



DENSO® Petrolatum tapes and mastics


For pipes/pipelines

1. Surface treatment



The surface must be free from dust and loose objects. Rust must be removed using a wire brush. Minimum degree of cleanliness (ISO 8501-1) St2.

2. Primer (optional)




Work DENSO® Primer into the surface thoroughly. Apply DENSO® Primer by hand or using a spatula to the surface to be coated.

3. Anti-corrosion tape (pipes & bends)



Wind DENSO® Petrolatum tape around the pipe with the required overlap and with no wrinkles. Then smooth down the DENSO® Petrolatum tape with your hand and press it firmly into position.

4. Mechanical protection



Coat the areas encased in DENSO® Petrolatum-tape with a layer of DEPROTEC®-DRM PP up to the transitional point with the factory-encased surface. Fix the pipe protection mat in the overlap area by applying the heat of a flame and pressing down immediately. For additional mechanical protection, DEPROTEC®-PUR glass fibre bandage can be used.


For armatures/flange connections

1. DENSO® Petrolatum mastics



Apply DENSO® Petrolatum mastics by hand or using a spatula in order to fill hollow spaces. Shape the mastic and then wind DENSO® Petrolatum-tape all the way around.

2. Flange connections & armature housing



Depending on the operating temperature, fill the hollow space from the crack between the flange plates with DENSO®-Jet or DENSO®-Fill.


3. Flange connections & armature housing



Lay DENSO® Petrolatum tape centrally on the flange and shape it over the external circumference, screw heads, nuts etc. Tape width depends on the nominal size: 250, 300 or 400 mm


4. Flange connections & armature housing

Optional: Flanges DN > 400



Position 2 layers of DENSO® Petrolatum tape alternately on the right and left flange edge. The length of the DENSO® Petrolatum tape sections correspond to the external flange circumference plus 50 mm overlap. Cover the pipe surface adjacent to both sides of the flange with DENSO® Petrolatum tape in a sleeve formation or spiral pattern.

5. Mechanical protection



Coat the areas encased in DENSO® Petrolatum-tape with a layer of DEPROTEC®-DRM PP up to the transitional point with the factory-encased surface. Fix the pipe protection mat in the overlap area by applying the heat of a flame and pressing down immediately. For additional mechanical protection, DEPROTEC®-PUR glass fibre bandage can be used.

Processing temperature	Primer	
	Product	DENSO®-AQ Primer HT
Material °C (°F)	DENSO®-AQ DENSO®-Cal	+5 to +50 (+41 to +122)
Surface °C (°F)		-10 to +100 (+14 to +212)

Processing temperature	Tape without lamination film						Tape with lamination film		Mastic			
	Product	DENSO®-Feu	DENSO®-Tape ET	DENSO®-Tape MT ¹	DENSO®-TapeST	DENSO®-Tape HT ³	DENSO®-Tec DENSO®-Verte DENSO®-Tape LT ¹	DENSO®-Cal ²	DENSO®-Flex DENSO®-Plast	DENSO®-PF	DENSO®-Plast	DENSO®-Fill/-Jet (Cartridges)
Material °C (°F)		-10 to +40 (+14 to +104)	+5 to +55 (+41 to +131)	-10 to +50 (+14 to +122)	+5 to +45 (+41 to +113)	+5 to +50 (+41 to +122)	-10 to +30 (+14 to +86)	+5 to +50 (+41 to +122)	-10 to +30 (+14 to +86)	+0 to +30 (+32 to +86)	+4 to +30 (+39,2 to +86)	+40 to +85 (+104 to +185)
Surface °C (°F)		-20 to +50 (-4 to +122)	-10 to +60 (+14 to +140)	-20 to +50 (-4 to +122)	-20 to +40 (-4 to +104)	-10 to +100 (+14 to +212)	-10 to +30 (+14 to +86)	+40 to +110 (+104 to +230)	-10 to +30 (+14 to +86)	+0 to +30 (+32 to +86)	+0 to +30 (+32 to +86)	≥ +5 (≥ +41)

General	
Surface preparation	Use an abrasive cloth #40 in a peripheral direction to roughen adjacent work surfaces and chamfer at an angle of < 30°. Surface cleanliness: min. St2 (ISO 8501-1) dry and free from grease, dust etc.
Health, safety & environmental protection	The installation must take place in accordance with customary and local environmental and safety standards. The safety and environmental notes which accompany DENSO products must be heeded. Personal protective equipment such as safety glasses, safety gloves and fastened work garments must be worn.

- 1) Only for use with DENSO®-AQ Primer
- 2) At low temperatures DENSO®-Cal Primer can be used (surface -10 °C to +50 °C (+14 °F to +122 °F))
- 3) Only for use with DENSO®-AQ Primer HT