

Lining and Coating Specifications

Fusion Bonded Epoxy

- Material:** The lining and coating material shall be 100% solids, thermosetting, fusion bonded, dry powder epoxy such as PipeClad 1500 / 701R-FB, red in color, as manufactured by Valspar (formerly Lilly Industries,
- Surface Preparation:** All sharp edges and corners, and other surface irregularities, are to be removed and the fitting is to be abrasive blast cleaned in accordance
- Application:** The epoxy powder shall be applied by the fluidized bed method with a finished dry film thickness of not less than 6 mils (the pipe penetration and gasket areas of the bells may be less than 6 mils in order to facilitate assembly of the pipe joint). Fittings shall be heated and cured in accordance with powder manufacturer's specifications.
- Inspection:** All fittings shall be holiday tested in accordance with ASTM D 5162-01 "Standard Practice for Discontinuity (Holiday) Testing of Nonconductive Protective Coating on Metallic Substrates", NACE RP0188-99, and SSPC Vol. 1, Para. XIV, with a low voltage, wet sponge holiday detector. Holidays will be marked and repaired with 920C970 / 920R970 red liquid epoxy touch-up as manufactured by

Field Damage Repair

- Material:** Damaged areas are to be repaired with 920C970 / 920 R 970 red liquid epoxy touch-up as manufactured by Valspar or approved equal.
- Procedure:** Small nicks or chips in the lining and/or coating caused by field handling and installation can be repaired by removing all oils, grease oxidation or other contaminants using a suitable solvent prior to the application of the liquid epoxy touch-up. If rust is apparent in the damaged area, the rust should be removed by wire brushing or sanding. If the damaged area is extensive, the area should be abrasive blast cleaned or abraded prior to the application of the liquid epoxy touch-up. If the damaged area is larger than 36 square inches, the fitting should be returned to the coating applicator for complete

