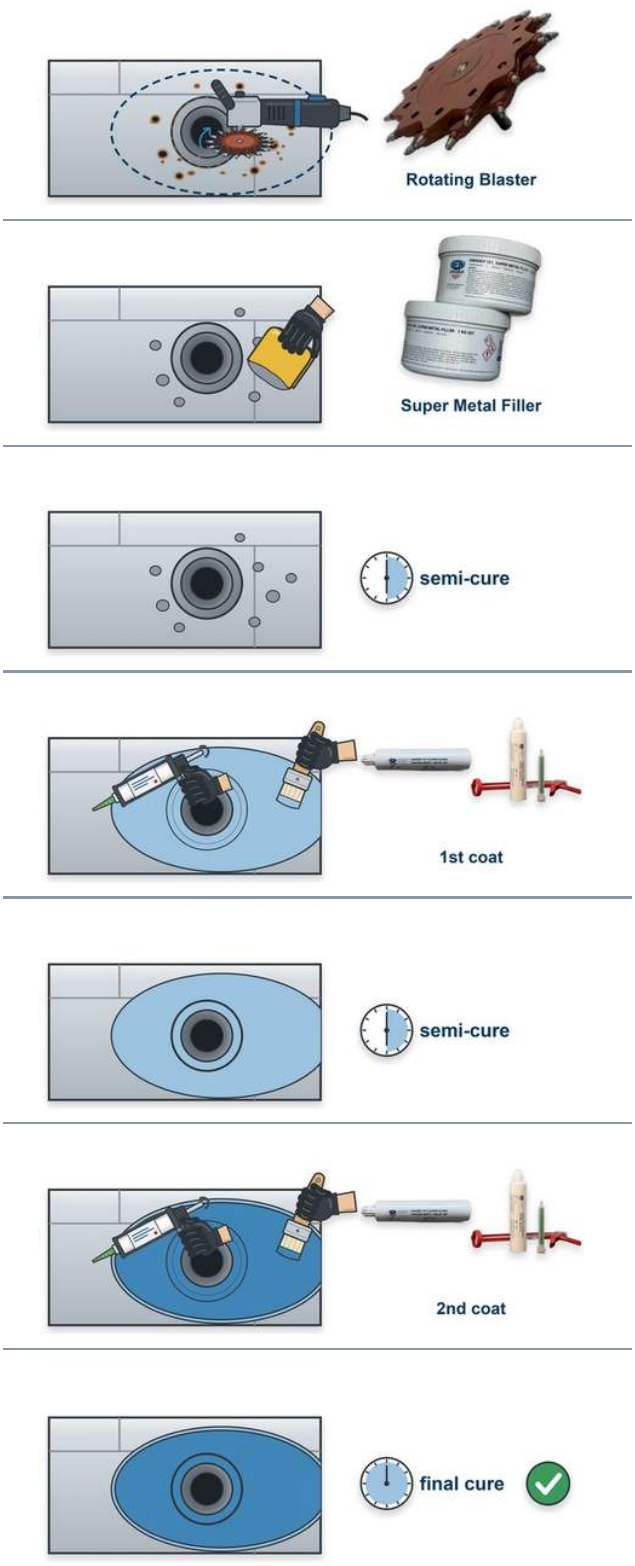
4. Reinforce by wrapping

- 1st layer - Apply 500 µm SepcoTech Super Metal Filler
- Wrap SepcoTech Super Wrap Reinforcement Tape into the Super Metal Filler
- Allow semi-curing
- 2nd layer - Apply SepcoTech Super Guard Coating - 500 µm
- Wrap SepcoTech Super Wrap Reinforcement Tape into the coating
- Allow semi-curing
- 3rd layer - Apply final layer coating
- Allow curing



*Includes AI generated images*

# Overboard Hull protection




**Protection of the hull area around the scrubber outlet, exposed to aggressive scrubber wash water.**

1. Define the protection area around the outlet, according to outlet geometry and discharge direction. Surface preparation acc. to SepcoTech standards over the complete area.

2. Rebuild corroded or pitted areas using SepcoTech Super Metal Filler, where required.

3. Allow semi-curing.

4. Apply a stripe coat of SepcoTech Super Guard to the outlet-to-hull transition, welds and edges, followed by the first full coat - 200 µm DFT.

5. Allow semi-curing.

6. Apply a second stripe coat and the second full coat of SepcoTech Super Guard - 200 µm DFT (total approx. 400 µm DFT).

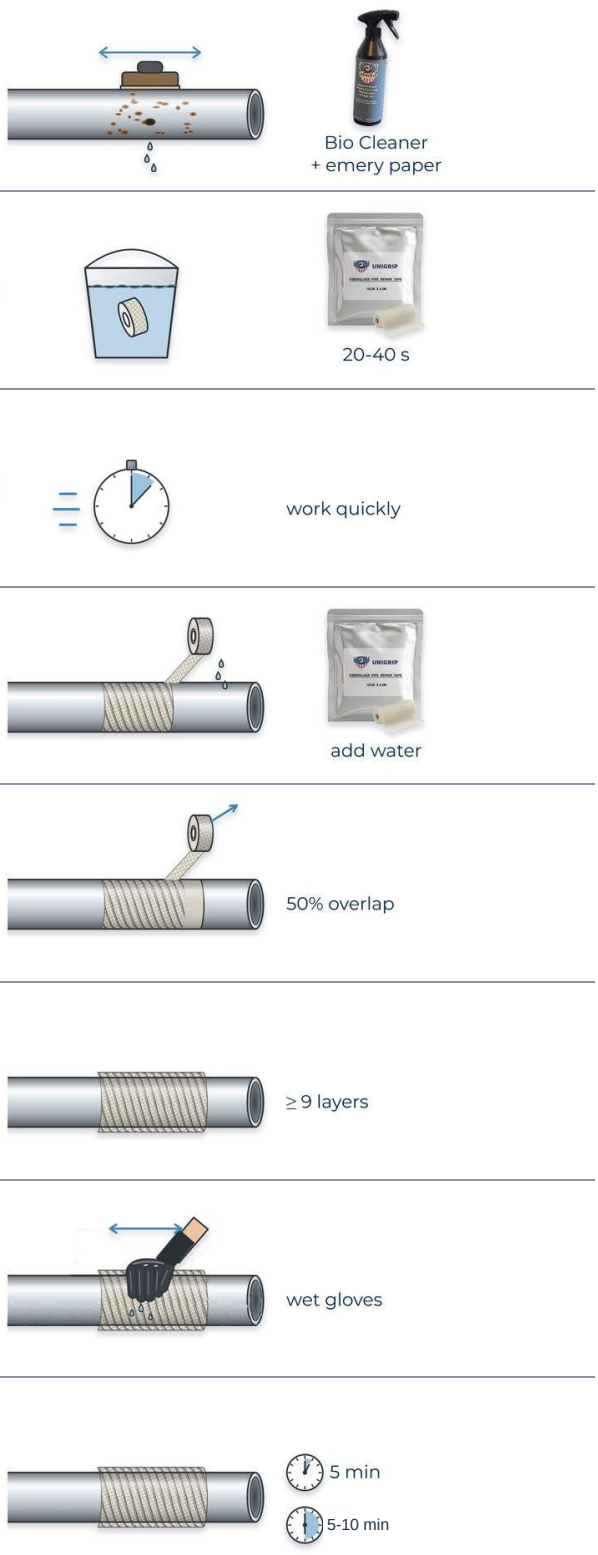
7. Allow final curing.

*Note: Brush application of Super Guard is recommended. Alternatively, SepcoTech Aqua Guard can be used in the same sequence - 200 µm DFT per coat, applied by brush, roller or spray.*



*Includes AI generated images*

# Pipe repair - Emergency




**Emergency method for leaking pipes using SepcoTech QuickFix Pipe Repair Tape and optional Putty; pot life 5 minutes and cure time 5-10 minutes.**

1. Clean and roughen the working surface, grind it with emery paper or similar.

2. Unpack the SepcoTech QuickFix Pipe Repair Tape and submerge it in water for 20-40 seconds to activate the resin which is already impregnated into the tape.

3. Make sure to work quickly as the curing is fast.

4. Apply the Tape firmly onto the repair area. With your gloved hands add water to the roll (QuickFix Pipe Repair Tape) as it is being wrapped around the repair section.

5. Apply hand tension (50% overlap) to prevent any entrapped air.

6. Ensure that a minimum 9 layer wrap of SepcoTech QuickFix Pipe Repair Tape is applied over the damaged area.

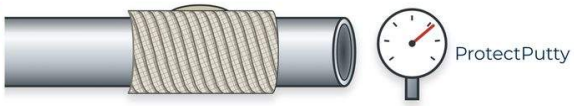
7. Dip gloves in water and smooth out the surface with your hands.

8. The pot life is 5 minutes, and the product is cured after 5-10 minutes.



*Includes AI generated images*




9. If there still is a leakage before applying the tape use Putty first, held in place with a small metal plate and steel band, before applying the QuickFix Pipe Repair Tape.

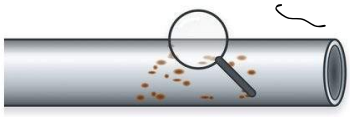
10. For higher pressure pipes, use Putty.

*Note: 1 x 9 layers of SepcoTech QuickFix Pipe Repair Tape = 145 psi (10 Bar) pressure before leaking.*
*2 x 9 layers of SepcoTech QuickFix Pipe Repair Tape with putty = 1500 psi (103 Bar) pressure before leaking.*



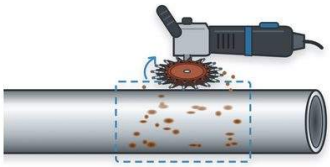
*Includes AI generated images*

# Pipe wrap





Bio Cleaner

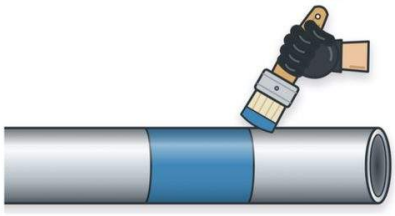




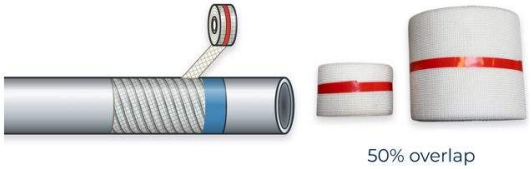
Rotating Blaster



mix coating



400 µm



50% overlap

## Surface preparations:

Surface preparations must always be in compliance with clients specifications or job requirements.

- Inspect the pipe for corrosion, scale, coatings, oil, and contaminants.
- Identify the repair area and extend the preparation area at least 10 cm. beyond the repair zone.
- Remove oil, grease, salt, and contaminants before blasting.
- Allow the surface to dry completely.
- Start the rotating blaster and move it steadily along the pipe section.
- Achieve a surface cleanliness equivalent to near-white metal.
- Ensure the blasting produces a surface roughness profile of minimum 40 µm suitable for epoxy adhesion.

## First layer of epoxy coating:

- Mix the coating out on to a mixing board or apply directly on the pipe.
- Apply the epoxy coating evenly on the prepared pipe surface using a brush or a roller.
- Aim to achieve a Wet Film Thickness of 400 µm.

Ensure:

- Full coverage of the prepared surface.
- No dry spots or air pockets.
- The coating remains wet/tacky before wrapping.

<u>Wrapping</u>

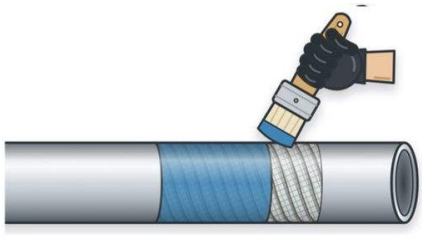
- Start wrapping from one end of the prepared area.
- Maintain constant tension on the tape during wrapping.
- Apply the tape with 50% overlap.
- Allow semi-curing.

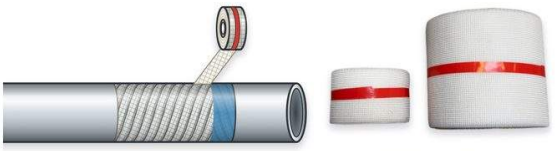


*Includes AI generated images*

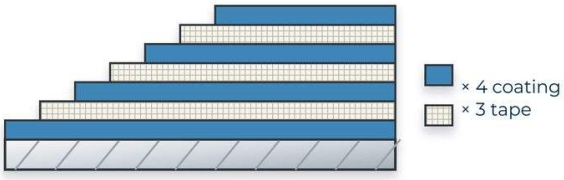


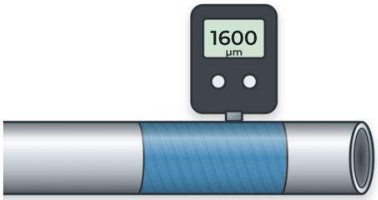
2nd coat



50% overlap




check thickness

## Second layer of epoxy coating

- Mix the coating out on to a mixing board or apply directly on the first layer.
- Apply the epoxy coating evenly on the prepared pipe surface using a brush or a roller.
- Aim to achieve a Wet Film Thickness of 400 µm.

Ensure:

- Full coverage of the prepared surface.
- No dry spots or air pockets.
- The coating remains wet/tacky before wrapping.

Wrapping

- Start wrapping from one end of the prepared area.
- Maintain constant tension on the tape during wrapping.
- Apply the tape with 50% overlap.
- Allow semi-curing.

Same procedure continues until 4 layers of coating & 3 layers of Super Wrap Reinforcement Tape obtained.

***Products used:***

Super Guard Blue 265 ml - item no. 10234

Super Guard White 265 ml - item no. 10233

Super Wrap Reinforcement Tape Small 5 cm x 10 m - item no. 10251

Static mixing nozzle - item no. 10260

Caulking gun - item no. 10263

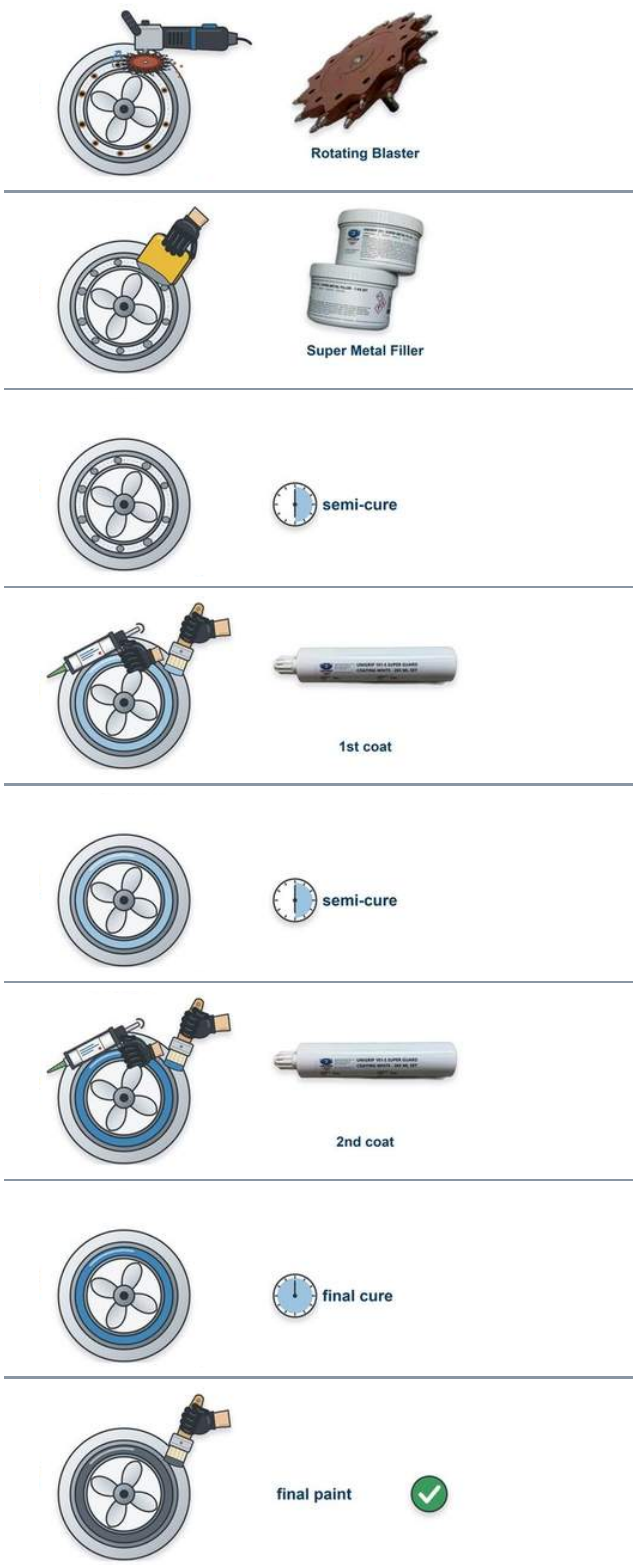
Rotating Blaster Duo - item no. 10267

Bio Cleaner 0.5 l - item no. 10254



*Includes AI generated images*

# Propeller Nozzle




**Propeller nozzles are commonly exposed to bi-metallic corrosion due to mixed metals. Rebuilding the pittings and applying a protective coating extends the lifetime.**

1. Surface preparation acc. to SepcoTech standards, over the affected area (the welding belt).

2. Rebuild the surface to its original dimensions using SepcoTech Super Metal Filler, filling the pittings.

3. Allow semi-curing.

4. Apply the first layer of SepcoTech Super Guard Coating.

5. Allow semi-curing.

6. Apply the second layer of SepcoTech Super Guard Coating.

7. Allow final curing.

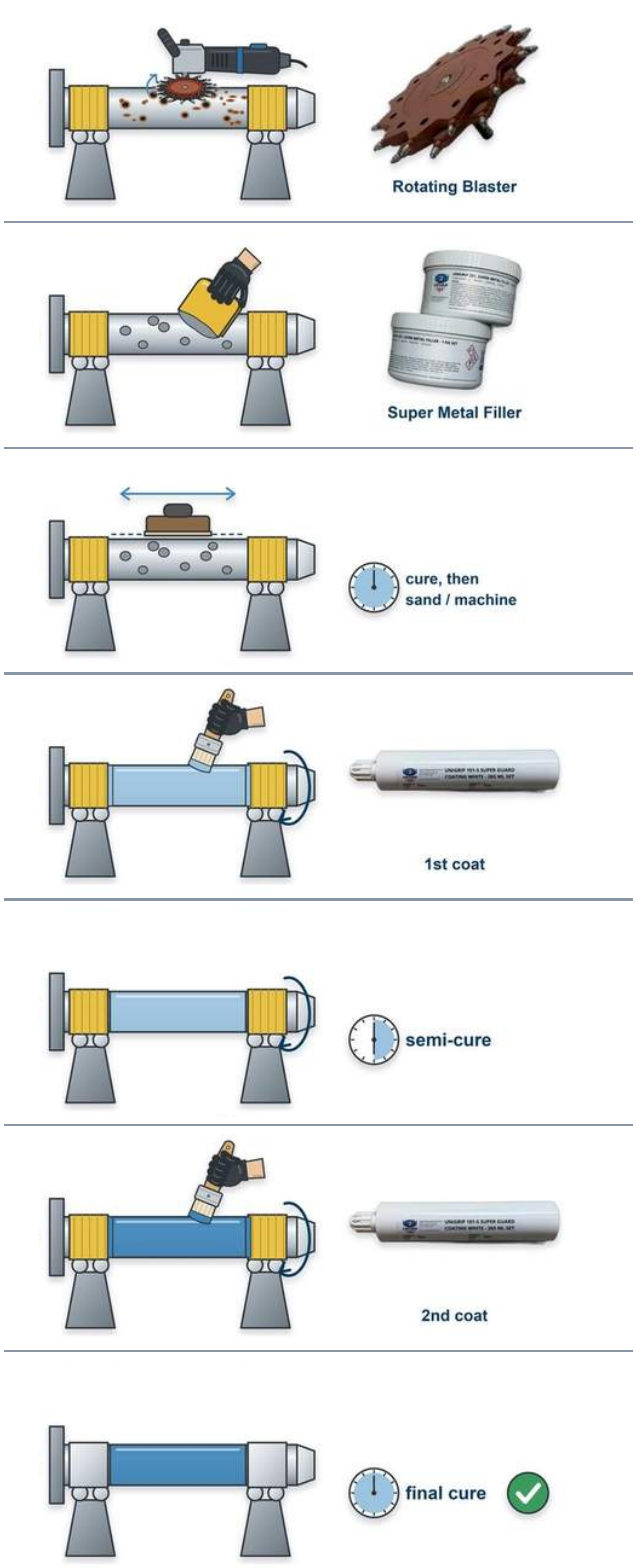
8. Final paint.

*Note: In general, propulsion areas suffering from bi-metallic corrosion can be repaired using the same application principles.*



*Includes AI generated images*

# Propeller shaft - Corrosion protection




**Protect exposed propeller shaft surfaces against galvanic corrosion and seawater exposure.**

1. Inspect the shaft and mask bearing journals, seal surfaces, coupling fits and threads. Surface preparation acc. to SepcoTech standards.

2. Rebuild local pitting with SepcoTech Super Metal Filler where approved.

3. Allow curing and restore the surface geometry by sanding or machining.

4. Apply a stripe coat of SepcoTech Super Guard, followed by the first full coat - 200 µm DFT by brush while rotating the shaft slowly.

5. Allow semi-curing.

6. Apply a second stripe coat and the second full coat of Super Guard - 200 µm DFT, with slow rotation.

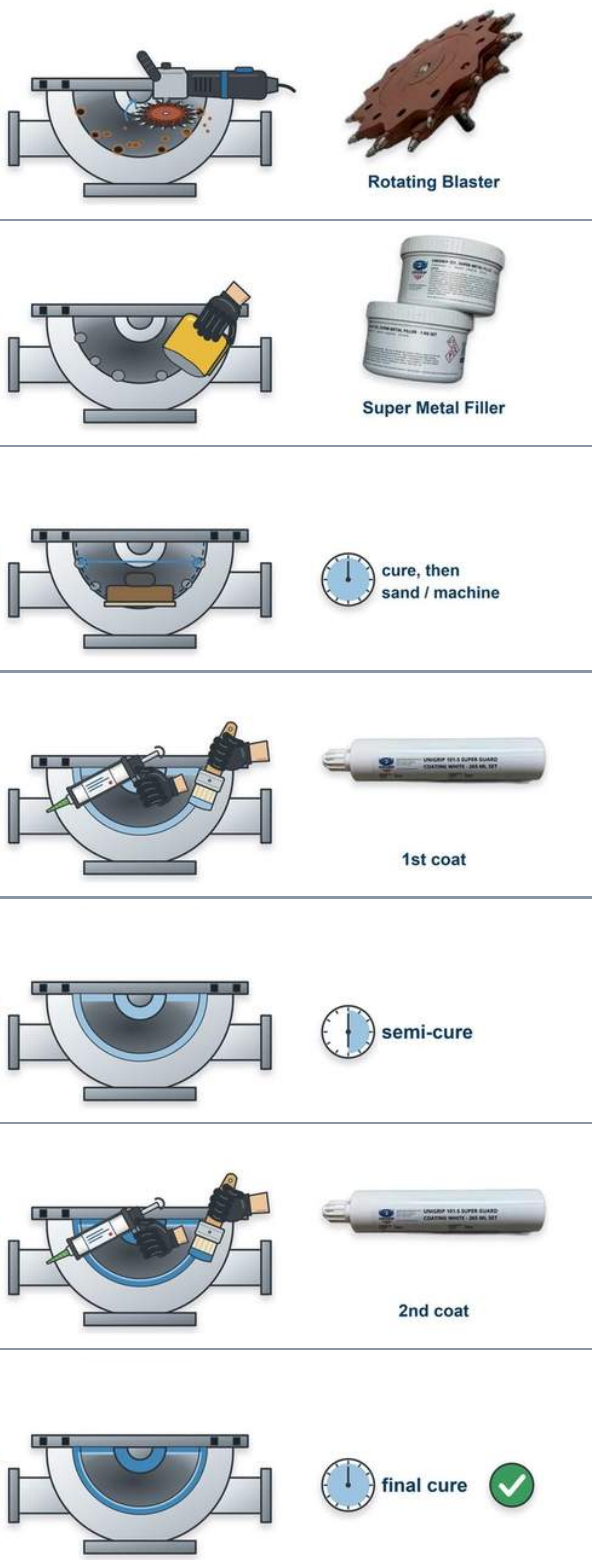
7. Allow final curing. Remove the masking and inspect before returning to service.

*Note: Do not coat bearing journals, seal running surfaces or coupling fits. SepcoTech Aqua Guard may be used as an alternative where approved.*



*Includes AI generated images*

# Pumps - Refurbishment




**Restore corroded and eroded internal surfaces of split case pumps and protect them against corrosion.**

1. Dismantle and inspect the pump. Surface preparation acc. to SepcoTech standards. Protect bearing locations and sealing faces.

2. Rebuild pits and eroded areas using SepcoTech Super Metal Filler, restoring the original casing profile.

3. Allow curing. Finish by sanding or machining where needed, keeping flow passages and clearances.

4. Apply a stripe coat of SepcoTech Super Guard to edges and welds, followed by the first full coat - 200 µm DFT.

5. Allow semi-curing.

6. Apply a second stripe coat and the second full coat of Super Guard - 200 µm DFT.

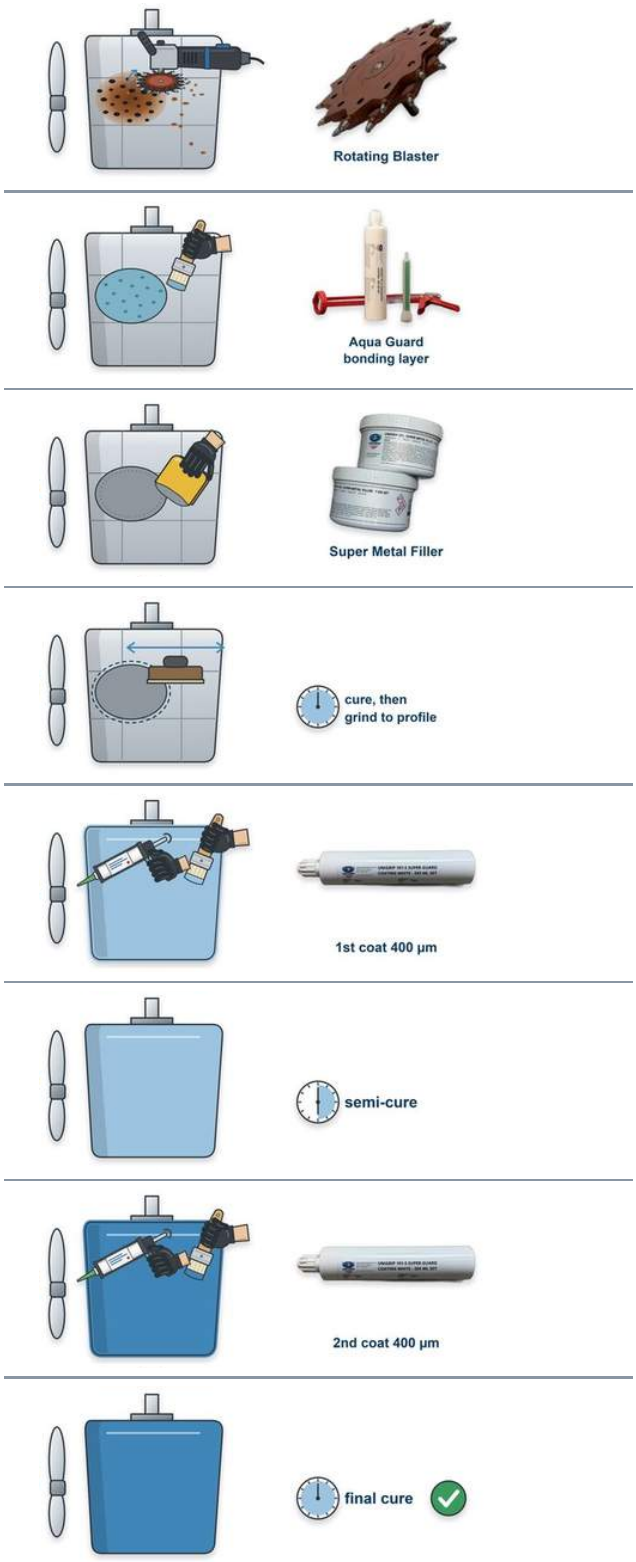
7. Allow final curing, inspect the coating, then reassemble and test the pump.

*Note: Coating must not interfere with bearing seats, impeller clearances or sealing faces. Brush application of Super Guard is recommended.*



*Includes AI generated images*

# Rudder - Cavitation damage




**Rebuild cavitation-damaged rudder surfaces, restore the profile and apply heavy-duty protection.**

1. Inspect and complete any required steel repairs. Grit blast to Sa 2½, min. 40 µm profile.

2. Apply a thin bonding layer of SepcoTech Aqua Guard, worked into the profile and pits.

3. Rebuild the damaged areas with SepcoTech Super Metal Filler, slightly above the original profile.

4. Allow curing and grind to the original hydrodynamic profile with smooth transitions.

5. Apply a stripe coat of SepcoTech Super Guard, followed by the first full coat - 400 µm DFT.

6. Allow semi-curing.

7. Apply a second stripe coat and the second full coat - 400 µm DFT (800 µm in total).

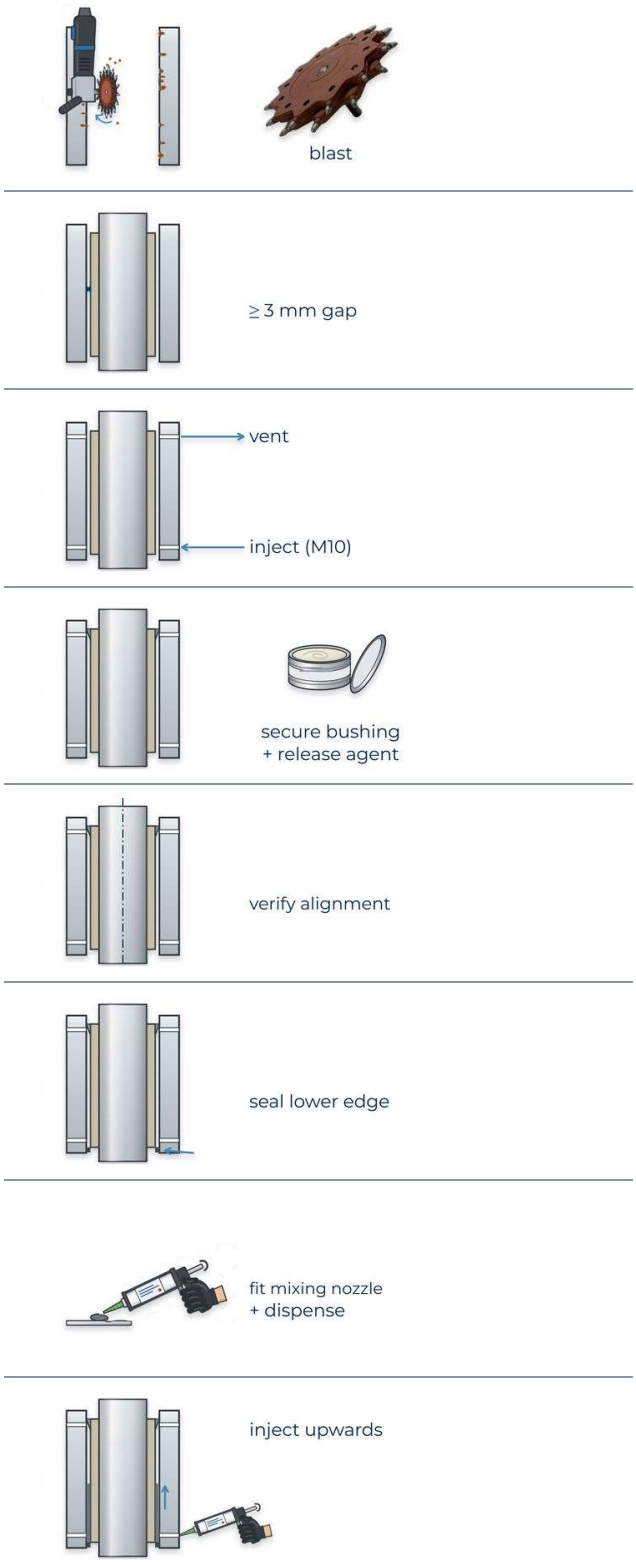
8. Allow final curing. Inspect the profile and coating before service.

*Note: Cavitation is repeated mechanical impact, not only corrosion. A tough, well-bonded repair is more durable than the hardest material.*



*Includes AI generated images*

# Rudder stock bushing - Cast to fit




**Installation of a new or replacement rudder stock bushing using the SepcoTech Cast-to-Fit method. All mechanical work follows normal mechanical procedures and vessel requirements.**

1. Surface preparation acc. to SepcoTech standards. Surfaces must be clean, sound and roughened - blasting is preferred.

2. Ensure a continuous casting gap of min. approx. 3 mm between bushing and rudder trunk.

3. Make injection points at the bottom (e.g. M10) and venting points at the top.

4. Position, align and secure the bushing. Apply Release Agent to any temporary bolts or fixtures.

5. Verify alignment before casting - the casting material does not correct alignment.

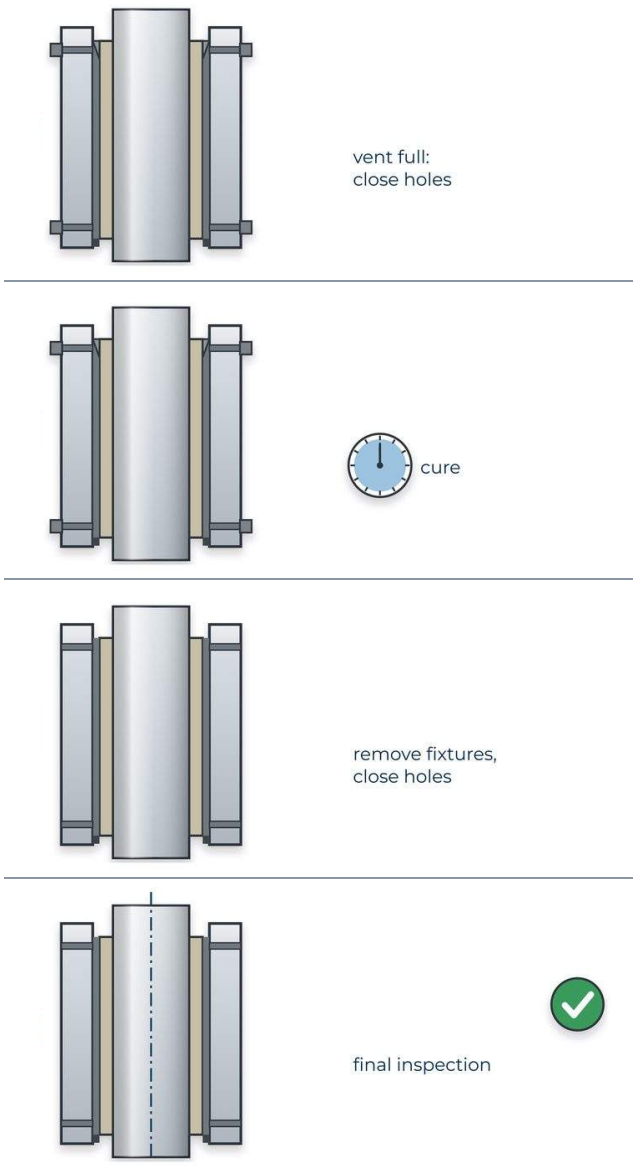
6. Seal the lower edge between bushing and rudder trunk.

7. Fit the static mixing nozzle to the cartridge and dispense a little material until evenly mixed.

8. Inject slowly from the lowest point and work upwards, one injection point at a time. Avoid excessive pressure.



*Includes AI generated images*




9. Stop when material appears at the top venting points, then close the holes with threaded bolts.

10. Allow full curing - do not disturb or load the bushing.

11. Remove temporary bolts, fixtures and excess material. Close all holes with SepcoTech repair material.

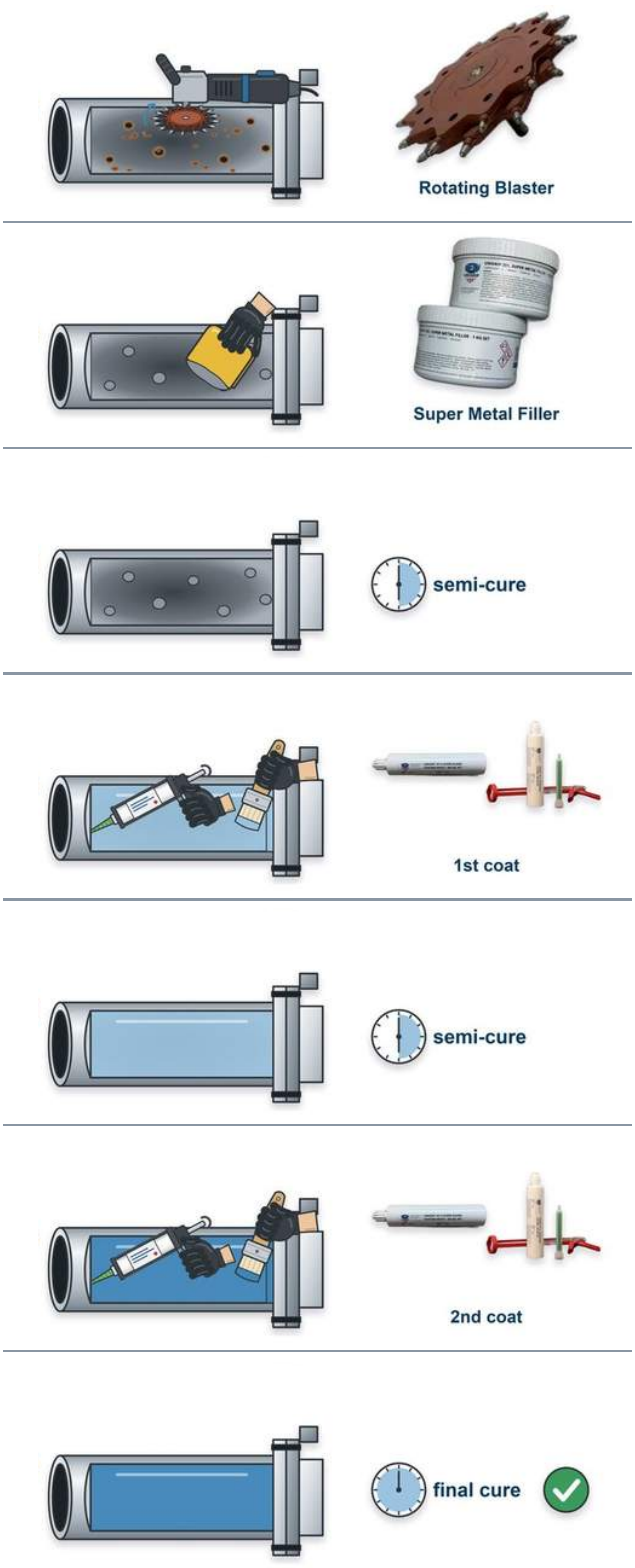
12. Final inspection of alignment, tolerances, clearances and complete filling.

Note: The Cast-to-Fit method does not replace normal mechanical installation and alignment. SepcoTech pre-filled cartridges with static mixing nozzles need no manual mixing - faster, cleaner and more controlled.



*Includes AI generated images*

# Scrubber overboard outlet




**Internal protection of the scrubber overboard pipe and spool piece, exposed to aggressive scrubber wash water.**

1. Inspect the internal surface for corrosion, erosion and pitting. Surface preparation acc. to SepcoTech standards.

2. Rebuild corroded or pitted areas using SepcoTech Super Metal Filler, where required.

3. Allow semi-curing.

4. Apply a stripe coat of SepcoTech Super Guard to welds, edges and flange transitions, followed by the first full coat - 200 µm DFT.

5. Allow semi-curing.

6. Apply a second stripe coat and the second full coat of SepcoTech Super Guard - 200 µm DFT (total approx. 400 µm DFT).

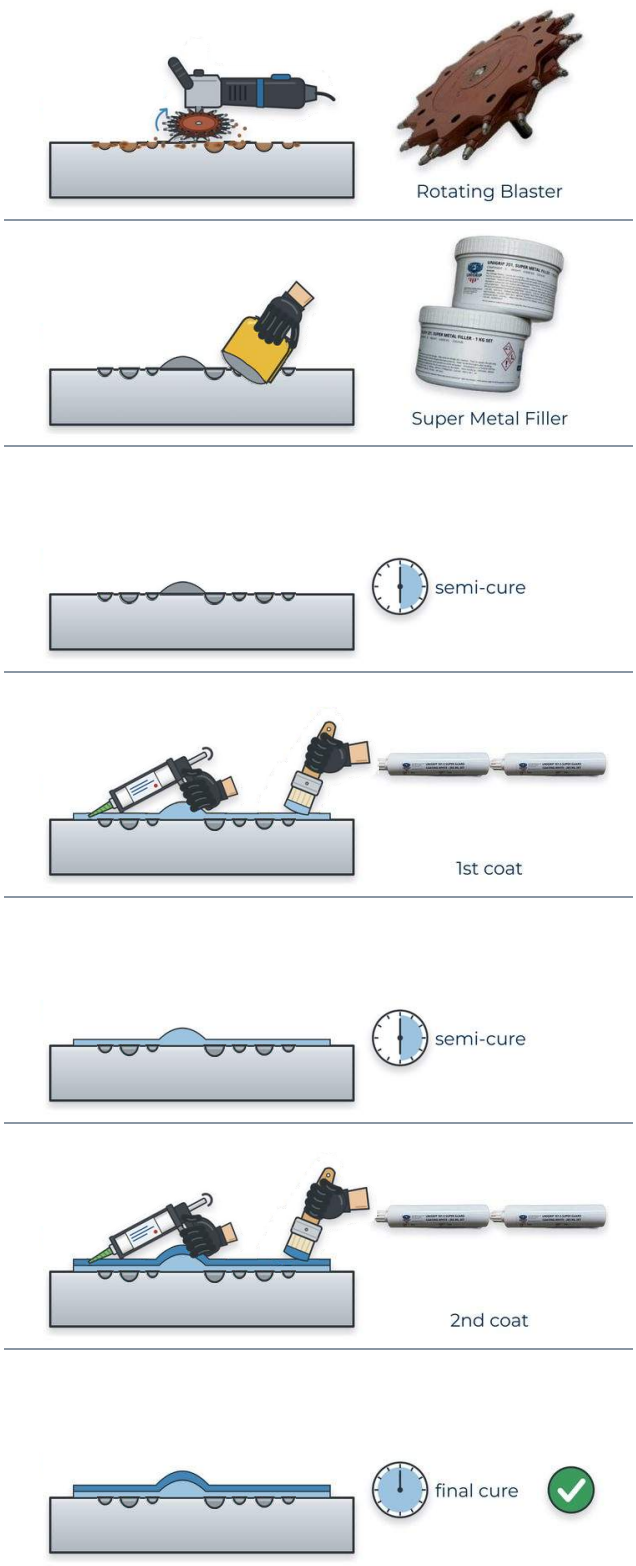
7. Allow final curing.

*Note: Pay particular attention to the connection between the overboard pipe and the overboard valve flange. Alternatively, SepcoTech Aqua Guard can be used in the same sequence - 200 µm DFT per coat.*



*Includes AI generated images*

# Sea chest - Protection




**Life extension of Sea Chest exposed to erosion, corrosion and bimetallic corrosion.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Rebuild the surface to its original dimensions and structure using SepcoTech Super Metal Filler in the heavily deteriorated areas and in the welding areas.

3. Allow semi-curing.

4. Apply the first layer of SepcoTech Super Guard or Aqua Guard Coating.

5. Allow semi-curing.

6. Apply the second layer of SepcoTech Super Guard or Aqua Guard Coating.

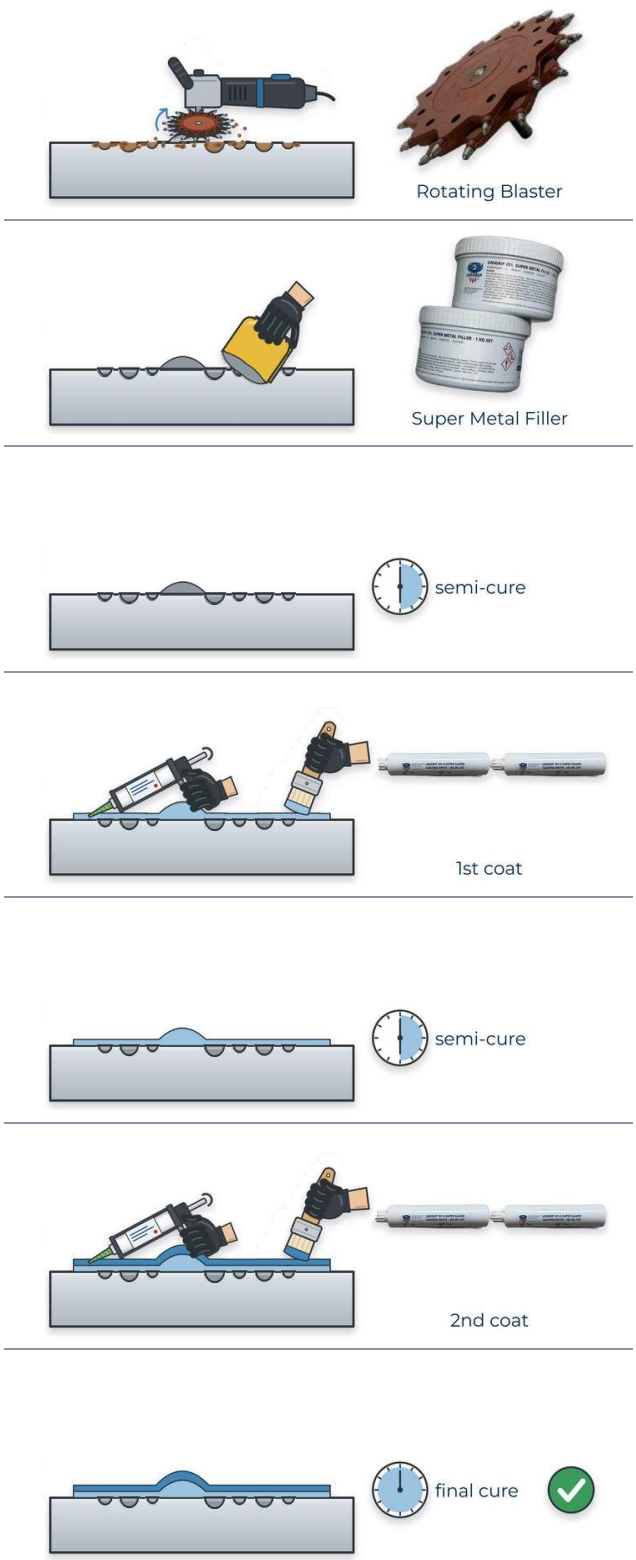
7. Allow final curing.

*Note: Following the technical information and guidance ensures years of lifetime extension.*



*Includes AI generated images*

# Sea chest/sea water filter




**Protection of sea chest and sea water filter against corrosion, erosion and marine fouling.**

1. Isolate and, if possible, dismantle the sea water filter. Remove all salt, grease, oil and marine fouling with high-pressure fresh water and a suitable degreaser if required. Surface preparation acc. to SepcoTech standards.

2. Rebuild deteriorated areas to their original dimensions using SepcoTech Super Metal Filler.

3. Allow semi-curing.

4. Apply the first layer of SepcoTech Aqua Guard Coating with a brush or roller - Wet Film Thickness of 200-250 µm.

5. Allow semi-curing. The coating should remain wet/tacky before applying the second layer.

6. Apply the second layer of SepcoTech Aqua Guard Coating - Wet Film Thickness of 200-250 µm.

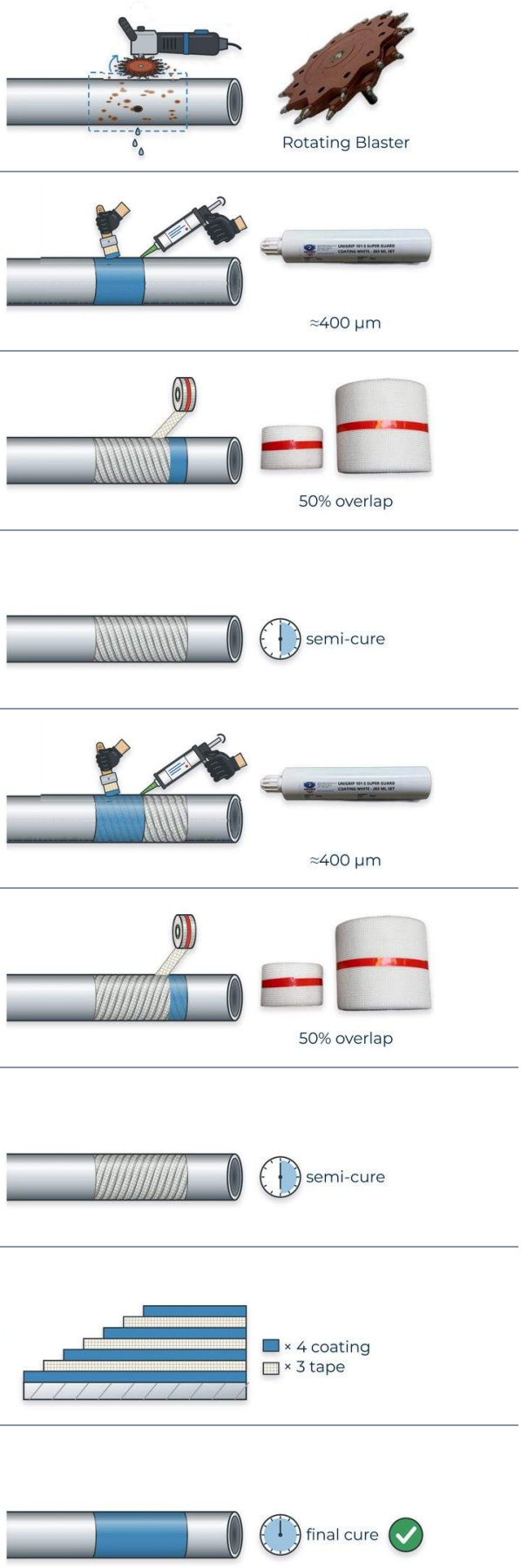
7. Allow final curing.

*Note: Surface preparations must always be in compliance with client specifications or job requirements. The surface does not need to be dry to apply the product.*



*Includes AI generated images*

# Sea water pipes - Repair/sealing leaks




Repair of leaking Sea Water pipes using SepcoTech Epoxy & Super Wrap Reinforcement Tape solution.

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Apply first layer of SepcoTech Super Guard Coating - approx. 400 µm.

3. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

4. Allow semi-curing.

5. Apply second layer of SepcoTech Super Guard Coating - approx. 400 µm.

6. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

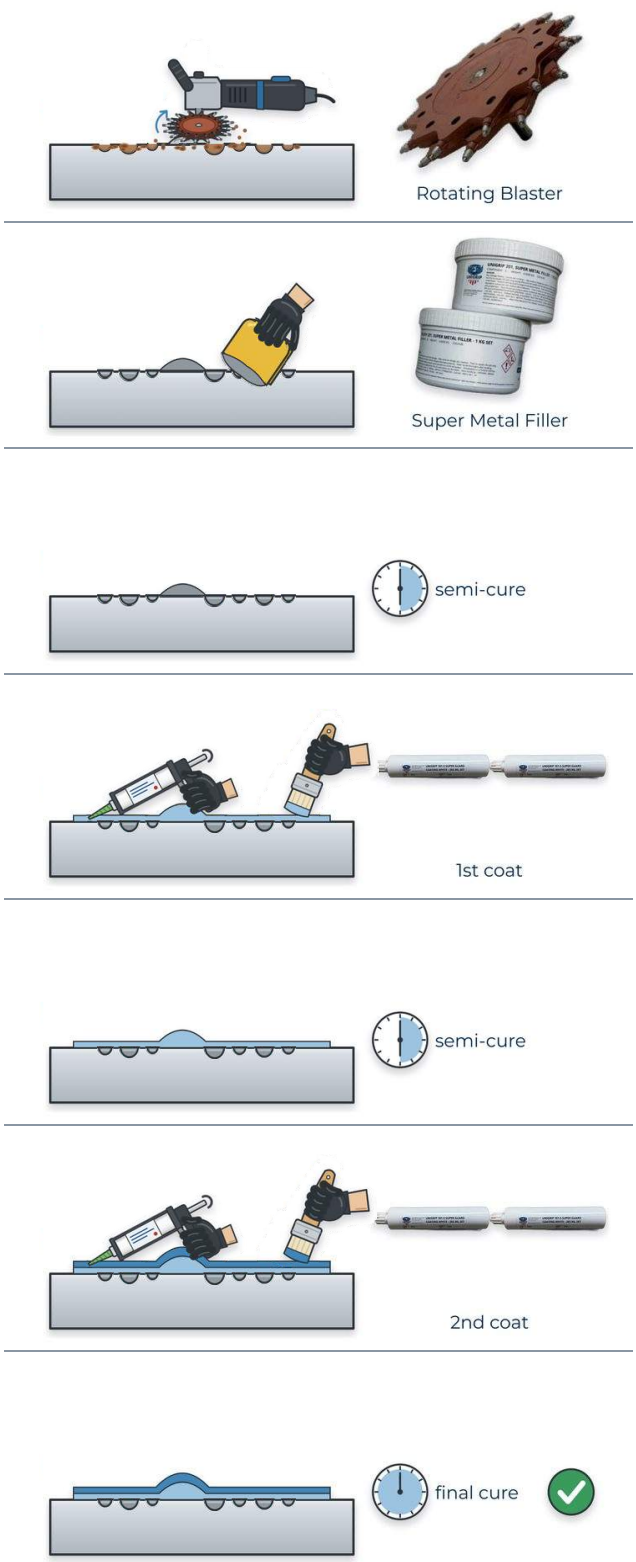
7. Allow semi-curing.

8. Repeat this method until minimum 4 layers of coating and 3 layers of tape are obtained.

9. Allow final curing.

Note: Make sure that the coating penetrates the Super Wrap Reinforcement Tape while wrapping. In case of larger holes use SepcoTech Putty stick to preseal the area.

# Sea water strainer - Protection




**Life extension of Sea Water Strainers exposed to erosion, corrosion and bimetallic corrosion.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Rebuild the surface to its original dimensions and structure using SepcoTech Super Metal Filler in the heavily deteriorated areas and in the welding areas.

3. Allow semi-curing.

4. Apply the first layer of SepcoTech Super Guard or Aqua Guard Coating.

5. Allow semi-curing.

6. Apply the second layer of SepcoTech Super Guard or Aqua Guard Coating.

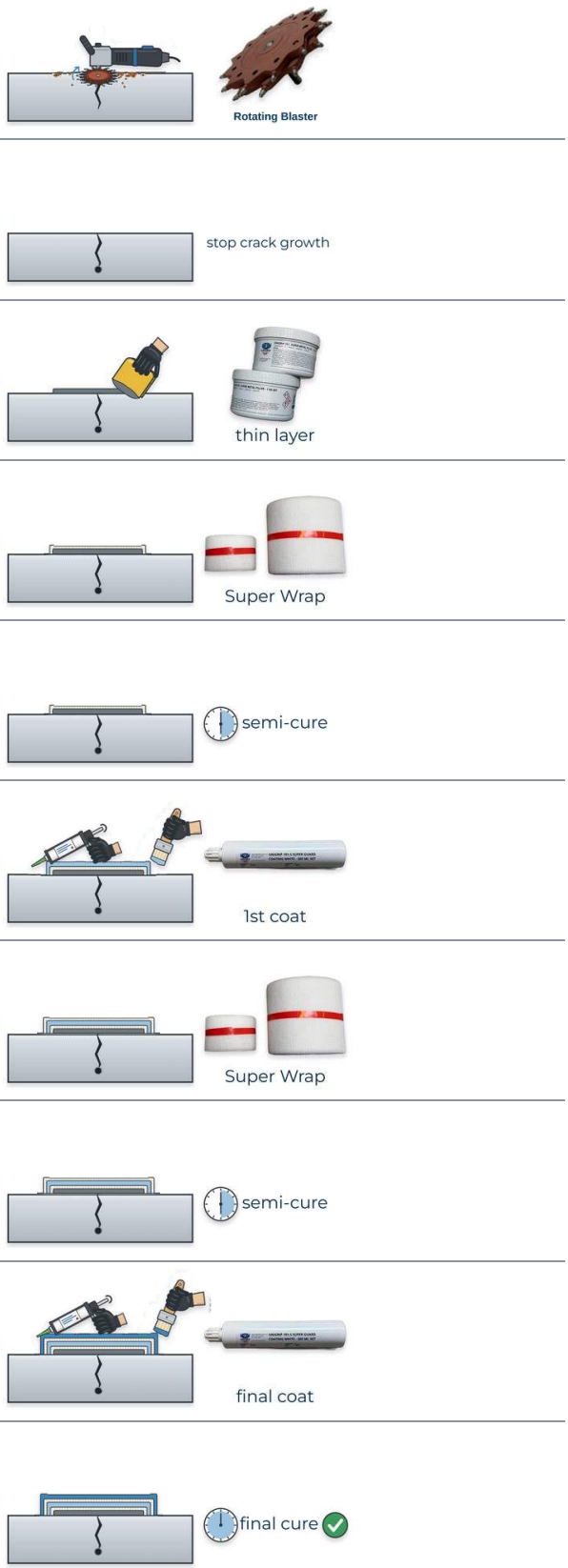
7. Allow final curing.

*Note: By following SepcoTech technical guidance this procedure can be done by crew during voyage.*



*Includes AI generated images*

# Seal a crack




**Seals cracks by using SepcoTech epoxy compound/coating and Super Wrap Reinforcement Tape to prevent leaks.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Ensure mechanically that the crack does not develop any further.

3. Apply the Super Metal Filler in a thin layer over the damaged area.

4. Apply Super Wrap Reinforcement Tape into the Super Metal Filler - while still wet.

5. Allow semi-curing.

6. Apply first layer of SepcoTech Super Guard Coating.

7. Apply Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet.

8. Allow semi-curing.

9. Apply final layer of coating.

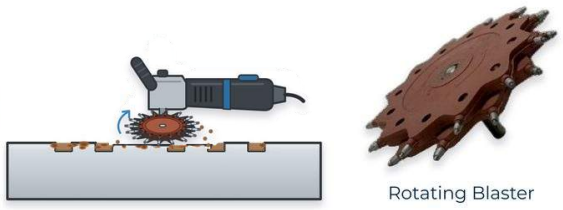
10. Allow final curing.

*Note: Applying SepcoTech products does not prevent the crack from developing.*



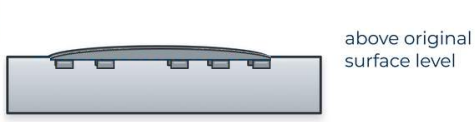
*Includes AI generated images*

# Shafts & liners - Surface recovery



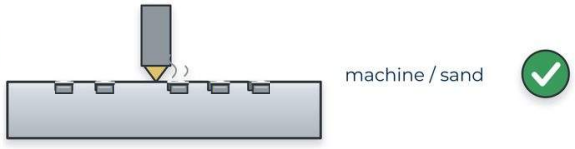













**Repair method to recover superstructure and seal surfaces due to worn grooves and corrosion damages.**

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Apply the SepcoTech product. Both Super Metal Filler and the Super Guard Coating can be used depending on the scope of the damaged area.
   a. Heavy deep damage: use the Super Metal Filler.
   b. Minor damage: use the Super Guard Coating.

3. Rebuild the surface to its original dimensions and structure using SepcoTech products applied above original surface level.

4. Allow curing.

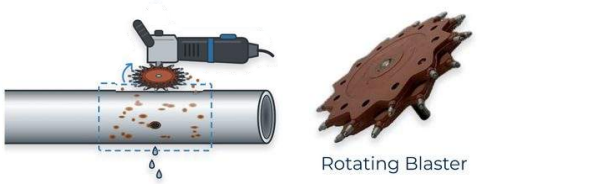
5. Fit to original shape and size by mechanical machining and sanding.

*Note: It is often advantageous to use a custom-shaped sanding tool - for example, one made of putty - to achieve the original surface and dimensions.*



*Includes AI generated images*

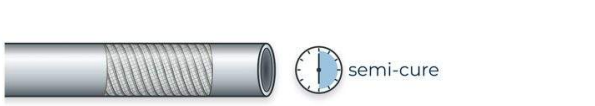
# Steam pipes - Repair/sealing leaks





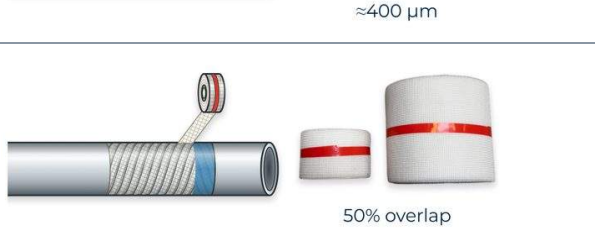




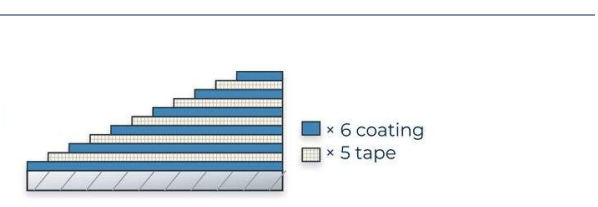
















Repair of leaking Steam Pipes using SepcoTech Epoxy & Super Wrap Reinforcement Tape solution.

1. Surface preparation acc. to SepcoTech standards, over the affected area.

2. Apply first layer of SepcoTech Super Guard Coating - approx. 400 µm.

3. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

4. Allow semi-curing.

5. Apply second layer of SepcoTech Super Guard Coating - approx. 400 µm.

6. Wrap the Super Wrap Reinforcement Tape into the Super Guard Coating - while still wet with 50% overlap of the tape.

7. Allow semi-curing.

8. Repeat this method until minimum 6 layers of coating and 5 layers of tape are obtained.

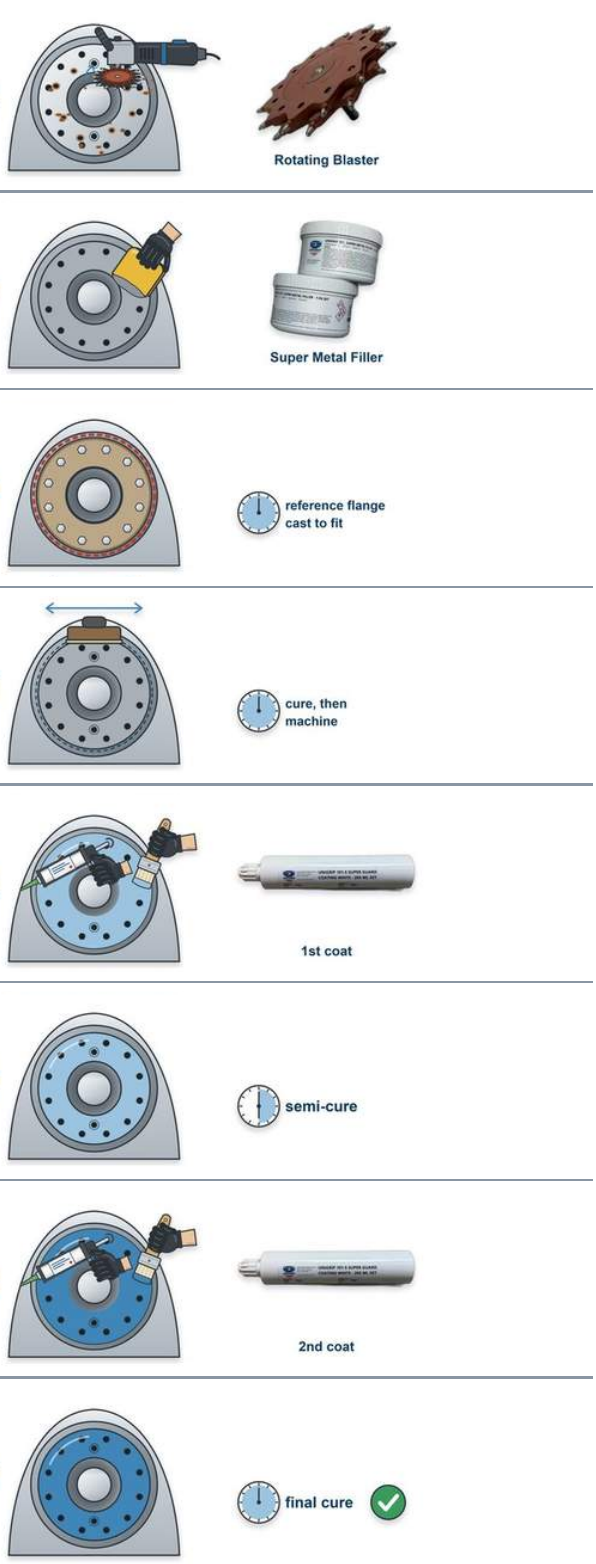
9. Allow final curing.

Note: Make sure that the coating penetrates the Super Wrap Reinforcement Tape while wrapping.



*Includes AI generated images*

# Stern boss flange - Refurbishment




**Restore corroded stern tube seal flange surfaces to their original geometry with the cast-to-fit method.**

1. Remove the rope guard and seal. Surface preparation acc. to SepcoTech standards.

2. Apply Release Agent to the existing flange ring. Rebuild the flange with SepcoTech Super Metal Filler.

3. Bolt the reference flange ring on while the filler is uncured and tighten evenly.

4. Allow curing, remove the flange and machine. Restore lubricating holes and edges.

5. Apply a stripe coat of SepcoTech Super Guard, followed by the first full coat - 200 µm DFT.

6. Allow semi-curing.

7. Apply a second stripe coat and the second full coat - 200 µm DFT (400 µm in total).

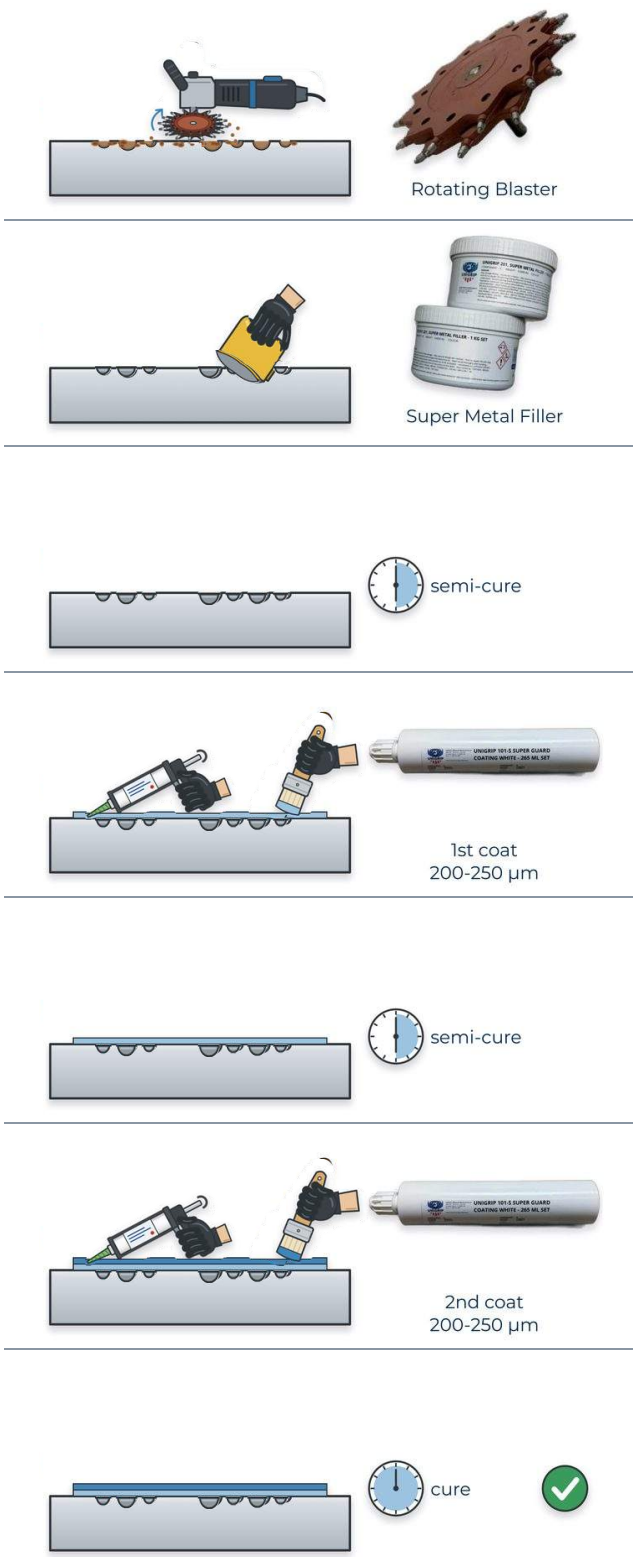
8. Allow final curing. Reinstall the seal with a new gasket and check for leaks.

*Note: The cast-to-fit method reproduces the flange geometry and reduces machining. Final geometry must always be verified.*



*Includes AI generated images*

# Tanks - pittings




**Pittings in Tanks due to corrosion, wear & tear often occurs and can be repaired with SepcoTech products.**

1. Surface preparation acc. to our recommendations.

2. Apply SepcoTech Super Metal Filler to fill out pittings and build up surface.

3. Allow semi-curing.
4. Apply 1st layer of Aqua Guard Coating - 200-250 µm.

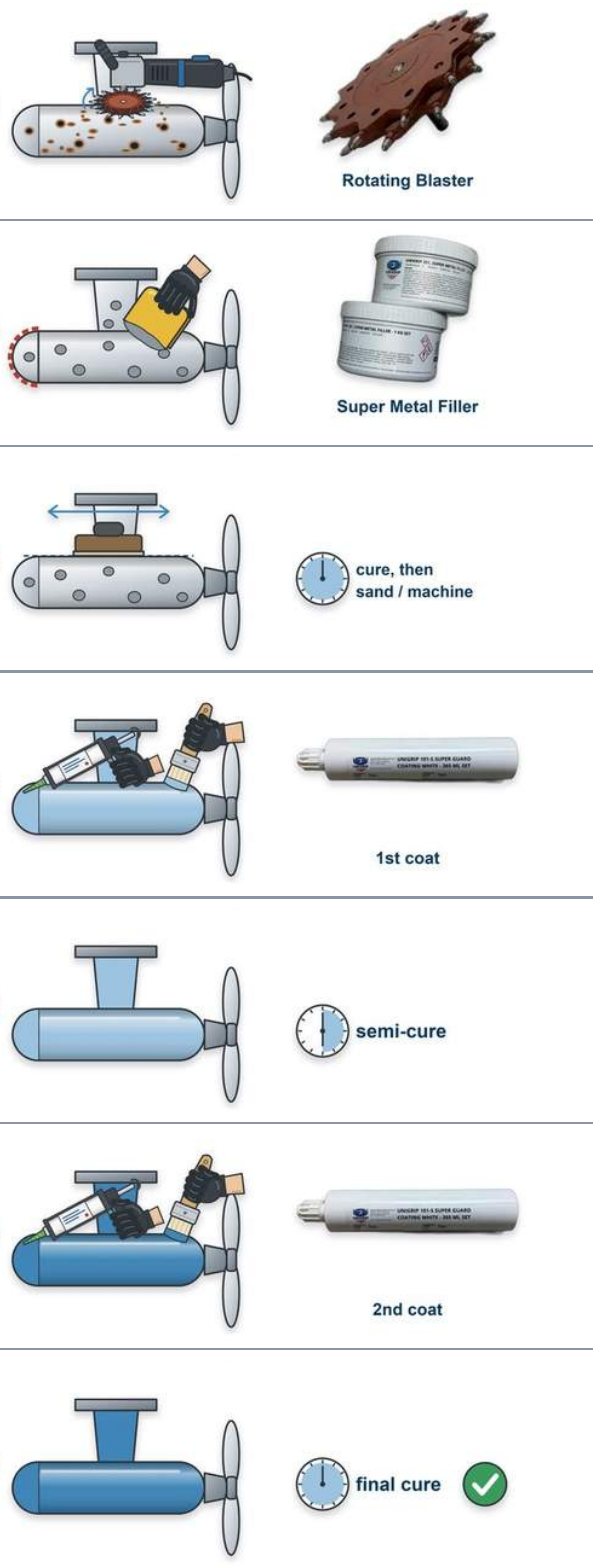
5. Allow semi-curing.
6. Apply 2nd layer of Aqua Guard Coating - 200-250 µm.

7. Allow curing.



*Includes AI generated images*

# Thruster Gear Housings




**Rebuild corroded and eroded bow thruster casing surfaces to their original geometry and protect them against corrosion.**

1. Inspect the casing. Surface preparation acc. to SepcoTech standards - abrasive blasting recommended.

2. Rebuild pits and eroded areas using SepcoTech Super Metal Filler. Use a temporary mould with SepcoTech Release Agent where the cover profile is lost.

3. Allow curing and restore the original geometry by sanding or machining.

4. Apply a stripe coat of SepcoTech Super Guard to welds, edges and transitions, followed by the first full coat - 200 µm DFT.

5. Allow semi-curing.

6. Apply a second stripe coat and the second full coat of Super Guard - 200 µm DFT.

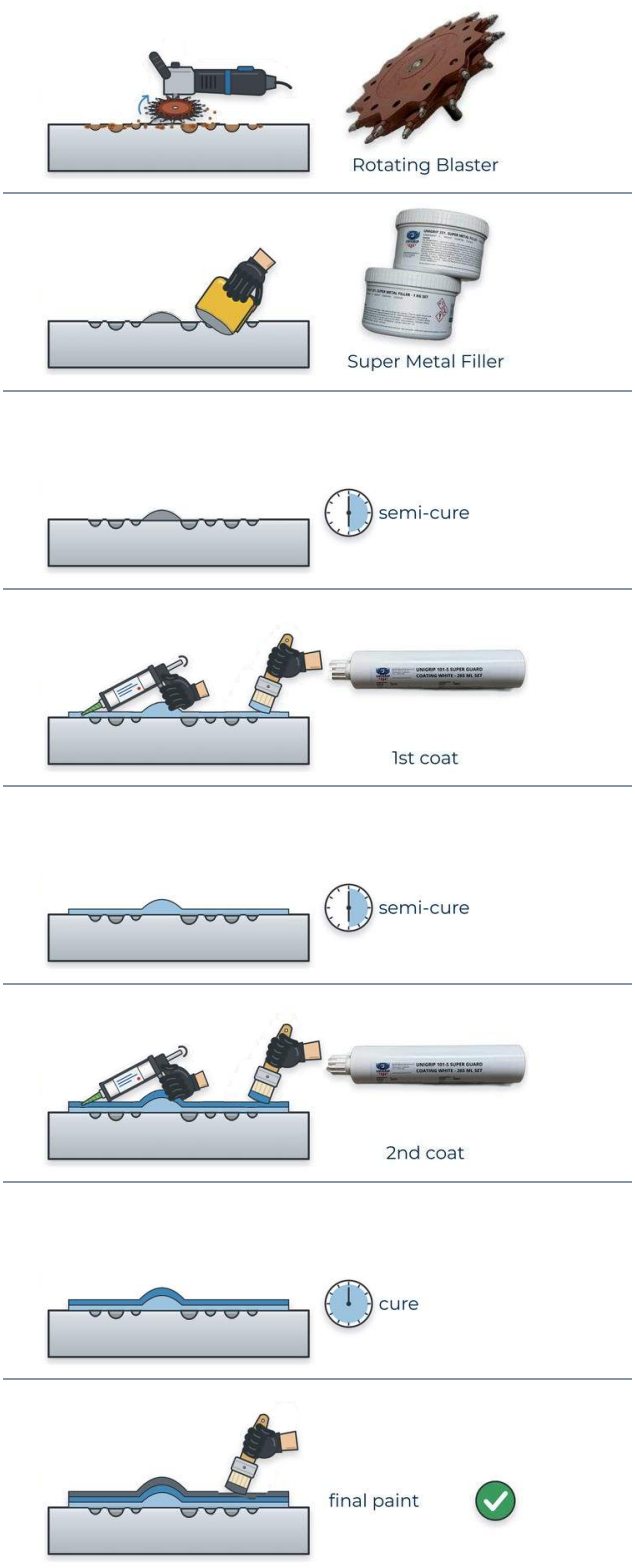
7. Allow final curing, inspect the coating, then reassemble and test.

*Note: Protect machined surfaces, bearing locations and sealing faces. Super Metal Filler does not replace structural steel repairs.*



*Includes AI generated images*

# Thruster tunnel - Propulsion nozzle




**Thruster tunnels and propulsion nozzles are commonly exposed to bi-metallic corrosion due to mixed metals. Rebuilding the pittings and applying a protective coating protects the surface and extends the lifetime.**

1. Surface preparation acc. to SepcoTech standards, over the affected area (the welding belt).

2. Rebuild the surface to its original dimensions using SepcoTech Super Metal Filler, filling the pittings.

3. Allow semi-curing.

4. Apply the first layer of SepcoTech Super Guard Coating.

5. Allow semi-curing.

6. Apply the second layer of SepcoTech Super Guard Coating.

7. Allow final curing.

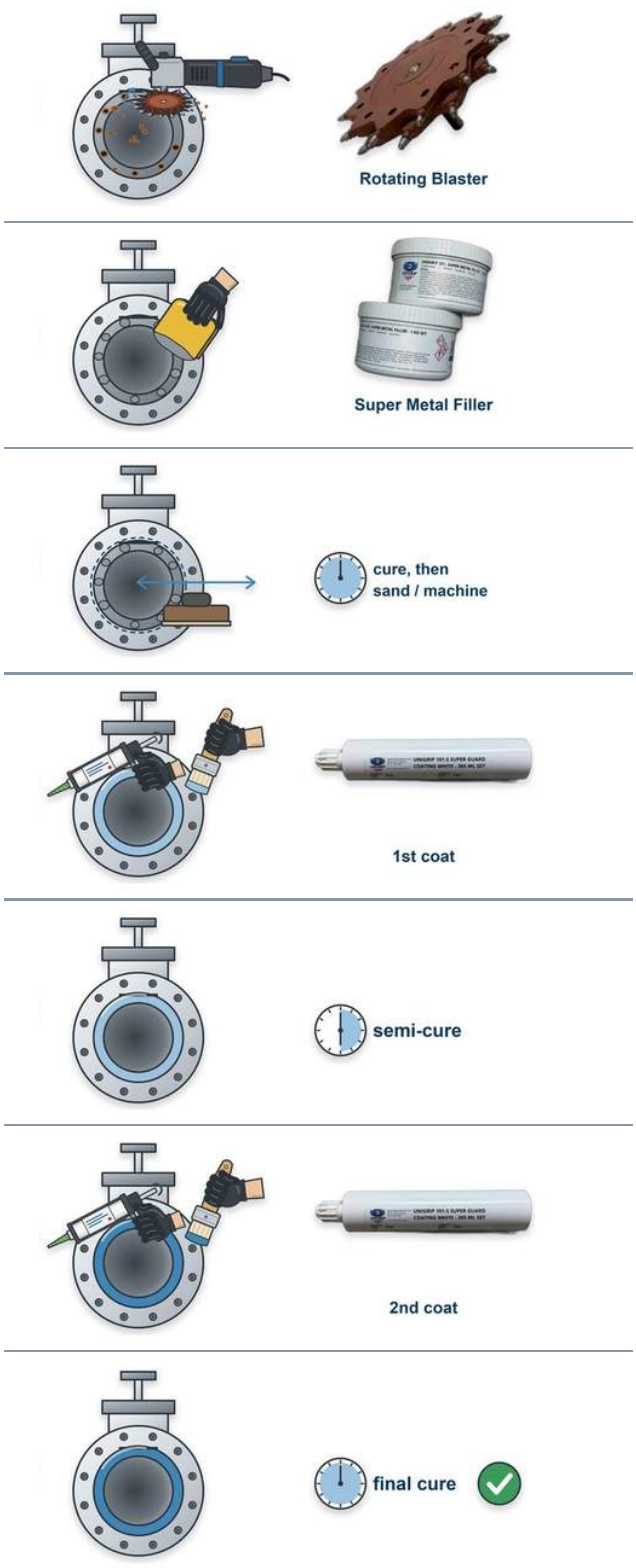
8. Final paint.

*Note: In general, propulsion areas suffering from bi-metallic corrosion can be repaired by the same application principles.*



*Includes AI generated images*

# Valves - Spade valves




**Restore damaged internal surfaces of spade valves (knife gate valves) and protect them against corrosion and erosion.**

1. Dismantle and inspect the valve. Surface preparation acc. to SepcoTech standards. Protect sealing faces, guides and machined areas.

2. Rebuild damaged or eroded areas using SepcoTech Super Metal Filler, slightly above the final profile.

3. Allow curing and restore the original dimensions by machining or sanding. Verify clearances and gate movement.

4. Apply a stripe coat of SepcoTech Super Guard to welds, edges and corners, followed by the first full coat - 200 µm DFT.

5. Allow semi-curing.

6. Apply a second stripe coat and the second full coat of Super Guard - 200 µm DFT.

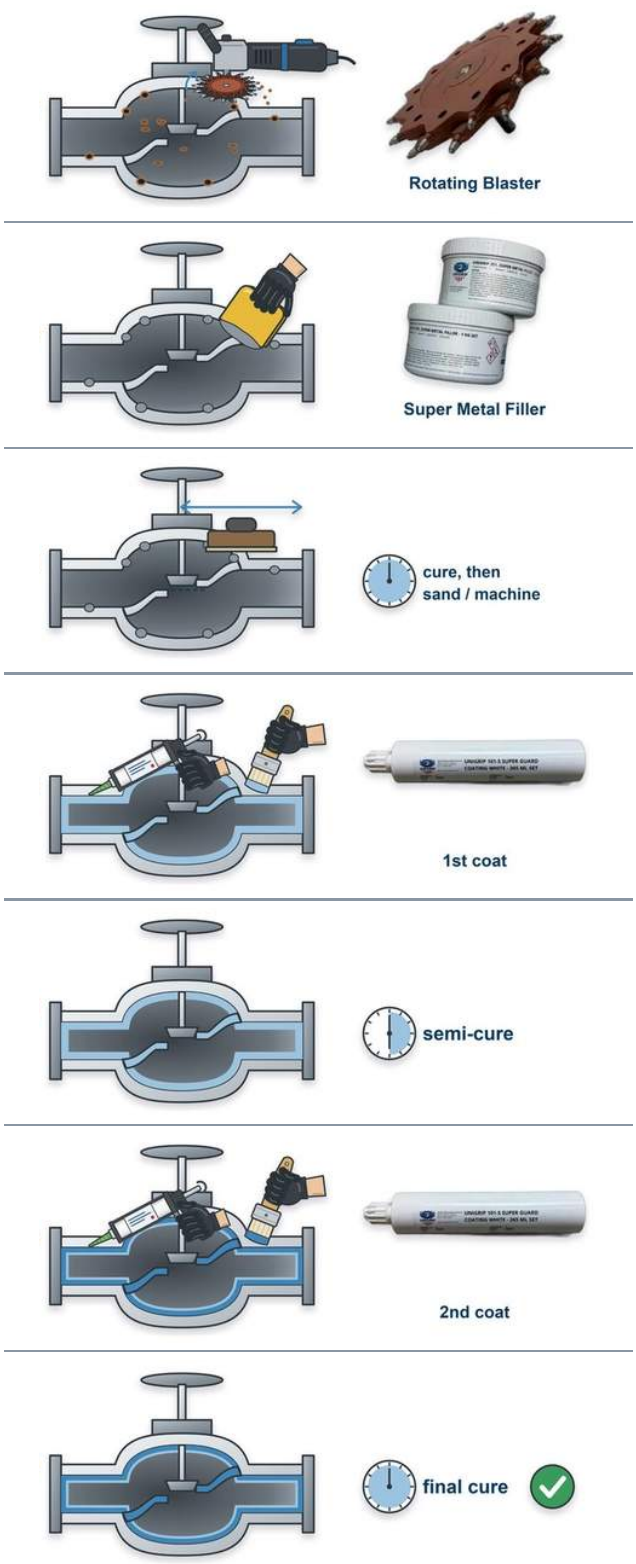
7. Allow final curing. Inspect the coating, reassemble and check the operation.

*Note: The coating must not interfere with gate movement, sealing surfaces or clearances. SepcoTech Aqua Guard may be used as an alternative where approved.*



*Includes AI generated images*

# Valves - Valve bodies & globe valves




**Restore corroded or eroded internal surfaces of valve bodies and globe valves and protect them against corrosion and erosion.**

1. Dismantle and inspect the valve body and seat areas. Surface preparation acc. to SepcoTech standards. Protect seats, sealing faces and stem guides.

2. Rebuild damaged or eroded areas using SepcoTech Super Metal Filler, slightly above the final profile.

3. Allow curing and restore the required geometry by machining or sanding. Check flow passages and seat geometry.

4. Apply a stripe coat of SepcoTech Super Guard to welds, edges and internal transitions, followed by the first full coat - 200 µm DFT.

5. Allow semi-curing.

6. Apply a second stripe coat and the second full coat of Super Guard - 200 µm DFT.

7. Allow final curing. Inspect the coating, reassemble and verify the operation.

*Note: The coating must not interfere with the valve seat, disc, stem or sealing performance. SepcoTech Aqua Guard may be used as an alternative where approved.*



*Includes AI generated images*

# why choose us?

## Reduce downtime

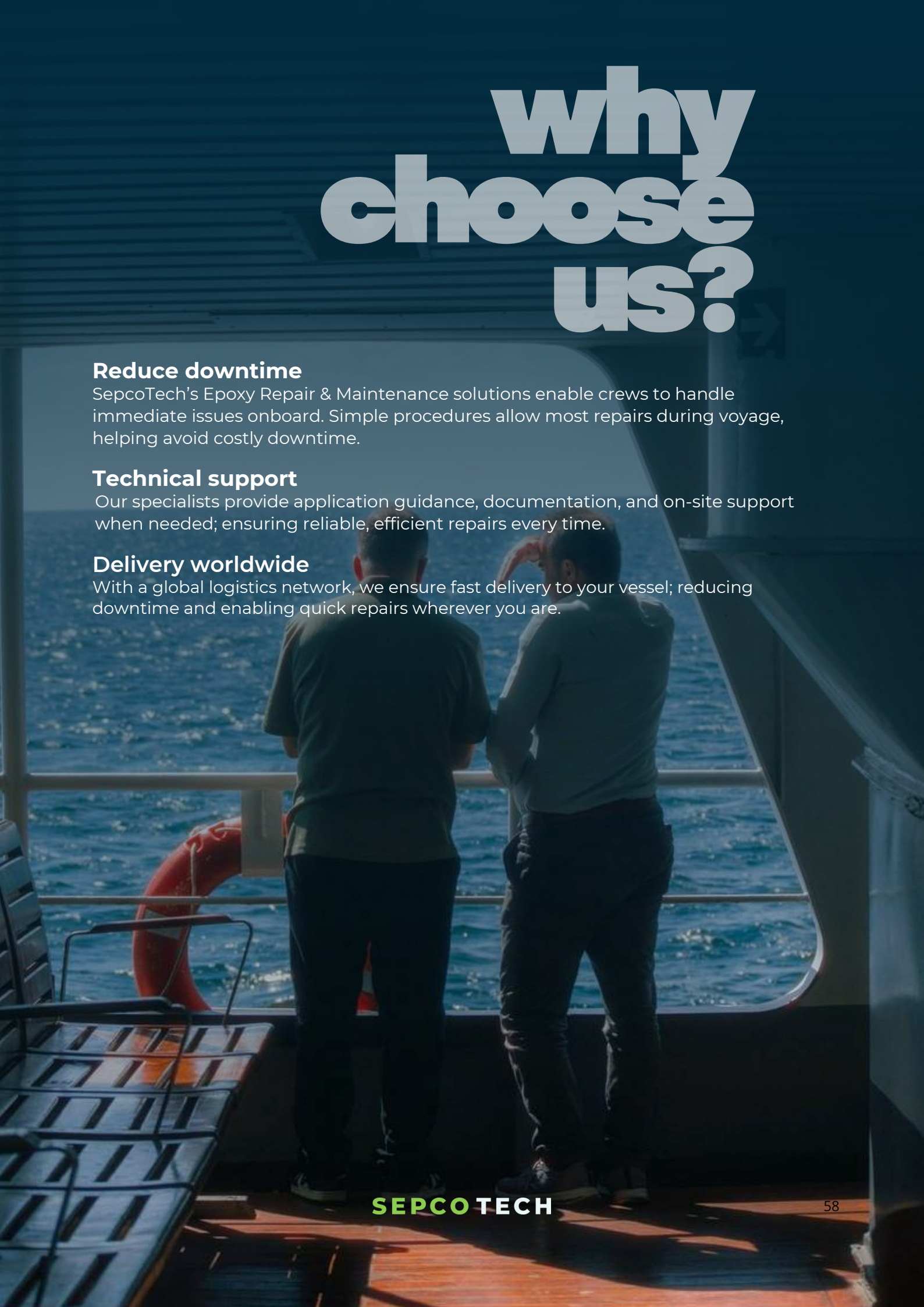
SepcoTech's Epoxy Repair & Maintenance solutions enable crews to handle immediate issues onboard. Simple procedures allow most repairs during voyage, helping avoid costly downtime.

## Technical support

Our specialists provide application guidance, documentation, and on-site support when needed; ensuring reliable, efficient repairs every time.

## Delivery worldwide

With a global logistics network, we ensure fast delivery to your vessel; reducing downtime and enabling quick repairs wherever you are.



# Technical specifications - index


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# Aqua Guard Coating

**TECHNICAL SPECIFICATIONS**



## MIXING AND APPLICATION

| | |
|---|---|
| Mixing ratio (volume) | **2:1** |
| Mixing ratio (weight) | **Part A 71.46 : Part B 28.54** |
| Density | **approx. 1.35 kg/dm³ at 20°C (DIN 53217)** |
| Pot life | **60 min.** |
| Peak exotherm | **120°C (248°F) after 92 min.** |
| Theoretical coverage | **2.1 m²/kg (= 2.8 m²/ltr) at 350 µm dry layer thickness** |

## POT LIFE BY TEMPERATURE

| Temperature | Pot life |
|---|---|
| **20°C** | 55-60 min. |
| **30°C** | 20-35 min. |
| **40°C** | 15-20 min. |
| **50°C** | 10-15 min. |
| **60°C** | 5-10 min. |

## CURING TIME

| Temperature | Dry to touch | Dry to handle | Fully cured |
|---|---|---|---|
| **10°C** | 10 h | 15 h | 14 days |
| **20°C** | 5 h | 6.5 h | 7 days |
| **30°C** | 4 h | 4 h | 4 days |
| **40°C** | 3 h | 3 h | 2 days |
| **50°C** | 2 h | 2 h | 1 day |
| **60°C** | 1 h | 1 h | 12 h |

## MECHANICAL AND PHYSICAL PROPERTIES

| | |
|---|---|
| Heat resistance | **110°C** |
| Compressive strength | **Rmax 91.1 N/mm², E 2517.0 N/mm²** |
| Tensile strength | **Rmax 20.7 N/mm², E 369.4 N/mm²** |
| Hardness | **Shore D 83 (after 16 h, 24 h and 7 days at 20°C)** |
| Adhesion (ISO 4624) | **steel 7.6 N/mm², aluminum 7.2 N/mm², concrete 5.6 N/mm²** |
| Dielectric strength | **26.5 kV/mm (DIN 53483)** |
| Chemical resistance | **hydrocarbons, ketones, alcohols, esters, halocarbons, aqueous salt solutions, dilute acids, bases, solvents and alkalis** |

# Exhaust Repair Compound

**TECHNICAL SPECIFICATIONS**




## PRODUCT TYPE

| |
|---|
| Asbestos-free one-component cold weld paste / putty |
| Base of alkaline silicates and water glass |
| Non-shrinking, non-crumbling, pasty, does not run |
| Adheres to all common materials in exhaust systems and furnaces such as metal, concrete, masonry, firebrick, refractory linings, fiberglass gaskets, etc. |

## TEMPERATURE

| | |
|---|---|
| Temperature resistance | **up to 1300°C (2372°F)** |
| Working temperature | **+5°C - +40°C** |

## CURING AND OVERPAINTING

| | |
|---|---|
| Curing time | **24 hours** |
| Possible to carefully heat up for quicker curing, must be kept below boiling point until fully cured | |
| Overpainting is not recommended, as the product is used in areas with high temperatures (risk of discoloration and the release of fumes from the paint) | |

## KIT CONTENTS AND STORAGE

| | |
|---|---|
| Exhaust repair compound, 10.48 fl. oz. (310 ml) single cartridge incl. nozzle | |
| Application tools (putty knife + spatula), reinforcement steel mesh, nitrile gloves and instructions for use | |
| Store out of direct sunlight, dry and frost free, between +5°C and +30°C | |
| Shelf life | **2 years in the original sealed container** |

# Fast Steel Putty Stick

TECHNICAL SPECIFICATIONS



## MIXING AND USE

| |
|---|
| Each stick contains pre-measured portions of activator and base |
| No measuring or mixing tools are necessary. Just cut, mix, and apply. |
| Supplied in stick form wrapped in a clear release film, in a reusable clear plastic tube |

## PROPERTIES

| | |
|---|---|
| Work life | **1 hour at 24°C** |
| Shore D hardness | **80 (ASTM D2240)** |
| Compressive strength | **55 N/mm² (ASTM D695)** |
| Dielectric strength | **11,800 V/mm (ASTM D149)** |
| Chemical resistance | **hydrocarbons, ketones, alcohols, esters, halocarbons, aqueous salt solutions, dilute acids, and bases** |

## LAP SHEAR STRENGTH ON STEEL (ASTM D1002)

| |
|---|
| 5.6 N/mm² at 24°C |
| 4.2 N/mm² at 204°C |
| 2.45 N/mm² at 260°C |

## TEMPERATURE LIMITATIONS

| | |
|---|---|
| Continuous | **-40°C to +232°C (-40°F to +450°F)** |
| Intermittent | **-40°C to +260°C (-40°F to +500°F)** |
| ABS rated temperature resistance | **150°C (302°F)** |

# QuickFix Pipe Repair Tape

TECHNICAL SPECIFICATIONS




## PRESSURE RESISTANCE

| | |
|---|---|
| As is | **10 Bar (145 psi), based on 9 layers** |
| Double layer (2 x 9 layers) and use of putty | **103 Bar (1500 psi)** |

## SERVICE TEMPERATURE

| | |
|---|---|
| Continuous | **150°C (300°F)** |
| Peak | **190°C (374°F)** |

## WORKING AND CURING TIME

| | |
|---|---|
| Pot life | **5 min** |
| Cure time | **5-10 min** |

## APPLICATION RANGE

| | |
|---|---|
| Metal, plastic and composite pipes | |
| Pipe diameters from 0.5" to 24" | |
| Chemical resistance | **chemicals, crude oil, diesel, ketones, alcohols, esters, halocarbons, aqueous salt solutions, dilute acids, bases, solvents, and alkalis** |

# Super Guard Coating

TECHNICAL SPECIFICATIONS



## MIXING AND APPLICATION

| | |
|---|---|
| Mixing ratio | **2:1 by volume, 66.85 A : 33.15 B by weight** |
| Density | **1.26 g/cm³** |
| Pot life | **60 min.** |
| Peak exotherm | **120°C (248°F) after 92 min.** |
| Coverage | **0.76 kg/m² (0.60 l/m²) at 600 µm** |
| Airless spray | **180-250 bar, nozzle sizes 13 to 21** |
| Surface preparation | **blast cleaning to Sa 2½, surface profile minimum 40 µm** |

## POT LIFE BY TEMPERATURE

| Temperature | Pot life |
|---|---|
| **20°C** | 55-60 min. |
| **30°C** | 20-25 min. |
| **40°C** | 13-15 min. |
| **50°C** | 5-8 min. |
| **60°C** | 2-4 min. |

## CURING TIME

| Temperature | Dry to touch | Dry to handle | Fully cured |
|---|---|---|---|
| **10°C** | 10 h | 15 h | 14 days |
| **20°C** | 5 h | 6.5 h | 7 days |
| **30°C** | 3.5 h | 5 h | 4 days |
| **40°C** | 2.5 h | 3 h | 2 days |
| **50°C** | 1 h | 2 h | 1 day |
| **60°C** | 30 min | 1 h | 12 h |

## PROPERTIES AND STORAGE

| | |
|---|---|
| Heat resistance | **180°C** |
| Compressive strength | **Rmax 91.1 N/mm², E 2517.0 N/mm²** |
| Tensile strength | **Rmax 20.7 N/mm², E 369.4 N/mm²** |
| Hardness | **Shore D 83** |
| Dielectric strength | **26.5 kV/mm (DIN 53483)** |
| Shelf life | **36 months** |

# Super Metal Filler

TECHNICAL SPECIFICATIONS



## MIXING AND APPLICATION

| | |
|---|---|
| Mixing ratio | **1:1 in parts by weight and volume** |
| Pot life | **approx. 15-30 minutes at 20°C (68°F), depending on amount mixed and temperature** |
| Theoretical spreading rate | **0.62 m²/kg (=1.0 m²/ltr) at 1 mm layer thickness** |
| Practical spreading rate | **approx. 1.6 kg/m² at 1 mm layer thickness** |
| Application temperature preferably between 10 - 30°C, relative humidity lower than 85%, substrate 3°C above dew point | |
| May not be diluted. Cleaning: Brush thinner EP / Spray thinner EP | |

## CURING TIME (20°C / 65% R.H.)

| | |
|---|---|
| Dust-free | **after approx. 1-2 hours** |
| Functional use | **after 2-4 hours** |
| Sandable and re-coatable | **after approx. 4-6 hours** |
| Full mechanical or thermal loading | **24 hours** |
| Maximum strength and resistance | **7 days at 20°C** |

## MECHANICAL AND PHYSICAL PROPERTIES

| | |
|---|---|
| Hardness | **Shore D 81 (DIN 53505)** |
| Shear adhesion | **20 N/mm² (ASTM D1002)** |
| Flash point | **Component A and B >65°C (DIN 53213)** |
| After curing, the product can be machined, drilled and worked like metal | |

## TEMPERATURE AND CHEMICAL RESISTANCE

| | |
|---|---|
| Corrosion | **60°C (140°F)** |
| Light load | **120°C (248°F)** |
| As filler | **250°C (482°F)** |
| ABS rated temperature resistance | **110°C (230°F)** |
| Chemical resistance | **hydrocarbons, ketones, alcohols, esters, halocarbons, aqueous salt solutions, dilute acids, bases, solvents and alkalis** |

# Super Wrap Reinforcement Tape

**TECHNICAL SPECIFICATIONS**



## PRODUCT TYPE

| |
|---|
| Flexible fiber reinforced fabric gauze |
| Used for reinforcing repairs made with SepcoTech compounds and coatings |
| Used together with SepcoTech Super Guard Coating and Super Metal Filler |

## APPLICATION RANGE

| | |
|---|---|
| Pipe diameters from 0.5” to 24” | |
| Substrates | **steel, GRE, Fiberglass, FRP and other composite materials** |
| Cracks, leaks, fractures and corrosion porosity in piping systems | |
| Tanks, joints, flanges and structural components | |

## APPLICATION

| | |
|---|---|
| Wrap the tape into the coating while still wet | |
| Overlap | **50% of the tape width** |
| Coating per layer | **approx. 400 µm** |
| Heating coils and steam pipes | **minimum 6 layers of coating and 5 layers of tape** |
| Sea water pipes | **minimum 4 layers of coating and 3 layers of tape** |

## SIZES AND STORAGE

| | |
|---|---|
| Tape size | **5 cm x 10 m** |
| Tape size | **10 cm x 20 m** |
| Storage | **dry, frost free and out of direct sunlight, between 5°C and 20°C** |
| Shelf life | **36 months from the date of manufacture** |



*Keeping vessels operational doesn't have to mean costly replacements. At SepcoTech, we help shipowners extend the life of critical components by repairing instead of replacing.*

SEPCO TECH

# Surface preparation - index


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**GUIDELINE AT A GLANCE**

PREFERRED METHOD

**Abrasive blasting**

ALTERNATIVE METHODS

**Mechanical preparation, high-pressure or ultra-high-pressure water jetting**

MINIMUM SURFACE PROFILE

**40 µm**

**Unless otherwise specified in the product TDS**

USE TOGETHER WITH

**Product TDS, project specifications and approved application procedures**

PURPOSE AND SCOPE

# Surface Preparation Technical Application Guideline

For Marine, Offshore and Industrial Epoxy Repair & Protective Coating Systems

Proper surface preparation is essential to achieving reliable adhesion, corrosion protection and long-term performance of epoxy repair compounds and protective coating systems.

This guideline establishes SepcoTech's recommended surface preparation requirements for steel substrates, including conventional abrasive blasting, mechanical preparation and high-pressure or ultra-high-pressure water jetting.

It is intended for professional coating applicators, shipyard personnel, marine engineers, maintenance technicians and vessel crews carrying out repair and maintenance operations.

Abrasive blasting is the preferred method wherever practical. However, SepcoTech recognises that marine, offshore and industrial maintenance activities frequently take place under conditions where conventional blasting equipment or controlled environmental conditions are unavailable.

Alternative preparation methods may therefore be used, provided the required surface cleanliness, mechanical profile and product-specific application requirements are achieved.

This guideline shall be used together with the applicable product Technical Data Sheet (TDS), project specifications and approved application procedures.

**MINIMUM SURFACE PROFILE**

General minimum surface profile requirement: 40 µm, unless otherwise specified in the applicable product TDS or an approved technical procedure.

RECOMMENDED SEQUENCE

STEP 1
**Initial inspection and assessment**

STEP 2
**Removal of oil, grease and other surface contamination**

STEP 3
**Freshwater washing and soluble salt removal where required**

STEP 4
**Abrasive blasting or mechanical surface preparation**

STEP 5
**Removal of dust and residual contamination**

STEP 6
**Verification of surface cleanliness and profile**

STEP 7
**Final environmental and application readiness checks**

STEP 8
**Product application**

SURFACE PREPARATION

# General Surface Preparation Requirements

Before applying any SepcoTech epoxy repair compound or protective coating, the substrate shall be properly assessed and prepared.

## THE SURFACE SHALL BE

- Free from oil, grease, marine growth, loose corrosion, mill scale and other detrimental contamination.
- Cleaned of soluble salts to the specified acceptance limit.
- Free from loose or unsound existing coatings.
- Mechanically prepared to provide an appropriate anchoring profile.
- Free from dust, abrasive residues and other loose particles.
- Within the environmental and substrate conditions permitted by the selected product.

Particular attention shall be given to welds, sharp edges, corrosion pits, crevices and areas previously exposed to seawater or aggressive industrial environments.

Surface preparation shall be carried out in a logical sequence to avoid embedding or spreading contamination.

**SOLUBLE SALTS**

Where soluble salts remain above the specified acceptance limit, additional cleaning shall be performed before coating.

**REQUIREMENTS AT A GLANCE**

SURFACE CLEANLINESS

**Sa 2½**

**ISO 8501-1, minimum**

SURFACE PROFILE

**40 µm**

**Minimum**

ABRASIVE MEDIA

**Suitable angular abrasive**

SURFACE CONDITION

**Free from detrimental contamination**

INSPECTION

**Visual cleanliness and surface profile verification**

PREFERRED METHOD

# Abrasive Grit Blasting

Abrasive blasting is SepcoTech's preferred surface preparation method for carbon steel substrates.

It provides effective removal of corrosion products, deteriorated coatings and mill scale while creating a controlled mechanical anchoring profile.

## GUIDANCE

- The abrasive shall be clean, dry and suitable for the substrate and coating system.
- Compressed air used for blasting shall be free from detrimental oil and moisture contamination.
- Surface profile may be assessed using recognised methods from the ISO 8503 series, including ISO 8503-5 for replica tape measurement.
- The selected abrasive size and blasting parameters should produce a suitable profile without excessive surface roughness.
- Following blasting, all abrasive residues, dust and loose particles shall be removed before application.

**COATING THICKNESS**

Excessive peak height may result in insufficient coating coverage over profile peaks, particularly when applying relatively thin protective coating systems. The final surface profile shall therefore be compatible with the specified coating thickness.

**AT A GLANCE**

USE WHEN

**Abrasive blasting is impractical**

TYPICAL SITUATIONS

**Onboard repairs, offshore maintenance, confined spaces and localised repair areas**

VISUAL CLEANLINESS REFERENCE

**St 3**

**ISO 8501-1**

PREVIOUSLY COATED STEEL

**ISO 8501-2**

MINIMUM PROFILE

**40 µm**

**Unless a product-specific requirement applies**

ALTERNATIVE METHOD

# Mechanical Surface Preparation

Where abrasive blasting is impractical, mechanical surface preparation may be accepted for suitable repair and maintenance applications.

This is particularly relevant for onboard repairs, offshore maintenance, confined spaces and localised repair areas.

## SUITABLE EQUIPMENT MAY INCLUDE

- Rotary bristle blasting tools.
- Coarse abrasive grinding discs.
- Suitable mechanical profiling discs.
- Needle scalers for initial corrosion removal.
- Other approved power tools capable of producing the required surface condition.

Mechanical preparation shall not be confused with simple surface cleaning or polishing.

The objective is to remove unsound material and produce a clean, suitably roughened substrate capable of providing mechanical adhesion.

ISO 8501-1 St 3 may be used as a visual cleanliness reference for thorough power-tool cleaning.

Where applicable, ISO 8501-2 may be used for the preparation of previously coated steel substrates.

However, St 3 describes visual cleanliness and does not establish a measurable surface profile.

**MINIMUM PROFILE**

SepcoTech's general minimum profile requirement remains 40 µm unless a product-specific requirement or approved technical deviation applies.

**AT A GLANCE**

EFFECTIVE ALTERNATIVES

**Rotary bristle blasting tool or coarse mechanical profiling disc**

GIVE ATTENTION TO

**Corrosion pits, welds, edges and smooth or polished areas**

NOT SUFFICIENT ALONE

**Fine grinding, polishing and conventional wire brushing**

IF NOT ACHIEVABLE

**Obtain technical approval before proceeding**

SURFACE PREPARATION

# Practical Guidance for Onboard Maintenance

Where specialised blasting equipment is unavailable, a suitable rotary bristle blasting tool or coarse mechanical profiling disc may provide an effective alternative.

Particular attention should be given to corrosion pits, welds, edges and areas where smooth or polished surfaces may remain.

Fine grinding, polishing and conventional wire brushing alone should not be considered sufficient evidence of achieving the required surface profile.

Where the required surface condition cannot be achieved or verified, technical approval should be obtained before proceeding.

**AT A GLANCE**

REFERENCE STANDARD

**ISO 8501-4**

RECOMMENDED GRADE

**Wa 2½**

**Subject to project and product requirements**

ANCHORING PROFILE

**Not created by water jetting**

FLASH RUST

**Per coating specification and product requirements**

ALTERNATIVE METHOD

# High-Pressure and Ultra-High-Pressure Water Jetting

High-pressure and ultra-high-pressure (UHP) water jetting are recognised methods for removing corrosion products, deteriorated coatings and surface contamination.

These methods may be particularly useful where abrasive blasting is restricted due to dust generation, access limitations or operational requirements.

Surface preparation by water jetting shall be assessed with reference to ISO 8501-4.

For suitable applications, Wa 2½ is the recommended reference cleanliness grade, subject to project and product requirements.

## IMPORTANT TECHNICAL CONSIDERATION

Water jetting does not create a new abrasive anchoring profile.

It may expose an existing profile previously produced by blasting or corrosion, but it shall not be assumed to provide the minimum required 40 µm profile.

Where the existing profile is insufficient, supplementary mechanical profiling or abrasive blasting shall be carried out.

Water jetting may also result in flash rusting following cleaning.

The degree of acceptable flash rust shall be determined according to the applicable coating specification and product-specific requirements.

For conventional dry-surface epoxy coatings, the substrate must be allowed to dry to the required condition before application.

**SEPCOTECH AQUA GUARD**

For moisture-tolerant systems such as SepcoTech Aqua Guard, wet-surface application may be permitted within the product's approved application conditions.

WHY IT MATTERS

SOURCES

**Seawater, marine atmospheres, chemical environments and repeated wet and dry cycles**

CAN REMAIN IN

**Corrosion pits, crevices and irregularities**

POSSIBLE EFFECTS

**Osmotic blistering, underfilm corrosion and premature coating failure**

SURFACE PREPARATION

# Removal of Soluble Salts and Embedded Contamination

Steel exposed to seawater, marine atmospheres, chemical environments or repeated wet and dry cycles may contain soluble salts and other contamination.

These contaminants may remain within corrosion pits, crevices and irregularities even after the surface appears visually clean.

If not adequately removed, soluble salts may contribute to osmotic blistering, underfilm corrosion and premature coating failure.

## RECOMMENDED CLEANING PROCEDURE

### Step 1 - Initial cleaning

Remove oil, grease, marine deposits and other visible contamination using suitable cleaning agents.

Degreasing should be completed before mechanical preparation to minimise the risk of spreading or embedding contamination.

### Step 2 - Freshwater washing

Wash the substrate thoroughly using clean freshwater.

Where practical, warm water or suitable pressure-assisted washing may improve removal of soluble contamination.

### Step 3 - Assessment of heavily contaminated surfaces

For heavily corroded steel or surfaces exposed to prolonged seawater service, additional cleaning cycles may be required.

Controlled warming and drying may assist in bringing retained moisture and dissolved salts towards the surface, where they can subsequently be removed by washing.

This process is sometimes referred to as salt sweating.

Heating alone does not remove salts and shall not be considered a substitute for proper washing and verification.

**TEST METHODS**

ISO 8502-6

**Bresle extraction method**

ISO 8502-9

**Conductometric determination of water-soluble salts**

ACCEPTANCE LIMITS

**Set by the project specification or product-specific requirements**

REMOVAL OF SOLUBLE SALTS

# Salt Verification

### Step 4 - Salt verification

Where required, soluble salt contamination shall be assessed using:

- ISO 8502-6 - Bresle extraction method.
- ISO 8502-9 - Conductometric determination of water-soluble salts.

Acceptance limits shall be established by the applicable project specification or product-specific requirements.

A universal salt limit shall not be assumed for all products and applications.

### Step 5 - Repeat cleaning where necessary

If contamination exceeds the specified acceptance limit, repeat freshwater washing and reassess the substrate.

### Step 6 - Final surface preparation

Complete the required blasting or mechanical profiling and remove remaining dust and debris before application.

Where washing is repeated after blasting, inspect for flash rust and any change in surface condition before proceeding.

**AT A GLANCE**

DEW POINT MARGIN

**3°C**

**Substrate above calculated dew point (dry-surface systems)**

KEEP WITHIN PRODUCT LIMITS

**Relative humidity, substrate temperature, moisture conditions and curing**

MONITORING

**Throughout preparation and application where practical**

SURFACE PREPARATION

# Environmental Conditions and Application Readiness

Environmental conditions shall be assessed before applying SepcoTech epoxy repair compounds and protective coatings.

For conventional dry-surface epoxy systems, the substrate temperature should normally be at least 3°C above the calculated dew point, unless otherwise specified in the applicable TDS.

Relative humidity, substrate temperature, moisture conditions and curing requirements shall remain within the limits established for the selected product.

Environmental conditions should be monitored throughout preparation and application where practical.

**AT A GLANCE**

ENGINEERED FOR

**Damp, wet and underwater substrates**

STANDARD DEW POINT MARGIN

**Does not automatically apply within approved conditions**

SURFACE PREPARATION

**Still required**

SPECIAL CONSIDERATIONS

# SepcoTech Aqua Guard

SepcoTech Aqua Guard is specifically engineered for application on damp and wet substrates, including underwater applications, where conventional environmental conditions cannot always be controlled.

Unlike conventional dry-surface epoxy systems, Aqua Guard is intended for repair and protective coating applications where moisture or water is present at the substrate.

Accordingly, conventional dry-surface requirements, including the standard dew point margin, do not automatically apply to Aqua Guard when used within its approved application conditions.

However, the ability to apply Aqua Guard under wet or submerged conditions does not eliminate the requirement for proper surface preparation.

## THE FOLLOWING REQUIREMENTS REMAIN APPLICABLE

- Removal of oil, grease, loose corrosion and other detrimental contamination.
- Appropriate mechanical surface preparation and anchoring profile.
- Removal or reduction of soluble salts to the extent required by the approved application procedure.
- Verification of substrate integrity and removal of unsound material.
- Compliance with product-specific temperature, mixing, application and curing requirements.

For underwater applications, surface preparation should be completed as close as practical to application to minimise renewed contamination or marine deposits.

The substrate shall be assessed according to the specific application conditions and the approved Aqua Guard procedure.

**PREPARATION QUALITY**

SepcoTech Aqua Guard provides an engineered solution for applications where conventional environmental control is impractical or impossible. This capability shall not be interpreted as permission to compromise on surface cleanliness or preparation quality.

**KEY ACCEPTANCE VALUES**

SURFACE PROFILE

**40 µm**

**Minimum, or approved product-specific requirement**

SOLUBLE SALTS

**Within specified acceptance limit**

ENVIRONMENTAL CONDITIONS

**Within applicable TDS requirements**

SURFACE PREPARATION

# Final Inspection and Acceptance

Final inspection shall confirm that the prepared substrate meets the requirements of the selected SepcoTech product and the applicable project specification.

## GENERAL ACCEPTANCE CRITERIA

- Surface cleanliness: Specified preparation grade achieved
- Surface profile: Minimum 40 µm or approved product-specific requirement
- Oil and grease: No detrimental contamination
- Soluble salts: Within specified acceptance limit
- Dust and residues: Within specified cleanliness criteria
- Existing coatings: Sound, compatible and properly prepared where retained
- Flash rust: Within product-specific acceptance criteria
- Environmental conditions: Within applicable TDS requirements
- Documentation: Inspection results recorded where required

**AT A GLANCE**

MOISTURE OR WATER

**Not by itself grounds for rejection**

STILL ESSENTIAL

**Surface cleanliness, substrate integrity, mechanical preparation and product-specific requirements**

DEVIATIONS

**Technically evaluated and approved**

SPECIAL ACCEPTANCE CONSIDERATIONS

# SepcoTech Aqua Guard

For SepcoTech Aqua Guard, the presence of moisture or water shall not, by itself, constitute grounds for rejection, provided the application falls within the product's approved operating conditions.

Conventional dry-surface requirements shall therefore not be applied indiscriminately to Aqua Guard.

However, surface cleanliness, substrate integrity, mechanical preparation and product-specific application requirements remain essential acceptance criteria.

Where conventional inspection or measurement methods cannot be performed under wet or submerged conditions, an appropriate preparation and acceptance procedure shall be established before application.

Any deviation from the specified surface profile or cleanliness requirements shall be technically evaluated and approved.

**PRACTICAL ASSESSMENT MAY INCLUDE**

**Visual inspection**

**Comparison with recognised preparation standards**

**Surface profile comparators**

**Photographic documentation**

SURFACE PREPARATION

# Practical Inspection for Marine Maintenance Personnel

In onboard maintenance and field repair situations, specialised inspection instruments may not always be available.

Where permitted by the applicable work specification, practical assessment may include visual inspection, comparison with recognised preparation standards, appropriate surface profile comparators and photographic documentation.

Such assessments can support the evaluation of surface preparation quality but shall not be considered equivalent to mandatory instrument measurements.

Where compliance with a numerical surface profile or soluble salt limit is required, appropriate verification equipment or an approved alternative inspection procedure shall be used.

**IMPORTANT**

Application shall not proceed where specified preparation requirements remain unfulfilled unless an authorised technical deviation has been approved.

**STANDARDS BY TOPIC**

SURFACE CLEANLINESS

**ISO 8501-1 to ISO 8501-4**

CONTAMINATION

**ISO 8502-3, ISO 8502-6 and ISO 8502-9**

SURFACE PROFILE

**ISO 8503 series, including ISO 8503-5**

SURFACE PREPARATION

# Applicable Standards and References

The following standards provide the technical framework for the surface preparation methods described in this guideline.

## STANDARDS

- ISO 8501-1: Visual assessment of surface cleanliness - rust grades and preparation grades
- ISO 8501-2: Preparation grades of previously coated steel substrates
- ISO 8501-3: Preparation grades of welds, edges and other surface imperfections
- ISO 8501-4: Initial surface conditions, preparation grades and flash rust grades for water jetting
- ISO 8502-3: Assessment of dust on prepared steel surfaces
- ISO 8502-6: Extraction of water-soluble contaminants - Bresle method
- ISO 8502-9: Conductometric determination of water-soluble salts
- ISO 8503 series: Surface roughness characteristics of blast-cleaned steel substrates
- ISO 8503-5: Replica tape method for determining surface profile

Where contractual requirements specify additional AMPP, SSPC or NACE standards, the applicable project specification shall identify the required preparation and inspection criteria.

**AT A GLANCE**

PREFERRED METHOD

**Abrasive blasting**

ALTERNATIVES

**Mechanical preparation and water jetting**

SPECIALISED PRODUCTS

**SepcoTech Aqua Guard**

SURFACE PREPARATION

# General Technical Statement

SepcoTech recommends abrasive blasting as the preferred method of surface preparation wherever practical.

However, the company recognises that marine, offshore and industrial maintenance frequently requires alternative preparation methods.

Mechanical preparation and water jetting may provide suitable alternatives when correctly selected, executed and verified.

The required preparation standard shall always reflect the selected product, substrate condition, service environment and intended application.

Specialised products such as SepcoTech Aqua Guard are engineered to perform under conditions where conventional dry-surface application is not feasible.

**THE OBJECTIVE**

The objective is not simply to achieve a visually clean surface, but to establish a properly prepared substrate capable of supporting reliable adhesion and long-term product performance.


One coating
for
all applications
SEPCO TECH

# Class approval - index

ABS 86

| | |
|---|---|
| CERTIFICATE NUMBER | 26-0531591-PDA |
| EFFECTIVE DATE | 03-Mar-2026 02- |
| EXPIRY DATE | Mar-2031 |
| ABS TECHNICAL OFFICE | Houston Materials |

CERTIFICATE OF

# Product Design Assessment

This is to certify that a representative of this Bureau did, at the request of

## DANTECH OFFSHORE & MARINE GROUP LLC

2660 NW 15TH CT STE 104, , POMPANO BEACH, FL, United States, 33069-1500

assess design plans and data for the below listed product. This assessment is a representation by the Bureau as to the degree of compliance the design exhibits with applicable sections of the Rules. This assessment does not waive unit certification or classification procedures required by ABS Rules for products to be installed in ABS classed vessels or facilities. This certificate, by itself, does not reflect that the product is Type Approved. The scope and limitations of this assessment are detailed on the pages attached to this certificate.

| | |
|---|---|
| **Product:** | **Synthetic Repair Compounds & Resins UNIGRIP 101 Super Guard** |
| **Model:** | **UNIGRIP 201 Super Metal Filler Compound**<br>**UNIGRIP 301 Fast Steel Epoxy Sticks**<br>**UNIGRIP 401 Fiberglass Pipe Repair Tape**<br>**UNIGRIP 501 Exhaust Repair Compound**<br>**UNIG...** |
| **Endorsements:** | |
| **Tier:** | **2 - PDA Issued** |

This Product Design Assessment (PDA) Certificate remains valid until 02/Mar/2031 or until the Rules and/or Standards used in the assessment are revised or until there is a design modification warranting design reassessment (whichever occurs first).

Acceptance of product is limited to the "Intended Service" details prescribed in the certificate and as per applicable Rules and Standards.

This Certificate is valid for installation of the listed product on ABS units which exist or are under contract for construction on or previous to the effective date of the ABS Rules and standards applied at the time of PDA issuance. Use of the Product for non-ABS units is subject to agreement between the manufacturer and intended client.

American Bureau Of Shipping

Satya P.K. (Satya Meruva) Meruva,Manager

NOTE: This certificate evidences compliance with one or more of the Rules, Guides, standards or other criteria of ABS or a statutory, industrial or manufacturer's standards. It is issued solely for the use of ABS, its committees, its clients or other authorized entities. Any significant changes to the aforementioned product without approval from ABS will result in this certificate becoming null and void. This certificate is governed by ABS Rules 1-1-A3/5.9 Terms and Conditions of the Request for Product Type Approval and Agreement (2010).

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Web:

***Tier: 2 - PDA Issued***

***Product:*** ***Synthetic Repair Compounds & Resins***

***Model:*** ***UNIGRIP 101 Super Guard***
***UNIGRIP 201 Super Metal Filler Compound***
***UNIGRIP 301 Fast Steel Epoxy Sticks***
***UNIGRIP 401 Fiberglass Pipe Repair Tape***
***UNIGRIP 501 Exhaust Repair Compound***
***UNIGRIP 601 Super Cast Compound***
***UNIGRIP 701 AquaGuard - Epoxy Coating***

***Endorsements:***

***Intended Service:***
Thecomposite pipe repair wrap systems intendedfor therepairofmetallic and non-metallic piping systems. Repair compounds, fillers, casting materials, and protective coatings intended for patching, sealing, rebuilding, and resurfacing of worn or damaged components.

***Description:***
UNIGRIP 101 Super Guard:
Two-part Epoxy based compound

UNIGRIP 201 Super Metal Filler Compound:
Two-part Epoxy based compound use above and below the waterline

UNIGRIP 301 Fast Steel Epoxy Sticks
Two-part Epoxy based compound use above and below the waterline

UNIGRIP 401 Fiberglass Pipe Repair Tape:
Glass fiber-reinforced polyurethane resin system.

UNIGRIP 501 Exhaust Repair Compound:
Asbestos-free high-temp resistant compound. Based on alkaline silicates and water glass.

UNIGRIP 601 Super Cast Compound
Two-part Epoxy based compound.

UNIGRIP 701 AquaGuard - Epoxy Coating
Two-part Epoxy based compound use underwater, in the splash zone and above the waterline

***Rating:***
UNIGRIP 101 Super Guard:
Temperature Resistance: 356°F (180°C)

UNIGRIP 201 Super Metal Filler Compound
Temperature Resistance: 230°F (110°C)

UNIGRIP 301 Fast Steel Epoxy Sticks:
Temperature Resistance: 302°F (150°C)

UNIGRIP 401 Fiberglass Pipe Repair Tape:
Temperature Resistance: 302°F (150°C)
Maximum pipe pressure with Unigrip Putty: 1,500 psi (103 Bar)

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Maximum pipe pressure without Unigrip Putty: 145 psi (10 Bar)

UNIGRIP 501 Exhaust Repair Compound
Temperature Resistance: 2372°F (1300°C)

UNIGRIP 601 Super Cast Compound:
Temperature Resistance: 230°F (110°C)

UNIGRIP 701 AquaGuard - Epoxy Coating
Temperature Resistance: 230°F (110°C)

Please also refer to the attached technical data sheets for complete product ratings.

***Service Restriction:***
1.) Unit Certificationis not required for this product. 2.) Prior to each repair, a repair plan shall be prepared and discussed with the attending ABS Surveyor. 3.) Engineering calculations are required when repair applications exceed manufacturer-published approved Technical Data Sheet limits or involve non-standard configurations. 4.) Repairs performed fully within published approved TDS limits may be accepted without additional calculations at the discretion of the attending Surveyor. 5.) If the manufacturer or purchaser requests an ABS Certificate for compliance with a specification or standard, the specification or standard, including inspection standards and tolerances, must be clearly defined. 6.) Service conditions, and acceptance criteria applicable to composite pipe repair systems shall apply only to the relevant wrap products and shall not be interpreted as applicable to repair compounds or coatings unless explicitly stated. 7.) When applied in accordance with the manufacturer's instructions and within published approved Technical Data Sheet limits, the composite repair systems may be accepted as long-term repairs subject to surveyor acceptance and service conditions.

***Comments:***
1.) The manufacturer has provided a declaration about the control of, or the lack of Asbestos in this product. 2.) Prior to each repair, a reconditioning plan is to be prepared and discussed with the attending ABS Surveyor. The repair plan is to include as minimum the material to be removed from the affected machinery part, the cleaning and inspection methodology, the thickness of the epoxy resin applied, any curing taken place, etc. When required, calculations showing that the manufacturer's specified minimum allowable strength and corresponding thickness/ diameter are maintained, are to also be carried out. 3.) This coating has been type approved as complying with the identified Standards. 4.) Proper application in accordance with the Manufacturer's Iinstruction is needed, which should reflect the application of the test cases used to determine compliance. 5.) ABS expressly disclaims all warranties with respect to the coating and the design assessment, including warranties of merchantability and fitness for a particular purpose. Successful coating is dependent on coating properties (some of which may not have been addressed in the approval standard), proper application (including surface prep, application, curing environment, etc.) and proper maintenance. These aspects are beyond the scope of this type approval.

***Notes/Drawing/Documentation:***
Drawing No. 18 600 002, Certificate of Conformity, Revision: -, Pages: Drawing No. 701 TDS, Unigrip Aqua Guard, Revision: -, Pages: Drawing No. 18 600 005, Certificate of Conformity, Revision: -, Pages: Drawing No. 0058-BR-LAB-sl-25, Lab Report, Revision: -, Pages: Drawing No. 201 SDS, Unigrip Super Metal Filler, Revision: 1.0.0, Pages: Drawing No. NL029176, ISO 14001, Revision: -, Pages: Drawing No. 301 SDS, Unigrip FastSteel Putty Stick, Revision: 1.0.0, Pages: Drawing No. 0059-BR-LAB-sl-25, Lab Report, Revision: -, Pages: Drawing No. 101 SDS, Unigrip Super Guard, Revision: 1.0.0, Pages:

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Drawing No. GB19 964972, ISO 9001-2015, Revision: -, Pages:
Drawing No. 501 SDS, Unigrip Exhaust Repair Compound, Revision: 1.0.0, Pages:
Drawing No. 101 TDS, Unigrip Super Guard, Revision: -, Pages:
Drawing No. Client Letter 4, Unigrip products for ABS certification, Revision: -, Pages:
Drawing No. 501 TR, Technical Properties and Lab Test, Revision: -, Pages:
Drawing No. 0060-BR-LAB-sl-25, Lab Report, Revision: -, Pages:
Drawing No. 301 TDS, Unigrip FastSteel Epoxy Putty Stick, Revision: -, Pages:
Drawing No. 401 SDS, Unigrip Pipe Repair Tape, Revision: 1.0.0, Pages:
Drawing No. 401 TDS, Unigrip Pipe Repair Tape, Revision: -, Pages:
Drawing No. Client Letter 3, Change Control Statement, Revision: -, Pages:
Drawing No. 701 SDS, Unigrip Aqua Guard, Revision: 1.0.0, Pages:
Drawing No. 501 TDS, Unigrip Exhaust Repair Compound, Revision: -, Pages:
Drawing No. 16 001 001, Certificate of Conformity, Revision: -, Pages:
Drawing No. 601 TDS, Unigrip SuperCast Compound, Revision: -, Pages:
Drawing No. 601 SDS, Unigrip SuperCast Compound, Revision: 1.0.0, Pages:
Drawing No. 201 TDS, Unigrip Super Metal Filler, Revision: -, Pages:
Drawing No. 01 100 102101, ISO 9001-2015, Revision: -, Pages:
Drawing No. 08 Aug 25, Standard Roscoat Physical Properties, Revision: -, Pages:
Drawing No. 28 200 005, Certificate of Conformity, Revision: -, Pages:

***Terms of Validity:***
ThisProduct Design Assessment (PDA) Certificate remains valid until 02/Mar/2031 or until the Rules and/or Standards used in the assessment are revised or until there is a design modification warranting design reassessment (whichever occurs first).

Acceptance of product is limited to the "Intended Service" details prescribed in the certificate and as per applicable Rules and Standards.

This Certificate is valid for installation of the listed product on ABS units which exist or are under contract for construction on or previous to the effective date of the ABS Rules and standards applied at the time of PDA issuance.

Use of the Product for non-ABS units is subject to agreement between the manufacturer and intended client.

***~~STANDARDS~~***

***ABS Rules:***

ABS Rules forBuilding and Classing Marine Vessel Rules (2026): 1-1-4/7.7, 1-1-A3, 1-1-A4, 4-1-1/3.3
ABS Mobile Offshore Units (2026) 1-1-4/9.7, 1-1-A2, 1-1-A3

***National:***
ASTM D149-20
ASTM D695-26
ASTM D1002-10 (2019)
ASTM D2240-15 (2021)
ASTM D2566-86
ASTM E831-25

***International:***
ISO 527-2:2025
ISO 604:2002
ISO 868:2003
ISO 1522:2022

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ISO 4624: 2023 ISO 7784-2: 2023 DIN 53213-1:1978 DIN 53217-4:1991 DIN 53452:1977

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***Government:***

NA

***EUMED:***

NA

***OTHERS:***

NA



# Non dangerous goods

*Supplied in cartridges below 5 l/kg so it doesn't exceed the limits set by DG transport regulations. As a result, it is not classified as flammable or toxic and does not require hazard classification for shipping.*

# Chemical resistance list

## Application & Mixing

| Property | Super Guard | Super Metal Filler | Hi-Temp Putty | FastSteel Putty | Pipe Tape | Exhaust Repair Kit | Aqua Guard | Top Coat | PWS |
|---|---|---|---|---|---|---|---|---|---|
| Type | Epoxy Coating | Heavy duty filler | Epoxy Putty | Epoxy Putty | Fiberglass tape | Cold weld paste | Epoxy Coating | PU Coating | PU Coating |
| Consistency | Fluid | Paste | Paste | Paste | — | Fluid/Paste | Fluid | Fluid | Fluid |
| Application method | Brush/roller/ spray | Spatula | Hand/knead | Hand/knead | Hand | Spatula | Brush/roller/ spray | Brush/roller/ spray | Brush/roller/ spray |
| Mixing ratio (vol.) | Pre-mixed (or 2:1) | 1:1 | 1:1 | 1:1 | — | Pre-mixed | Pre-mixed | 4:1 | 3:1 |

## Temperature & Cure Times

| | Super Guard | Super Metal Filler | Hi-Temp Putty | FastSteel Putty | Pipe Tape | Exhaust Repair Kit | Aqua Guard | Top coat | PWS Clear-Semi matt-Matt |
|---|---|---|---|---|---|---|---|---|---|
| Max Temperature | 356 °F (180 °C) | 230 °F (110 °C) | 500 °F (260 °C) | 300 °F (150 °C) | 300 °F (150 °C) | 2372 °F (1300 °C) | 230 °F (110 °C) | 300 °F (150 °C) | 300 °F (150 °C) |
| Potlife @ 68°F (20 °C) | 65 min | 20-30 min | 15-20 min | 10-15 min | 5 min | 20-30 min | 45-55 min | 1-2 hrs | 2-3 hrs |
| Curing time / dust free @ 68°F (20 °C) | 3-4 hrs | 1-2 hrs | 10-20 min | 10-20 min | 5-10 min | 4-5 hrs | 3-4 hrs | 3-4 hrs | 3-4 hrs |
| Heat resistance corrosion protection | 356 °F (180 °C) | 482 °F (250 °C) | 500 °F (260 °C) | 300 °F (150 °C) | 300 °F (150 °C) | 2372 °F (1300 °C) | 230 °F (110 °C) | 300 °F (150 °C) | 300 °F (150 °C) |

## Mechanical Properties

| | Super Guard | Super Metal Filler | Hi-Temp Putty | FastSteel Putty | Pipe Tape | Exhaust Repair Kit | Aqua Guard | Top coat | PWS Clear-Semi matt-Matt |
|---|---|---|---|---|---|---|---|---|---|
| Machinability | yes | yes | yes | yes | | yes | yes | | |
| Hardness shore D | 80 | ≥82 | 80 | 80 | 75 | | 80 | | |
| Compressive strength Peak (N) | | 11351 | | | | | | | |
| Compressive Tension Peak (N/mm2) | | 67.58 | | | | | | | |
| Compressive strength F-Crack (N) | | 11351 | | | | | | | |
| Compressive strength Tension Break (N/mm2) | | 67.58 | | | | | | | |
| Compressive Strength Displacement Peak (mm) | | 0.514 | | | | | | | |
| Tenstile Strength Peak (N) | | 710.97 | | | | | | | |
| Tenstile Strength Peak (N/mm2) | | 23.276 | | | | | | | |
| Tenstile Strength F-Crack (N) | | 691.98 | | | | | | | |
| Tenstile Strength Tension Break (N/mm2) | | 22.648 | | | | | | | |
| Tenstile Strength Displacement Peak (mm) | | 1.243 | | | | | | | |
| Tensile strength R-crack (N/mm2) | 22.8 | | 5.7 | 5.6 | | | 22.1 | | 21.4 |
| Tensile strength E-modulus (N/mmz) | 2057.3 | | 4204.4 | | | | 1972.4 | | 1.933.2 |
| Compressive strength R-crack (N/mm2) | 53.7 | | 39 | 36 | | | 51.3 | | 51.4 |
| Compressive strength E-modulus (N/mm2) | 546.6 | | 571.64 | | | | 518.8 | | 548.2 |
| Compr. Strength R.Max (N/mm2) | 53.7 | | na | na | | | 51.3 | | 51.4 |
| Shear-adhesion R-Crack (N/mm2) | 30 | 34.413 | | | | | 29 | | TBA |

## Adhesion & Other Properties

| | Super Guard | Super Metal Filler | Hi-Temp Putty | FastSteel Putty | Pipe Tape | Exhaust Repair Kit | Aqua Guard | Top coat | PWS Clear-Semi matt-Matt |
|---|---|---|---|---|---|---|---|---|---|
| Adhesion to steel (N/mm2) | ≥8.4 | ≥7.2 | 5.6 | 5.5 | | | 6.6 | | ≥6.6 |
| Adhesion to aluminum (N/mm2) | ≥3.3 | ≥3.3 | 5.2 | 5.1 | | | 7.1 | | ≥7.1 |
| Specific volume (m2/kg) | 2.1 | 0.62 | na | na | | | 2.1 | 7.1 | 7.9 |
| dielectric strenght KV/mm | 10 | 10 | | 11.8 | 10.1 | | 10 | | |
| Taber test - Average wear index | 122 | | | | | | 146.2 | 66 | 142 |

## Chocking and Casting Compound

| Property | Value | Property | Value |
|---|---|---|---|
| Application Type | Casting/Chocking | Compressive Strength A + B (E-modulus) | 1025 N/mm2) |
| Consistency | Fluid | R-Brk | 106 N/mm2) |
| Application by | pour/inject | A + B + 25% Silver sand (E-modulus) | 855 N/mm2) |
| Mixing Ratio Vol. | mix 18:1 | R-Brk | 98 N/mm2) |
| Max Temperature | 300 °F (150 °C) | A + B + 25% Filler granulate 2.0-2.5 mm (E-modulus) | 1147 N/mm2) |
| Potlife @ 68°F (20 °C) | 20-30 min | Bending Tensile strength | 43.2 N/mm2 |
| Curing time / dust free @ 68°F (20 °C) | 6-8 hrs | E-modulus | 7.200 N/mm2 |
| Specific gravity (mixed product) | 2.2 kg/dm3 | Shear Strength | 6.8 N/mm2 |
| | | Tensile strength | 16.8 N/mm2 |
| | | Linear expansion coefficient | 5 x 10-5 K-1 |

# Contact us




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