

**Product
Bulletin**

AL3013

AMINE CURED 100% SOLIDS EPOXY PRIMER & REPAIR SYSTEM

GENERAL DESCRIPTION

AL3013 is a 100% solids epoxy based concrete developed for the repair of concrete especially in chemical environments. AL3013 is a tough, chemical resistant coating system that has a fast cure. In the unfilled state, AL3013 has a low viscosity which makes it conducive as a primer. AL3013 will have full cure within 72 hours for quick repair and treatment of concrete. For environments with aggressive chemicals such as acids or caustics, AL3013 can be top-coated.

SURFACE PREPARATION:

Metal surfaces should be cleaned and degreased then abrasive blasted with chloride free abrasives. Grind flat all weld seams, burrs and radius sharp edges. Concrete surfaces should be degreased if contaminants (oil & grease) are present. It is recommended that degreased surfaces be high pressure washed, acid etched and high pressure washed again so the surface are clean and free of all contaminants. Surfaces should be primed. Contact Alfa Customer Service for recommendations.

MIXING:

1. Before removing any material from the containers, thoroughly mix the material.
2. Mix by volume, 2 Parts Base to 1 Part of Activator. By weight, 100 grams of Base to 45 grams of Activator. Mix the Activator into the Base, with a mixing stick or low speed power mixing blade. Mix until the color is homogenous and streak-free.
3. Thinning of the material is not required.

APPLICATION:

Use a trowel, sturdy squeegee, putty knife or caulking gun. Work material into profile of the substrate to achieve adhesion and to remove entrapped air. Using a putty knife or applicator, contour AL3013 to the proper design. Use metal or plastic fabric to bridge large voids. Before full cure, AL3013 can be sanded or ground.

APPLICATION TEMPERATURE:

Keep material between 55 – 59°F (17 – 35°C). Substrate should be 45 – 105°F (7 – 40°C).

APPLICATION, Continued:

The difference in temperature should be 10°F or less. If necessary, heat the area prior to surface preparation. Do not use kerosene, gas or oil heaters as they will create contamination on the substrates. If necessary both parts can be heated prior to use in a warm water bath.

Recoat between 6 – 12 hours @ 77°F (35°C). Full cure before immersion is 7 days at 77°F. Add 1 day for each 10°F below 77°F. Subtract 15 hours for every 10°F above 77°F.

SPECIFICATIONS
HANDLING CHARACTERISTICS

Catalyst Number:	AL3013 PART B
Mix Ratio, Resin to Catalyst, by Weight:	100: 44.9
Mix Ratio, Resin to Catalyst, by Volume:	2:1
Workable Pot Life, 100 g @ 25°C:	30 Min/Gal
Mixed Viscosity @ 25°C cps:	700 – 900 unfilled
Solids, By Volume, %:	100
Color:	Clear Amber

PHYSICAL CHARACTERISTICS
Temperature, Immersion Service:

Maximum 100°F (38°C) Spike to 120°F (49°C)	3 Hrs
Dry to 120°F (49°C) Spike to 140°F (60°C)	3 Hrs

Flexibility:	Fair
Very Good with Fiberglass Mat, 1.5 oz/ft ² (0.5 Kg/M ²)	
Abrasion:	Very Good

CHEMICAL RESISTANCE:

Water:	Excellent
Alkalines:	Good
Inorganic Acids:	Good
Organic Acids:	Fair
Organic Solvents:	Fair

Film Thickness:

10 mils unfilled, fill as required.

STORAGE AND HANDLING:

SHELF LIFE: 3 Years @ 55 – 95°F (13 – 35°C)

COVERAGE:

160 FT² (14.8 M²)/Gal/Coat @ 10 mils.

WEIGHT PER GALLON: 9.0 lbs (4.1 Kg)