



HIMTAPE

HOT APPLIED COAL TAR TAPE



PRODUCT DATA SHEET

DESCRIPTION

Himtape is a hot applied, factory made, prefabricated coal tar coating in tape form for underground gas, oil and water pipelines. Himtape is composed of specially formulated plasticized coal tar coating completely saturated and bonded to both sides of a high tensile strength fabric. Himtape is manufactured in accordance with AWWA C-203 and IS-10221.

USES

Himtape is used to protect underground or submerged metal surface from corrosion and electrolysis.

It is commonly used in :

- Oil and gas pipelines
- Tanks underground structures and fittings
- Water and sewage pipelines
- Fire hydrant lines
- pipe joints, fittings and couplings

ADVANTAGES

- Ease of application and low application cost
- Uniform coating thickness
- High water and electrical resistance
- Cathodic disbonding resistivity
- Resistance to soil bacteria, marine organisms, root growth
- Resistance to petroleum products, acids & alkalies
- Resistance to damage due to impact of backfill
- Good flexibility and temperature susceptibility
- Excellent adhesion to metal surfaces
- Environment friendly
- Good resistance to abrasion

Technical specification

Characteristics	Range		Test Method
	Min	Max	
Softening point	65	121	ASTMD 36
Penetration 25°C	3	20	AWWA C-203
Filter percentage	20	30	ASTMD 2415
Weight average (kg/sqm/mm)	1.25		ASTMD 146
Breaking strength in longitudinal direction	0.7		AWWA C-203
Adhesion to prime steel	Passes		AWWA C-203
Holiday Test	Passes		AWWA C-203
Impact Test	Passes		AWWA C-203
Thickness MM	2	4	AWWA C-203
Cathodic Disbondment, 28 days (mm)	-	5	BS4164-87
Service temperature C	-	60	

Application methodology

EQUIPMENT

A torch with wider mouth is recommended

SURFACE PREPARATION

- 1 Surface must be free from dust, dirt, grease oil and other foreign material by scrapping or wire brushing to a SSPC-SP-1 standard.
- 2 If moisture is present, it should be removed before primer application by use of torch.

PRIMER APPLICATION

- 1 Himcoat Primer-B is compatible with Himtape. The drum is shaken thoroughly to get a homogenous solution. Primer is applied by brush or spray after proper surface preparation.
2. Precaution should be taken to avoid the contacts of any foreign material with the primed surface prior to application of Himtape.

TAPE APPLICATION

- 1 Himtape is applied after proper surface preparation and priming. When the primed surface gets tacky but not dry, by heating the coating side without polyester film until a smooth and glossy finish is obtained. Heating to be done by a wide-mouthed torch. Heating is to be done very carefully so that the film remains in a semi liquid state during application. Excessive heating is to be avoided. The heated tape is then applied with proper tension with an overlap of 10-12 mm.
2. Spiral wrapping as well as circumferential wrapping is possible with our tape.
3. For weld joints the taping shall start and stop at atleast 4 inches onto the factory wrap.

STORAGE, HANDLING & SHIPPING

To be stored in cardboard boxes in a cool dry covered area. Direct contact with sunlight to be avoided. Proper care must be taken while handling the material during stacking, loading and unloading.

SIZES AND PACKAGING

Available in widths of 200 mm, 250 mm, 330 mm, 500 mm & 1000 mm in length of 10 mtrs and in thickness of 2, 3 and 4 mm. Material is packed in cardboard boxes and shipped.

TECHNICAL SERVICES

Other technical data and advice are available on request.

HEALTH & SAFETY

The use of gloves & goggles and fibre type mask is recommended when applying HIMTAPE.

HIMTAPE PRIMER - C

Himtape Primer - C, cold applied, synthetic primer coating which acts as an effective bond between the surface to be protected and the subsequent coating of 'HIMTAPE' coal tar tape. It conforms the requirements of BS 4164 and AWWA C-203.

Technical specification

Characteristics	Limits	Test Method
Flow time (4mm flow cup) at 23°C	35-60 Sec.	BS 3900 PartA-6
Flash point (Abel closed cup) min.	23°C	BS 2000 Part170
Volatile Matter (105°C to 110°C) Max.	75% loss by mass	Appendix - A
Drying time (Tack free)	5-30 Mts.	
Coverage (theoretical)	8-10 Sqm/ lit/Coat	



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CORROSION PROTECTION DIVISION

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