

# PRODUCT DATA SHEET

## SikaCor®-950 F

### HEAVY DUTY COATING FOR STEEL AND CONCRETE



#### DESCRIPTION

Resistant 2-pack coating of low solvent content based on epoxy with mineral fillers.  
Low solvent content according to Protective Coatings Directive of German Paint Industry Association (VdL-RL 04).

#### USES

SikaCor®-950 F may only be used by experienced professionals.

Protective coating for concrete and steel, for buried and submerged structures for hydraulic engineering constructions and as internal coating for tanks and reservoirs, e.g. sewage treatment, agricultural and chemical industries etc. Also suitable where application onto damp concrete is inevitable.

SikaCor®-950 F can be exposed to water immediately after application. But take into consideration that solvents get into the water which leads to temporary contamination.

Immediate exposure to water should therefore only be considered in special cases and after consulting the authorities for the protection of environment.

**Not suitable for surfaces in contact with drinking water.**

#### CHARACTERISTICS / ADVANTAGES

After complete curing SikaCor®-950 F is:

- Tough hard, heavy duty
- Abrasion and impact resistant
- Excellent resistance to water and chemicals

#### APPROVALS / CERTIFICATES

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

#### PRODUCT INFORMATION

Packaging	SikaCor®-950 F	35 kg and 15 kg net.
	Sika® Thinner S	25 l, 10 l and 3 l
	SikaCor® Cleaner	160 l and 25 l
Appearance and colour	Black, tinted red	
Shelf life	2 years	
Storage conditions	In originally sealed containers in a cool and dry environment.	
Density	~1.9 kg/l	
Solid content	~75 % by volume	
	~88 % by weight	

## TECHNICAL INFORMATION

<b>Chemical resistance</b>	Resistant to freshwater, process water, brackish water, seawater, domestic sewage, faeces, diluted inorganic acids and lyes, neutral salts, mineral and fuel oils, grease, detergents etc. Industrial wastewater upon request, based on wastewater analysis. Not resistant to exposure to benzene-hydrocarbons and tar oil.
<b>Temperature resistance</b>	Dry heat up to approx. + 100°C Warm water up to approx. + 60°C Not resistant to warm water at significant differential of temperature gradient!

## SYSTEM INFORMATION

<b>System</b>	<p><u>Concrete:</u> 2 - 3 x SikaCor®-950 F 1<sup>st</sup> coat to be thinned with max. 5 % by weight Sika® Thinner S, 2<sup>nd</sup> coat unthinned.</p> <p>Alternatively Sika® Icoment®-520 Mortar can be used for levelling and repair of minor surface defects in concrete surfaces by thin layer trowel application process (scratch and fine/smoothing mortar).</p> <p>Furthermore Sikagard®-720 EpoCem Mortar can be used as a relaxation layer instead of Sika Icoment® -520 Mortar in case of rising damp or retral moisture penetration.</p> <p><b>For application and use of the mortar layers we refer to the respective product data sheets!</b></p> <p><u>Steel:</u> 2 - 3 x SikaCor®-950 F Preferably alternating colour shades. In case of heavy mechanical exposure priming with SikaCor® Zinc R is recommended.</p>
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## APPLICATION INFORMATION

<b>Mixing ratio</b>	<table><thead><tr><th></th><th>Components A : B</th></tr></thead><tbody><tr><td>By weight</td><td>93 : 7</td></tr><tr><td>By volume</td><td>100 : 14</td></tr></tbody></table>		Components A : B	By weight	93 : 7	By volume	100 : 14				
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By weight	93 : 7										
By volume	100 : 14										
<b>Thinner</b>	Sika® Thinner S, only thin material where stated. If necessary max. 5 % Sika® Thinner S may be added to adapt the viscosity. In this case an immediate exposure to water is not possible.										
<b>Consumption</b>	<table><tbody><tr><td>Theoretical material-consumption/coverage without loss for medium dry film thickness of:</td><td></td></tr><tr><td>Dry film thickness</td><td>150 µm</td></tr><tr><td>Wet film thickness</td><td>200 µm</td></tr><tr><td>Consumption</td><td>0.380 kg/m<sup>2</sup></td></tr><tr><td>Coverage</td><td>2.63 m<sup>2</sup>/kg</td></tr></tbody></table>	Theoretical material-consumption/coverage without loss for medium dry film thickness of:		Dry film thickness	150 µm	Wet film thickness	200 µm	Consumption	0.380 kg/m <sup>2</sup>	Coverage	2.63 m <sup>2</sup> /kg
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<b>Material temperature</b>	Min. + 10°C										
<b>Relative air humidity</b>	Max. 85 %, except the surface temperature is significantly higher than the dew point temperature, it shall be at least 3 K above dew point. Under unfavourable conditions, e.g. influence of high air humidity into the fresh coating, surface damages and possibly little alligatoring may occur. However, this will not affect the quality.										

<b>Surface temperature</b>	Min. + 10°C		
<b>Pot Life</b>	At + 20°C	1,5 h	
	At + 30°C	45 min.	
<b>Waiting time to overcoating</b>	Waiting time between operations up to max. 150 µm dry film thickness:		
		Waiting time min.	Waiting time max.
	At + 10°C after	30 h	72 h
	At + 15°C after	24 h	60 h
	At + 20°C after	12 h	48 h
	At + 25°C after	8 h	36 h
	At + 30°C after	6 h	24 h
	If these maximum waiting times cannot be observed, the surface must be activated by sweep blasting to avoid intercoat adhesion problems. Prior to application of the next coat a thorough dedusting is necessary.		
	Between SikaCor® Zinc R and SikaCor®-950® F: 24 h at + 20°C (see product data sheet).		
<b>Drying time</b>	Drying Time at + 20°C: Dry to touch after ~4 h, dry to handle after ~12 h		
	Final drying time At + 20°C and good ventilation final curing is achieved after approx. 7 days. Curing also takes place at lower temperatures – below + 10°C – but it takes longer.		

## BASIS OF PRODUCT DATA

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

## ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data. Further notes and information data sheets on product safety and disposal can be found on the Internet at [www.sika.de](http://www.sika.de).

## APPLICATION INSTRUCTIONS

### SUBSTRATE PREPARATION

#### Concrete:

Solid and gripping, free of cement laitance, dust, loose and friable particles and other contamination. Concrete moisture content max. 6 %. Sweep blasting increases adhesion. This is particularly important in case of underwater exposure. Large holes, holidays and cavities etc. should be levelled up with e.g. Icoment®-520 Mortar.

### SURFACE PREPARATION

#### Steel:

Blast-cleaning to Sa 2 ½ according to ISO 12944-4. Free from dirt, oil and grease.

Average roughness depth RZ ≥ 50 µm.

### MIXING

Stir component A very thoroughly using an electric mixer (start slowly, then increase up to approx. 300 rpm). Add 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.

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## 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 and roller

#### 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)
- Temperature of material min. + 15°C

## CLEANING OF EQUIPMENT

SikaCor® Cleaner

## LOCAL RESTRICTIONS

Note that as a result of specific local regulations the declared data and recommended uses for this product may vary from country to country. Consult the local Product Data Sheet for the exact product data and uses.

## 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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