



Nap-Gard®

COATING APPLICATION PROCEDURE FIELD GIRTH WELD NAP-GARD GOLD

Revised: 17 September 2013

1. Blast clean the weld surface using sand or grit of appropriate size to produce an angular profile of 2 mils (50µm) to 4.5 mils (112µm). The blasting procedure must insure at least 0.5" feathering to the parent coating on each side of the weld. The profile should be verified by one of the industry recognized test methods.
2. The cleaned surface shall be of minimum SA 2½ cleanliness.
3. The blasted surface shall be further cleaned with a stream of pressurized dry air and a bristle brush to remove all loose coatings and dust from the cut back area where coating is to be applied.
4. Heat the area using an induction coil heating system to raise the surface temperature above 475° F using a heat-up rate that does not blister the parent coating*. Verify the surface temperature. Tempstiks® or surface contact pyrometers are acceptable methods. 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. Apply the FBE powder when the surface temperature is at or above 450°F temperature. After achieving a minimum coating thickness of 10 mils, apply the top coat 7-2504 or 7-2504LG, to a minimum thickness of 20 mils. For details refer to the application procedure of the TM. 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 to be used.

NOTE:

In most cases, the residual heat on the substrate is sufficient to cure the FBE. However, for thin wall pipe and fittings additional heat may be required. Post curing two (2) minutes at or above 425° F is sufficient to cure the coating.

- If blistering occurs, reduce generator amperage and extend the heat-up time.

Refer to NACE RP0402-2002 for additional helpful details.

QUALITY CONTROL TESTS

1. Take a sample to test for cure using DSC analysis. If this is not practical, other cure tests are to be employed to ensure cure of the FBE coating.
2. After allowing sufficient time for the substrate to cool, adhesion test shall be conducted to ensure proper adhesion of the coating.

Other tests include, Dry Film Thickness, Holiday Testing and Visual Defects.

NOTE:

We recommend that an application procedure 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 coating. This procedure should be used during the entire project. Any further deviations shall be reviewed and approved by the Project Engineer.

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

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