

**Product Data Sheet**

<b>Product Name:</b> BITUMEN ENAMEL	<b>Standard:</b> EN 10300 Category 1, Grade b and c / AWWA C 203
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**Product Description:** The Bitumen Enamel is based on specially selected bitumen which is modified by oxidation.

**Delivery:** Bitumen Enamel is available cold in 20 kg block or hot in bulk.

**Application:** Bitumen Enamel is applied to steel pipes, previously primed with Synthetic Primer, at 215-230°C. Also one layer of inner-wrap and one layer of outer-wrap are used in this coating system.

**Storage:** Heated Bitumen Enamel is to be stored under constant low-speed stirring. Storage temperature and duration depends on the Bitumen grade stored.

**Standards:** The Bitumen Enamel meets or exceeds all the performance requirements of EN 10300 Category 1, Grade b or c and AWWA C 203.

**Quality Control:** All raw materials for Bitumen Enamel are tested and approved in the laboratories of Raha Bitumen Co. The quality of the finished enamel is controlled to either EN 10300 or the customer's specific requirements and a quality certificate is issued for each batch produced.



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<b>BITUMEN ENAMEL Type 1 Grade b Technical Data</b>			
<b>Properties</b>	<b>Unit</b>	<b>Requirement</b>	<b>Method of test</b>
Softening Point	°C	110 to 130	EN 1427
Penetration	0.1 mm	5 to 17	EN 1426
Density at 25 °C	g/cm <sup>3</sup>	1.2 to 1.4	EN 10300, Annex L
Filler Content	%	25 to 35	EN 10300, Annex K
Flash Point	°C	Min 260	EN/ISO 2592
Sag at 75 °C , 24 h	°C	Max 1.5	EN 10300, Annex D
Impact disbanded area @25°C	mm <sup>2</sup>	Max 6500	EN 10300, Annex E
Peel Initial / Delayed at 30 °C 40 °C 50 °C 60 °C	mm	3 3 3 3	EN 10300, Annex F, F.4.1
Bend at 0°C	°C	Min 15	EN 10300, Annex G
Catholic Disbanding, Disbanded radius after 28 day	mm	Max 10	EN 10300, Annex I



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<b>BITUMEN ENAMEL Type 1 Grade c Technical Data</b>			
<b>Properties</b>	<b>Unit</b>	<b>Requirement</b>	<b>Method of test</b>
Softening Point	°C	120 to 150	EN 1427
Penetration	0.1 mm	5 to 15	EN 1426
Density at 25 °C	g/cm <sup>3</sup>	1.4 to 1.65	EN 10300, Annex L
Filler Content	%	45 to 55	EN 10300, Annex K
Flash Point	°C	Min 260	EN/ISO 2592
Sag at 75 °C , 24 h	°C	Max 1.5	EN 10300, Annex D
Impact disbanded area @25°C	mm <sup>2</sup>	Max 6500	EN 10300, Annex E
Peel Initial / Delayed at 40 °C 50 °C 60 °C	mm	3 3 3	EN 10300, Annex F, F.4.1
Bend at 0°C	°C	Min 10	EN 10300, Annex G
Catholic Disbanding, Disbanded radius after 28 day	mm	Max 10	EN 10300, Annex I



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