Approved Quality Management System AS/NZS ISO 9001:2008 Lloyds Register-Certificate No. MEL 0927759

Technical Data Sheet
DENSOPOL 80HT MARINE TAPE

Description:	A heavy duty, reinforced, bitumen based adhesive compound, corrosion protection tape designed for use in tropical marine environments.
Composition:	A synthetic fabric reinforcement coated with a bitumen based adhesive compound backed with a heavy duty PVC. Includes a release liner (interleaving) which is removed prior to use, for ease of application and handling.
Characteristics:	• sticks and bonds rapidly and permanently to clean dry primed surfaces • fast simple application • flexible, long lasting, self sealing to minor substrate blemishes • secure lap sealing on edges and overlaps • specially designed high impact PVC backing ensuring rugged durability and a high degree of conformability and controlled elasticity • stable in composition over a wide temperature range • non hardening or cracking, contains no volatile components • accommodates vibration and movement of substrate • highly resistant to mineral acids, alkalis and salts • highly resistant to cathodic disbondment • protruding interleaving prevents edge of roll dirt "pick-up" during site handling, minimising contamination risk and assuring coating integrity
Uses:	Designed specifically for the protection of butt welded joints on large diameter weight coated steel pipes intended for submarine use. Provision of corrosion protection to weld areas and the withstanding of hot poured marine mastic as commonly used in lay barge operations. Used in conjunction with Denso Primer D and Bitumen Mastic Strip to contour and protect irregular surfaces and shapes The mechanical protection of petrolatum systems in marine environments.
Surface Preparation:	Prepare steel to St2 (power brushed) / AS1627 P.2 (minimum) Edges should be chamfered to remove step down. Approximately a 100mm band of any pre-existing factory coatings should be abraded and solvent (toluene) degreased either side of a joint.
Application: **Primer** **Profiling** **Wrapping**	Denso Primer D should be applied to the prepared substrate at a rate of 9 - 11 m^2/litre and allowed to tack dry (10 to 20 minutes), prior to the use of Bitumen Mastic Strip or Densopol 80HT Marine Tape. Denso Bitumen Mastic Strip should be applied to contour weld beads and step downs on shop coatings so that subsequent tape wrapping can conform smoothly to the substrate being protected. The mastic can be cut into smaller strips and moulded into crevices and cavities. Apply Densopol 80HT Marine Tape with compound side to substrate, creating a 55% overlap of tape to effectively provide a double layer. Smooth down and mould tape by hand, especially at all overlapped edges.
Recommended Temperatures:	Application: + 15 to + 50 °C Service: - 20 to + 75 °C Mastic Pour: + 210 °C max.
Storage:	Store in a cool, dry area away from direct heat and sunlight.
Available Sizes:	Roll Widths: 50, 100, and 150 mm Roll Lengths: 10 M Other sizes available on request.

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Physical Properties:	Test	Method	Units	Value
	Total Thickness	ASTM D1000	mm	2.10 ± 0.25
	Total Weight	ASTM D751	kg/m^2	2.40 ± 0.27
	Tensile Strength	ASTM D1000	MPa	≥ 17.0 ± 3.0
	Breaking Strength	ASTM D1000	N/mm	≥ 18.0
	Elongation at Break	ASTM D1000	%	250 ± 30
	Adhesion - to steel - to self	ASTM D1000	N/mm	≥ 3.0 ≥ 3.0
	Tear Resistance	ASTM D1004	N	≥ 60
	Impact Strength - round cup - chisel cup	 ASTM G14 BGC/PS/CW2	Joule	 10.0 5.5
	Dielectric Strength	ASTM D149	kV	≥ 40
	Limestone Drop Test	ASTM G13	Drops	> 40
	Insulation Resistance	ASTM D257 BS 2782	Ω/cm² MΩ	10^{12} 10^6
	Cathodic Disbondment	ASTM G8 (30 days)	mm^2 Group	< 160 A