

# Technical Data

## Jotamastic 80



### Product description

Jotamastic 80 is a two-pack, surface-tolerant, high solids epoxy mastic coating which can be applied in low film thickness. Available with different hardeners for varying substrate temperatures, Standard (Std) and Wintergrade (WG).

---

### Recommended use

Anticorrosive coating for steel structures above and below water (aluminium versions for use below water), also on steel where blast cleaning may not be possible or desired.

---

### Film thickness and spreading rate

<b>Std Comp. B</b>	<b>Minimum</b>	<b>Maximum</b>	<b>Typical</b>
Film thickness, dry (µm)	75	200	100
Film thickness, wet (µm)	95	250	125
Theoretical spreading rate (m <sup>2</sup> /l)	10,6	4	8

  

<b>WG Comp. B</b>	<b>Minimum</b>	<b>Maximum</b>	<b>Typical</b>
Film thickness, dry (µm)	75	200	100
Film thickness, wet (µm)	105	280	140
Theoretical spreading rate (m <sup>2</sup> /l)	9,6	3,6	7,2

---

### Physical properties

<b>Colour</b>	Aluminium, Aluminium Red toned, Grey, Red, Green, Off-white, Black
<b>Solids (vol %)*</b>	80 ± 2 Std Comp. B 72 ± 2 WG Comp. B
<b>Flash point</b>	<b>Std Comp. B:</b> 35°C ± 2 (Setaflash) <b>WG Comp. B:</b> 31°C ± 2 (Setaflash)
<b>VOC</b>	<b>Std Comp. B</b> 145 gms/ltr UK-PG6/23(97). Appendix 3 <b>WG Comp. B</b> 210 gms/ltr UK-PG6/23(97). Appendix 3
<b>Gloss</b>	Semigloss
<b>Gloss retention</b>	Fair
<b>Water resistance</b>	Very good
<b>Abrasion resistance</b>	Very good
<b>Solvent resistance</b>	Good
<b>Chemical resistance</b>	Good
<b>Flexibility</b>	Good

\*Measured according to ISO 3233:1998 (E)

---

## Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

### Bare steel

Cleanliness: Power tool cleaning to min. St 2, mill scale free (ISO 8501-1:2007). Improved surface treatment (blast cleaning to Sa 2½) will improve the performance. In case of hydrojetting the flash rust degree shall not exceed moderate in SSPC and NACE standards for water prepared surfaces.

### Shopprimed steel

Clean, dry and undamaged approved shopprimer.

### Coated surfaces

Clean, dry and undamaged compatible primer. Contact your local Jotun office for more information. For maintenance UHPWJ to WJ2 (NACE No.5/SSPC-SP 12) or Power tool cleaning to min. St 2 for rusted areas

### Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

---

## Condition during application

The temperature of the substrate should be minimum +10°C (Std) (-5°C in WG) and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is required in confined areas to ensure proper drying.

Hydrojetting of steel surface makes a wet surface. The surrounding air must have a relative humidity not exceeding 85 %. Before painting the surface shall not be glossy with moisture, but can have a patchy appearance.

---

## Application methods

<b>Spray</b>	Use airless spray
<b>Brush</b>	May be used but care must be taken to achieve the specified dry film thickness.
<b>Roller</b>	May be used. However when using roller application care must be taken to apply sufficient material in order to achieve the specified dry film thickness.

---

## Application data

<b>Mixing ratio (volume)</b>	<b>Std Comp. B:</b> 7:1 <b>WG Comp. B:</b> 4:1
<b>Mixing</b>	7 parts by volume Comp. A (Base) to 1 part Jotamastic 80, Std Comp B (curing agent) 4 parts by volume Comp. A (Base) to 1 part Jotamastic 80, WG Comp B (curing agent)
<b>Induction time</b>	10 minutes.
<b>Pot life (23°C)</b>	<b>Std Comp. B:</b> 2 hours <b>WG Comp. B:</b> 1 hour
<b>Thinner/Cleaner</b>	Jotun Thinner No. 17

## Guiding data airless spray

<b>Pressure at nozzle</b>	15 MPa (150 kp/cm <sup>2</sup> , 2100 psi.).
<b>Nozzle tip</b>	0,43 - 0,58 mm (0,017 - 0,023")
<b>Spray angle</b>	40 - 80°
<b>Filter</b>	Check to ensure that the filters are clean

## Note

- \* The temperature of the mixture of base and curing agent is recommended to be at least 15°C, otherwise extra solvent may be required to obtain correct viscosity.
- \* Too much solvent results in lower sag resistance and slower cure.
- \* If extra solvent is necessary, this should be added after mixing of the two components.

Due to local legislation, the standard hardener may be supplied as either STD or SD versions.

---

## Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- \* Good ventilation (Outdoor exposure or free circulation of air)
- \* Typical film thickness
- \* One coat on top of inert substrate

### Std Comp. B

Substrate temperature	10°C	23°C	40°C
Surface dry	8 h	4 h	2 h
Through dry	24 h	10 h	4 h
Cured	14 d	7 d	2 d
Dry to recoat, minimum	24 h	10 h	4 h
Dry to recoat, maximum <sup>1</sup>			

### WG Comp. B

Substrate temperature	-5°C	0°C	5°C	10°C	23°C
Surface dry	24 h	18 h	12 h	6 h	2,5 h
Through dry	48 h	26 h	18 h	12 h	5 h
Cured	21 d	14 d	7 d	3 d	2 d
Dry to recoat, minimum	48 h	26 h	18 h	12 h	5 h
Dry to recoat, maximum <sup>1</sup>					

1. Provided the surface is free from chalking and other contamination prior to application, there is normally no overcoating time limit. Best intercoat adhesion occurs, however, when the subsequent coat is applied before preceding coat has cured. If the coating has been exposed to direct sunlight for some time, special attention must be paid to surface cleaning and mattening/removal of the surface layer in order to obtain good adhesion.
2. At temperatures below 15 °C, it is recommended to use WG Comp. B due to potential drops in temperatures during the curing process.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

---

## Typical paint system

Above water

<b>Jotamastic 80</b>	<b>2 x 100 µm</b>	<b>(Dry Film Thickness)</b>
Hardtop AS/XP	1 x 50 µm	(Dry Film Thickness)

Submerged

<b>Jotamastic 80 Aluminium</b>	<b>2 x 150 µm</b>	<b>(Dry Film Thickness)</b>
or		
<b>Jotamastic 80 Aluminium</b>	<b>1 x 200 µm</b>	<b>(Dry Film Thickness)</b>

Jotamastic 80

Safeguard Universal ES 1 x 100 µm  
and antifouling as required

(Dry Film Thickness)

Other systems may be specified, depending on area of use

---

## Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

---

## Handling

Handle with care. Stir well before use.

---

## Packing size

16 litres Comp. A (base) in a 20 litre container and 2.3 litres Jotamastic 80, Std Comp. B (curing agent) in a 3 litre container  
and

16 litres Comp. A (base) in a 20 litre container and 4 litres Jotamastic 80, WG Comp B (curing agent) in a 5 litre container

---

## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

**For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.**

---

### DISCLAIMER

*The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.*

Jotun is a World Wide company with factories, sales offices and stocks in more than 50 countries. For your nearest local Jotun address please contact the nearest regional office or visit our website at [www.jotun.com](http://www.jotun.com)

ISSUED 26 MARCH 2009 BY JOTUN  
THIS DATA SHEET SUPERSEDES THOSE PREVIOUSLY ISSUED