

**3M** Science.  
Applied to Life.™

For U.S. Distribution Only

3M™ Scotchkote™ Coatings Guide

# Delivering Energy with Advanced Corrosion Control





# 3M™ Scotchkote™ Coatings: Celebrating Over 65 Years of Pipeline Integrity

Since 1960, 3M has achieved an international reputation in the field of high performance corrosion protection coatings with fusion bonded epoxy and liquid epoxy. Focusing on the challenges facing today and tomorrow's infrastructure owners, engineers and contractors, 3M delivers innovative and cost-effective coating solutions for a diversity of operating environments for the following applications:

- Fusion-Bonded Epoxy Pipeline Coatings
- Liquid Epoxy Pipeline Coatings

For more information, visit [www.3M.com/corrosion](http://www.3M.com/corrosion).



## 3M™ Scotchkote™ Fusion-Bonded Epoxy and Liquid Epoxy

Fusion-bonded epoxies are thermosetting materials with low oxygen permeability, providing an effective barrier to corrosion. These products are heat-cured, creating a tightly crosslinked epoxy network that protects the pipe from damage during storage, transit, construction, backfilling, and service. More advanced dual-layer coating systems provide protection during horizontal directional drilling.

Liquid epoxy coatings do not require extra heat to achieve cure. On-site field application is simplified because only cleaning and application equipment are needed. Applicators should be able to achieve a high build in a single application.

3M™ Scotchkote™ Fusion-Bonded Epoxy Coatings	Description
<b>External Coatings</b>	
6233P	A stand-alone fusion-bonded epoxy coating, featuring 3M’s advanced adhesion technology and color stability. Offering long-term performance when applied correctly, this coating helps you to ensure your pipeline remains protected and reliable over time. Color: Dark Green
6233	A stand-alone fusion-bonded epoxy coating, featuring excellent adhesion and durability. Offering long-term performance when applied correctly, this coating helps you to ensure your pipeline remains protected and reliable over time. Color: Green
226N	The advanced adhesion properties make this coating a good choice for pipeline protection applications. Used as stand-alone or primer coating for multi-layer systems, providing corrosion protection for coated pipes. Color: Blue-Green
226N+	This coating helps provide exceptional adhesion and damage resistance while also providing a cost-effective alternative to standard coatings. Used as stand-alone or primer coating for multi-layer systems, providing corrosion protection for coated pipes. Color: Blue-Green
<b>High Temperature Coatings</b>	
626-120	A high temperature corrosion coating for a multi-layer system for the corrosion protection of pipe. Operating temperature of < 115°C. Color: Green
626-140	A high temperature corrosion coating for a multi-layer system for the corrosion protection of pipe. Operating temperature of < 135°C. Color: Green
<b>Abrasion-Resistant Overcoats</b>	
6352HF	An abrasion resistant overcoat (ARO) with enhanced flexibility, maintaining excellent impact strength and gouge resistance. This hard, mechanically robust top coating offers maximum damage protection. Color: Brown
6352	An abrasion resistant overcoat (ARO) with great impact strength and gouge resistance. This hard, mechanically robust top coating offers maximum damage protection. Color: Brown
328	A liquid epoxy ARO coating with improved flexibility, offering increased adhesion and enhanced gouge and impact resistance. Ideal over FBE or as a stand-alone damage-resistant liquid for situations where long-term adhesion is critical, as well as for horizontal directional drilling (HDD) and other damage-prone applications. Color: Blue-Green
207R	Serves as a rough overcoat to create a textured finish on all 3M™ Scotchkote™ Fusion-Bonded Epoxy Coatings, providing increased surface roughness for applications such as concrete weighting. Color: Blue-Green

**Disclaimer:** Performance of 3M™ Scotchkote™ Coatings is dependent on proper application. Please follow 3M application guides for each corresponding product.

*(continued on next page)*

3M™ Scotchkote™ Fusion-Bonded Epoxy Coatings		Description
<b>Custom Coatings</b>		
134	A stand-alone, chemical-resistant coating that provides exceptional corrosion protection for metal substrates, including valves, pumps, pipe drains, pipes, hydrants, and porous castings. It offers robust resistance to wastewater, corrosive soils, hydrocarbons, harsh chemicals, and sea water. Color: Forest Green. ANSI/NSF61 	
135	Used for corrosion protection of metal substrates such as valves, pumps, pipe drains, hydrants and porous castings. Resistant to wastewater, corrosive soils, hydrocarbons, harsh chemicals, and sea water. Listed on the QPL for MIL 23236-D. Color: Gray	
6233W	A one-part, heat curable, thermosetting epoxy coating powder for corrosion protection of drinking water pipes, valves, fittings, and couplers. 	
206N	This epoxy has extended gel time for various custom coating applications on pipelines, valves, fittings and couplers. Versions include standard, long gel, extra long gel and fluid bed grades while providing good chemical resistance. NSF 61 approved for contact with potable water. Color: Blue-Green 	

**Disclaimer:** Performance of 3M™ Scotchkote™ Coatings is dependent on proper application. Please follow 3M application guides for each corresponding product.

3M™ Scotchkote™ Liquid Coatings – External & Internal		Description
323+	3M’s leading liquid epoxy coating provides good adhesion, flexibility and impact resistance and has now been reformulated so that nonylphenol is no longer intentionally added. Color: Blue-Green	
328	3M’s premier liquid epoxy coating, suitable for direct application to steel, serves as an excellent topcoat over FBE for HDD applications. This product offers excellent adhesion and flexibility, making it ideal for scenarios where long-term adhesion is crucial and perfect surface preparation is not feasible. Color: Blue-Green	
327	A faster gelling liquid epoxy coating with excellent adhesion and durability. For adhesion to steel in brush or plural applications and can be used for faster setup on your repairs. Color: Green	

**Disclaimer:** Performance of 3M™ Scotchkote™ Coatings is dependent on proper application. Please follow 3M application guides for each corresponding product.

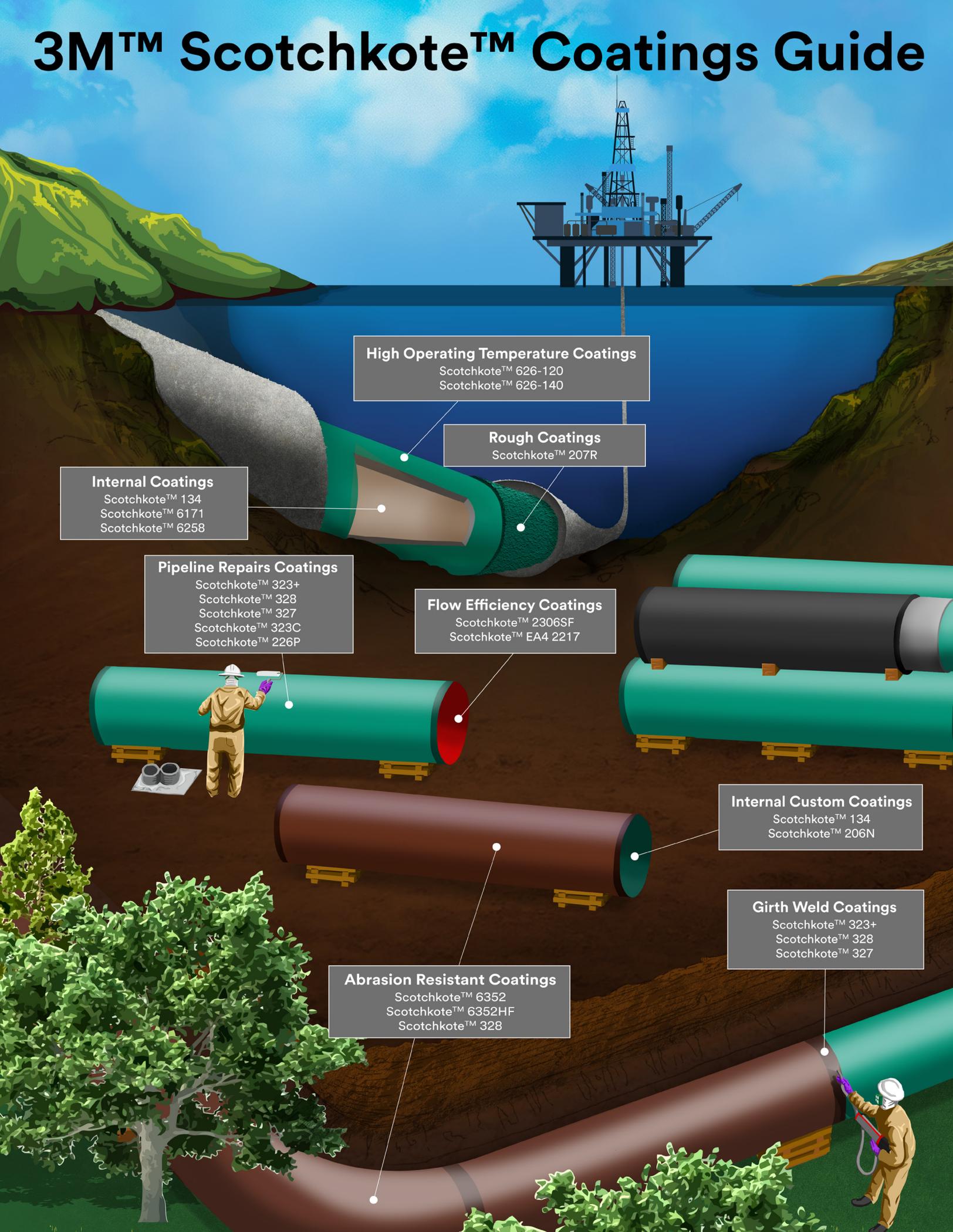
3M™ Scotchkote™ Internal Fusion-Bonded Epoxy Coatings	Description
6171	For interior corrosion protection of production tubing, line pipe, and fittings. Can withstand extreme pressures and corrosive environments. Color: Beige
6258	A coating for downhole internal tube applications offering excellent adhesion with higher temperatures and pressures in corrosive environments. Color: Green
206N	A longer gel-time coating for the interior of line pipe and fittings, valves, and couplers. NSF 61 approved for contact with potable water. Color: Blue-Green 
Flow Efficiency Coatings	
2306SF	Composed of 100% solids, this product is specifically developed as an internal lining for gas pipelines to maximize flow efficiency in oil and gas pipelines. Color: Red
EA4 2217	For the internal lining of tanks and pipelines holding and transporting aviation fuel and other refined petroleum products. Color: Red Oxide and Gray

**Disclaimer:** Performance of 3M™ Scotchkote™ Coatings is dependent on proper application. Please follow 3M application guides for each corresponding product.

3M™ Scotchkote™ Repair Coatings – Pipe & Rebar	Description
323+	3M’s leading liquid epoxy coating provides good adhesion, flexibility and impact resistance and has now been reformulated so that nonylphenol is no longer intentionally added. Color: Green (color match to Scotchkote Coating 6233)
328	For use as a repair and/or girth-weld coating on dual layer FBE systems that would be used for HDD applications. Color: Blue-Green
323C	Two-part epoxy system for use as a color match and patch material for 3M™ Scotchkote™ Fusion-Bonded Epoxy Coating 134. Color: Green
226P	Heat bondable polymeric coating in stick form for minor pinhole repair of 3M FBE coatings. Color: Green (color match to 3M™ Scotchkote™ Fusion-Bonded Epoxy Coatings 226N and 6233)
323R	Two-part repair cartridge system for repairs on ASTM 775 specification rebar products. Color: Green
323 Purple	Two-part repair cartridge system for repairs on ASTM 934 specification rebar products. Color: Purple

**Disclaimer:** Performance of 3M™ Scotchkote™ Coatings is dependent on proper application. Please follow 3M application guides for each corresponding product.

# 3M™ Scotchkote™ Coatings Guide



## High Operating Temperature Coatings

Scotchkote™ 626-120  
Scotchkote™ 626-140

## Rough Coatings

Scotchkote™ 207R

## Internal Coatings

Scotchkote™ 134  
Scotchkote™ 6171  
Scotchkote™ 6258

## Pipeline Repairs Coatings

Scotchkote™ 323+  
Scotchkote™ 328  
Scotchkote™ 327  
Scotchkote™ 323C  
Scotchkote™ 226P

## Flow Efficiency Coatings

Scotchkote™ 2306SF  
Scotchkote™ EA4 2217

## Internal Custom Coatings

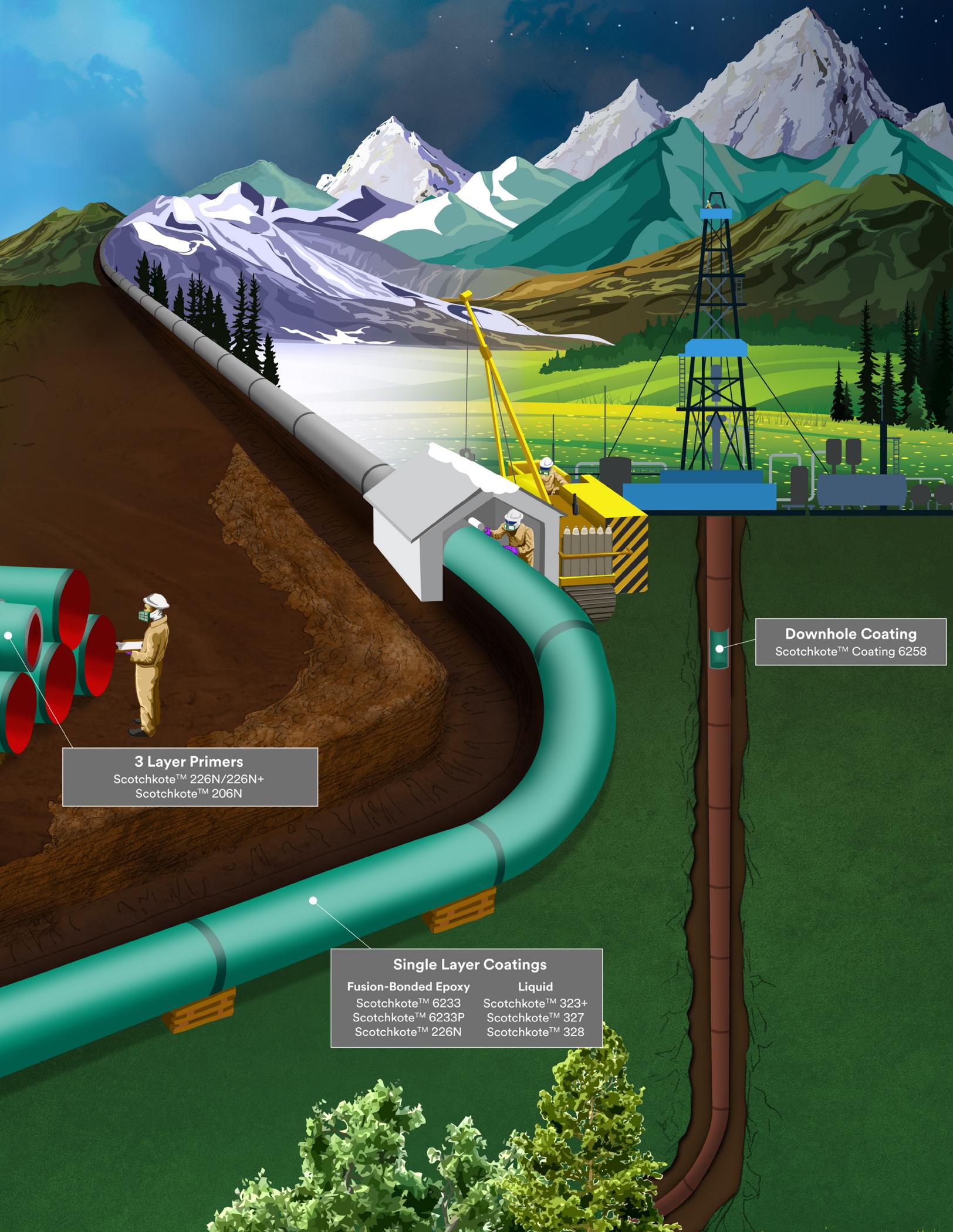
Scotchkote™ 134  
Scotchkote™ 206N

## Girth Weld Coatings

Scotchkote™ 323+  
Scotchkote™ 328  
Scotchkote™ 327

## Abrasion Resistant Coatings

Scotchkote™ 6352  
Scotchkote™ 6352HF  
Scotchkote™ 328



**3 Layer Primers**  
Scotchkote™ 226N/226N+  
Scotchkote™ 206N

**Single Layer Coatings**

Fusion-Bonded Epoxy	Liquid
Scotchkote™ 6233	Scotchkote™ 323+
Scotchkote™ 6233P	Scotchkote™ 327
Scotchkote™ 226N	Scotchkote™ 328

**Downhole Coating**  
Scotchkote™ Coating 6258

**Important Notice**

Before using this product, you must evaluate it and determine if it is suitable for your intended application. You assume all risks and liability associated with such use.

**Warranty, Limited Remedy, and Disclaimer:** Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement or repair of the 3M product or refund of the purchase price. Warranty claims must be made within one (1) year from the date of 3M's shipment.



**Electrical Markets Division**  
13011 McCallen Pass, Bldg. C  
Austin, TX 78753 USA

Phone 1-800-722-6721  
Fax 1-877-601-1305  
Web [3M.com/corrosion](http://3M.com/corrosion)

80-6016-0853-4  
Please recycle. Printed in USA.  
Copyright © 2025, 3M. All rights reserved.  
3M, 3M Science. Applied to Life., and Scotchkote  
are trademarks of 3M Company.