

## PRODUCT DATA SHEET

# Sika® Permacor®-3326 EG H

Very high solid epoxy coating for steel and concrete

Made in Germany

### DESCRIPTION

Sika® Permacor®-3326 EG H is a low solvent containing 2-pack epoxy coating for steel and concrete. The coating has high physical strength, with good abrasion and impact resistance. Crack bridging capability up to 3 mm (laminated system).

### USES

Sika® Permacor®-3326 EG H may only be used by experienced professionals.

Sika® Permacor®-3326 EG H is ideally suited for the corrosion protection of steel and concrete surfaces exposed to various media.

The principal use of Sika® Permacor®-3326 EG H is the internal lining of sludge digesters, composting vessels, and process water-, waste water-, and chemical storage tanks, as well as cooling water pipelines and biogas plants.

Sika® Permacor®-3326 EG H is also suitable as a robust anti-corrosive coating for use in industrial environments, e.g. for pipe bridges, bottling plants, and as an external coating for tanks and pipes, machinery and other pieces of apparatus.

### CHARACTERISTICS / ADVANTAGES

- High chemical resistance to water, aggressive effluents and waste water and a wide range of chemicals, particularly salt solutions and to acids occurring in biological processes
- High diffusion resistance
- Very good adhesion to steel and mineral surfaces
- Reliable application due to the ability to check for pores in the coating

### APPROVALS / CERTIFICATES

Evidence for chemical resistance against biogenous sulfuric acid (cat. XWW4/XBSK) acc. DIN 19573 and DIN EN 13529.

Coating based on epoxy resin for concrete protection according to EN 1504-2, DoP, with CE-mark.

### PRODUCT INFORMATION

<b>Packaging</b>	Sika® Permacor®-3326 EG H	16 kg net.
	Sika® Thinner E+B	25 l and 5 l
	SikaCor® Cleaner	160 l and 25 l
<b>Appearance and colour</b>	Pebble grey approx. RAL 7032 and green approx. DB 601	
<b>Shelf life</b>	2 years	
<b>Storage conditions</b>	In originally sealed containers in a cool and dry environment.	

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Density	~1.9 kg/l
Solid content	~75 % by volume ~88 % by weight

## TECHNICAL INFORMATION

Chemical resistance	Upon request
Temperature resistance	Dry heat up to approx. + 100°C

## SYSTEM INFORMATION

System	<p><u>Steel:</u> 2 - 3 x Sika® Permacor®-3326 EG H (250 µm per layer)</p> <p><u>Concrete:</u>  <b>1. Crack-bridging coating structure (up to 0,5 mm):</b>  - Surface preparation by blast cleaning etc.  - Surface filler Icoment®-520 mortar, approx. 1200 g/m<sup>2</sup>  - Fine surface filler Icoment®-520 mortar, approx. 1800 g/m<sup>2</sup>  - Primer and base coat Sikagard®-177, approx. 400 - 600 g/m<sup>2</sup>  - Broadcast quartz sand (0,1 - 0,3 mm), approx. 800 - 1000 g/m<sup>2</sup>  - Top coats 3 x Sika® Permacor®-3326 EG H, approx. 420 g/m<sup>2</sup> per coat</p> <p><b>2. Crack-bridging coating structure (laminated system, up to 3 mm):</b>  - Surface preparation by blast cleaning etc.  - Surface filler Icoment®-520 mortar, approx. 1200 g/m<sup>2</sup>  - Fine surface filler Icoment®-520 mortar, approx. 1800 g/m<sup>2</sup>  - Primer and base coat Sikagard®-177, approx. 400 - 600 g/m<sup>2</sup>  - Sika® Betonol special fabric (Sika® Betonol Spezialgewebe, 300 g/m<sup>2</sup>, not including laps)  - Embedding layer Sikagard®-177, approx. 800 - 1000 g/m<sup>2</sup>  - Top coats 3 x Sika® Permacor®-3326 EG H, approx. 420 g/m<sup>2</sup> per coat</p> <p>Note:  If there is a possibility of moisture penetration behind the system, Icoment®-520 fine surface filler must be replaced by Epoxy Cement Combination (ECC) based Sikagard®-720 EpoCem mortar. The actual consumption of all materials is dependent on the surface profile, characteristics and application method. The average dry film thickness must be min. 500 µm for Sika® Permacor®-3326 EG H top coat.  Please also refer to PDS of relevant levelling and surface filling mortars.</p>
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## APPLICATION INFORMATION

Mixing ratio		Components A : B
	By weight	100 : 23
	By volume	100 : 26
Thinner	Sika® Thinner E+B If necessary max. 5 % Sika® Thinner E+B may be added to adapt the viscosity.	
Consumption	Theoretical material-consumption/coverage without loss for medium dry film thickness of:	
	Dry film thickness	250 µm
	Wet film thickness	330 µm
	Consumption	0.633 kg/m <sup>2</sup>
	Coverage	1.58 m <sup>2</sup> /kg

<b>Material temperature</b>	Min. + 10°C	
<b>Relative air humidity</b>	Max. 85 % Max. 80 % in containers, except the surface temperature is significantly higher than the dew point temperature, it shall be at least 3 K above dew point.	
<b>Surface temperature</b>	Min. + 10°C	
<b>Substrate moisture content</b>	Max. 4 % (CM-measuring)	
<b>Pot Life</b>	At + 20°C	~90 min
	At + 30°C	~45 min
<b>Waiting time to overcoating</b>	<b>Waiting time at + 20°C</b> Min. 12 h <u>Coating used as lining:</u> Max. 48 h at + 20°C In case of longer waiting times the surface must be activated by sweep blasting. <b>Overcoating</b> With itself. <u>For exposure to corrosive atmospheric conditions, also:</u> With Sika® Permacor®-2230 VHS or Sika® Permacor®-2330. For other products please refer to Sika.	
<b>Drying time</b>	<b>Drying time at + 20°C</b>	
	Touch dry	after ~4 h
	Walkable	after ~12 h
	<b>Final drying time</b> Full mechanical and chemical resistance after 7 days at + 20°C.	
<b>Porosity test</b>	With a suitable high-voltage tester, e.g. Fischer-POROSCOPE® with flat electrode (rubber tongue). Test voltage 5 Volt per 1 µm coating thickness. Multiple porosity tests have negative effects on dielectric strength. This is to take into consideration when planning repetition tests.	

## BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## ECOLOGY, HEALTH AND SAFETY

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

## APPLICATION INSTRUCTIONS

### SUBSTRATE PREPARATION

#### Concrete:

The surface areas to be coated must meet recognised building standards, i.e. be solid, load-bearing and free from contaminants detrimental to adhesion. Pull-off adhesion strength in accordance with DIN 1048 should be > 1.5 N/mm<sup>2</sup> on average with the lowest reading no less than 1.0 N/mm<sup>2</sup>. For areas subject to heavy mechanical loading, the average value should be

> 2.0 N/mm<sup>2</sup> and the lowest reading no less than 1.5 N/mm<sup>2</sup>. Apply suitable compatible undercoats and observe recommended overcoating intervals.

### SURFACE PREPARATION

#### Steel:

Remove all weld spatter, then grind welds and joints in accordance with EN 14879-1.  
Blast-cleaning to Sa 2 ½ according to ISO 12944-4.  
Free from dirt, oil and grease.  
Average roughness depth R<sub>z</sub> ≥ 50 µm.

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## MIXING

Stir component A and B very thoroughly using an electric mixer (start slowly, then increase up to approx. 300 rpm). Add stirred component B carefully and mix both components very thoroughly (including sides and bottom of the container). Mix for at least 3 minutes until a homogeneous mixture is achieved. Fill mixed material into clean container and mix again shortly as described above. During mixing and handling of the materials always wear protective goggles, suitable gloves and other protective clothings.

## APPLICATION

The method of application has a major effect on achieving uniform thickness and appearance. Spray application will give the best results. The indicated dry film thickness is easily achieved by airless spray. Adding solvents reduces the sag resistance and the dry film thickness. In case of application by roller or brush, additional applications may become necessary to achieve the required coating thickness, depending on type of construction, site conditions, colour shade etc. Prior to major coating operations a test application on site may be useful to ensure the selected application method will provide the requested results.

### By brush or roller:

- Dry film thickness of approx. 150 µm per layer is achievable
- Possibly an additional layer may become necessary to achieve the total dry film thickness

### Airless-spraying:

- Efficient airless equipment
- Pressure min. 180 bar
- Remove sieves
- Nozzle size  $\geq 0.38$  mm ( $\geq 0.015$  inch)
- Spraying angle approx. 50°
- Diameter of hoses min. 10 mm ( $\frac{3}{8}$  inch), hose at spray gun approx. 2 m, min. 6 mm ( $\frac{1}{4}$  inch)
- Temperature of material min. + 15°C

## CLEANING OF EQUIPMENT

SikaCor® Cleaner

## LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the performance of this product may vary from country to country. Please consult the local Product Data Sheet for the exact description of the application fields.

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## LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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