



Nap-Gard®

FIELD GIRTH WELD (F.B.E.) COATING NAP-ROCK DUAL POWDER SYSTEM APPLICATION PROCEDURES

Revised: 17 September 2013

1. Remove any weld splatter, grease and residual tape from cutback area (prior to blast). Blast clean the weld surface using sand or grit of appropriate size to produce an angular profile of 2.5 to 4 mils (63µm to 110µm).

The blasting procedure must insure at least 0.5 inches feathering to the parent coating on each side of the weld.

The profile should be verified by one of the industry recognized test methods (such as Press-O-Film or Profile-O-Meter).
2. The cleaned surface shall be a minimum SA 2½ cleanliness.
3. The blasted surface shall be further cleaned with pressurized dry air to remove all loose coatings and dust from the cut back area where coating is to be applied.
4. Heat the area (preferably using an induction coil heating system) to raise the surface temperature above 475°F using a heat-up rate, not to blister the parent coating. Verify the surface temperature using proper method. Care should be taken not to contaminate the surface while taking temperature measurements.
5. Spray apply the fusion bonded epoxy base coat (Nap-Gard® 7-2500, 7-2501, 7-2514EN series, 7-2508STD/LG) to the surface. Ensure to cover the entire surface with FBE powder when it is at or above 450°F temperature. After achieving a minimum coating thickness of 10 mils, apply the top coat 7-2610 or 7-2617, a minimum thickness of 20 mils. For details refer to the application procedure of the DPS. The top coat should be applied before the gel time of the base coat has expired. For application details refer to the application procedures of Nap-Gard® Dual Powder Systems.
6. No reclaim shall be used.

Note:

If blistering occurs, reduce generator amperage output thereby extending the heat-up time.

QUALITY CONTROL TESTS

1. Following return of the applied coating to ambient temperature, take a sample to test for cure using DSC analysis. For details refer to the application procedure of Nap-Gard® Dual Powder systems.
2. After allowing sufficient time for the substrate to cool, adhesion test shall be conducted to ensure proper adhesion of the coating.

Other test may include, Dry Film Thickness and Holidays. Appropriate test must be used. For details refer to the Application procedure of Nap-Gard® Dual Powder systems.



Note: Recommend that an application procedure should be developed based on the customer's specification with these guidelines. A trial should be conducted using this procedure to verify the quality of the applied coatings. This procedure would be used during the entire project. Any further deviations shall be reviewed and approved by the engineer.

Always consult product Material Safety Data (MSDS) prior to handling.

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