



# KEBUTYL- SYSTEM C 50-C

Two-tape system

Corrosion protection system in accordance with DIN EN 12068 and  
DIN 30 672

Load class C, max. operating temperature 50°C

DIN-DVGW-Registration No. NV-5180AU0469



## PRODUCT INFORMATION

### GENERAL

**Kebutyl-System C50-C** is a cold-applied two-tape corrosion protection system. It is used for coating steel pipelines, fittings or welded joints of factory coated pipelines the coatings of which are mentioned by DIN EN 10329, table 2.

**Testo-Tape 1.2 H** (inner layer) is self-amalgamating in the overlap area into a homogenous layer, forming a continuous tubing. High plasticity and sufficient thickness of the material provides a coating free of voids.

**Kebulen-Tape PE 0.5** (outer layer) is constructed asymmetrically. In overlap areas the wrappings melt together with each other as well as with the underlying **Testo-Tape 1.2 H**. Total thickness of the system adds up to approx. 3.4 mm.

**Kebutyl-System C50-C** provides reliable corrosion protection due to its excellent workability and its low permeability to water vapour and oxygen.



### STRUCTURE

#### **Kebutyl-Primer KIII**

Solvent based coupling agent  
Dissolution made of butyl rubber and unsaponifiable resins in organic solvent

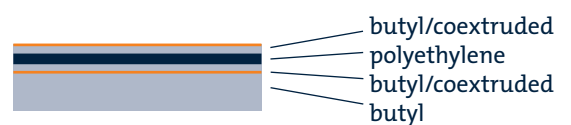
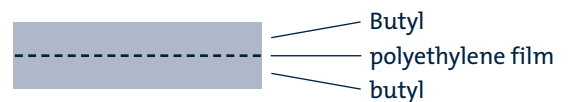
Consumption: approx. 0.2 l/m<sup>2</sup>  
Drying time: approx. 3 – 5 minutes

#### **Testo®-Tape 1.2 H**

Corrosion protection tape based on butyl rubber with polyethylene carrier film

#### **Kebulen-Tape PE 0.50**

Double-sided asymmetrical polyethylene foil coated with butyl rubber





## PACKAGE

| Kebutyl-Primer KIII  | Consumption/m <sup>2</sup> | Package                 |        |
|--|----------------------------|-------------------------|--------|
|  | approx. 0.2 ltr.           | approx. 1 / 5 / 10 ltr. |        |
| Testo®-Tape 1.2 H<br>Thickness: 1.2 mm<br>Butyl rubber tape with foil liner  | Length/roll                | rolls/carton            | width  |
|  | 10 m                       | 9                       | 30 mm  |
|  | 10 m/12.5m                 | 6/12                    | 50 mm  |
|  | 10 m/12.5m                 | 3/6                     | 100 mm |
| Kebulen-Tape PE 0.50<br>Thickness: 0.5 mm<br>black, yellow, blue<br>Double-sided asymmetrical<br>polyethylene foil coated with<br>butyl rubber | Length/roll                | rolls/carton            | width  |
|  | 20 m                       | 9                       | 30 mm  |
|  | 20 m/25m                   | 6/12                    | 50 mm  |
|  | 20 m/25m                   | 3/6                     | 100 mm |

Other lengths and widths upon request.

## APPLICATION

The area to be coated must be dry, if necessary dry the surface by using a propane torch. **Kebutyl-System C50-C** does not require any preheating. Wire-brush the steel substrate thoroughly to remove rust, dirt, residuals of ultrasonic inspection coupling agent as well as temporary end and edge protection.

On steel pipes with a three-layer factory polyethylene coating, the layers of epoxy resin and bonding adhesive on the pipe surface may also be covered by the field coating. To ensure high peel strength roughen the epoxy resin or adhesive using a manual wire brush. Remove any traces of oil and grease using suitable solvent.

When coating bare steel pipes take special care to ensure that no mill scale is present on the pipe surface. Any mill scale must be blasted to Sa 2.5 in accordance with DIN EN ISO 8501-1.

The edges of polyethylene factory coatings are normally bevelled. Take care to ensure that no voids are formed. Where voids may form, as in the case of straight edges, damage and reinforced factory coatings, prepare the edges using suitable tools. Semi-circular rasps have proved to be suitable for this purpose. When working on coating edges take care to prevent damage such as notches and cuts in the factory polyethylene coating.

Clean about 100 mm of the factory coating adjacent to the cutback area and roughen it manually using a wire brush.

Apply **Kebutyl-Primer K III** all over the area to be coated using a paint brush or a paint roller. Drying time takes 3 – 5 minutes, depending on the weather.

Apply **Testo-Tape 1,2 H** beginning and ending with a full circumferential wrap on about 50 mm of the factory coating. Proceed with 50 % overlapping, ensuring to work crease-free.

When coating pipelines with diameters > DN 900 the thrust forces that can be achieved are low. To ensure that butyl rubber moves into those areas likely to build voids apply a three-ply tape of max. 50 mm cylindrically with high tensile strength (overstretching the tape) before wrapping **Kebulen-Tape PE 0.5**.

Apply **Kebulen-Tape PE 0.5** like the first layer, beginning and ending with a full circumferential wrap and proceeding spirally with 50 % overlapping. The tape must completely cover the **Testo-Tape** applied before. An overlap of 25 mm is recommended.



## CONSUMPTION TABLE

The table is valid for coating a field joint with a steel surface of 300 mm and 50 mm of a adjacent factory coating on both ends (inner layer). The outer layer overlaps the inner layer by 25 mm on both ends.

| DN   | Diameter<br>Ø | Kebutyl<br>Primer K III | Testo®-Tape 1.2 H<br>50% overlapping<br>width |                     | Kebulen-Tape PE 0.50<br>50% overlapping<br>width |                     |
|------|---------------|-------------------------|---|---------------------|--|---------------------|
| 200  | 219.1 mm      | 0.062ltr.               | 100 mm  | 0.55 m <sup>2</sup> | 100 mm   | 0.62 m <sup>2</sup> |
| 250  | 273.0 mm      | 0.077 ltr.              | 100 mm  | 0.69 m <sup>2</sup> | 100 mm   | 0.77 m <sup>2</sup> |
| 300  | 323.9 mm      | 0.092ltr.               | 100 mm  | 0.81 m <sup>2</sup> | 100 mm   | 0.92 m <sup>2</sup> |
| 350  | 355.6 mm      | 0.100 ltr.              | 100 mm  | 0.90 m <sup>2</sup> | 100 mm   | 1.00 m <sup>2</sup> |
| 400  | 406.4 mm      | 0.115 ltr.              | 100 mm  | 1.02 m <sup>2</sup> | 100 mm   | 1.15 m <sup>2</sup> |
|      | 419.0 mm      | 0.118 ltr.              | 100 mm  | 1.05 m <sup>2</sup> | 100 mm   | 1.19 m <sup>2</sup> |
| 500  | 508.0 mm      | 0.144 ltr.              | 100 mm  | 1.28 m <sup>2</sup> | 100 mm   | 1.44 m <sup>2</sup> |
|      | 521.0 mm      | 0.147 ltr.              | 100 mm  | 1.31 m <sup>2</sup> | 100 mm   | 1.47 m <sup>2</sup> |
| 600  | 609.6 mm      | 0.172 ltr.              | 100 mm  | 1.53 m <sup>2</sup> | 100 mm   | 1.73 m <sup>2</sup> |
| 700  | 711.2 mm      | 0.201 ltr.              | 100 mm  | 1.79 m <sup>2</sup> | 100 mm   | 2.01 m <sup>2</sup> |
| 800  | 812.8 mm      | 0.230 ltr.              | 100 mm  | 2.05 m <sup>2</sup> | 100 mm   | 2.30 m <sup>2</sup> |
| 900  | 914.4 mm      | 0.258 ltr.              | 100 mm  | 2.30 m <sup>2</sup> | 100 mm   | 2.59 m <sup>2</sup> |
| 1000 | 1016.0 mm     | 0.287 ltr.              | 100 mm  | 2.56 m <sup>2</sup> | 100 mm   | 2.87 m <sup>2</sup> |

All quantities are based on abstract calculations.

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