

***Anti-corrosion protection of flange joints  
and steel pipes using the ANTICOR Plast system***

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## 1. Purpose of the manual

The technology consists in anti-corrosion protection of flange joints and steel pipes using the ANTICOR Plast system in A30 class.

## 2. Reference documents

Company standards.

## 3. Equipment (essential)

- sandpaper, cleaning cloths,
- protective clothing,
- auxiliary consumables.

## 4. Protection measures

- safety goggles,
- protective gloves,
- standard moisturising skin creams.

## 5. Operations of technological process

### 5.1 Surface preparation

**Remove dust and soil from the surface to be protected and degrease it using oil-free solvent (for example petroleum ether).**

Steel surfaces should be cleaned to the cleanliness degree of Sa 2½ (Sa 3 degree is acceptable) in accordance with PN-EN ISO 8501.

### 5.2 Application of ANTICOR Plast

Apply the ANTICOR Plast 701-40 tape with the anti-corrosion layer of the plastic mass facing the protected surface (figure no.1).



apply plastic mass facing the protected surface

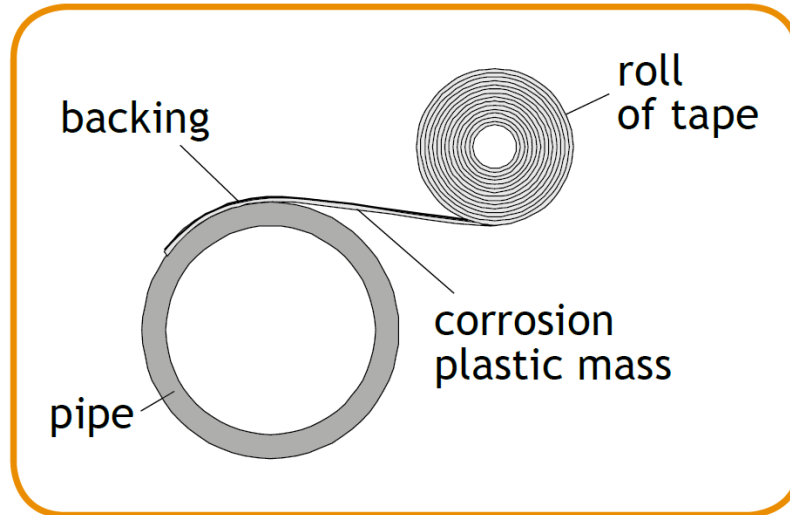


Figure 1. Diagram of ANTICOR Plast 701-40 tape application

## 5.2.1 Protection of flange joints

1. Apply the ANTICOR Plast 745 anti-corrosion plastic mass to the surface of the flange joint covering the heads and nuts of the bolts in excess so that no air pockets occur while wrapping the tape. Also, apply the mass into the space between the flanges.
2. Spiral the ANTICOR Plast 701-40 tape around under slight pre-tension, **with the plastic mass facing the protected surface**, double wrap with 50% overlap, covering around 5 cm of the existing insulation with the first winding and approx. 10 cm with the second one (see figure 2).
3. Smooth the surface of the applied coating with your hand applying pressure to it in order to make the coating fit the possible unevenness of the protected element.
4. Wrap the ANTICOR Plast 732-08 tape under tension, with 50% overlap, around the entire surface of the coating that was previously formed with the ANTICOR Plast 701-40 tape. Tension of the tape should ensure its adhesion to the previously applied coating without wrinkles and air pockets (see figure 2).

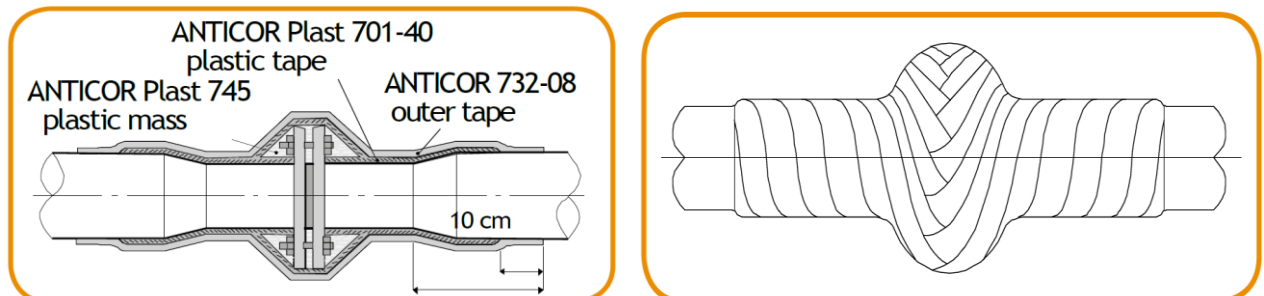


Figure 2. Flange connection diagram.

## 5.2.2 Protection of steel pipes

1. Spiral the ANTICOR Plast 701-40 tape around under slight pre-tension, **with the plastic mass facing the protected surface**, double wrap with 50% overlap, covering around 5 cm of the existing insulation with the first winding and approx. 10 cm with the second one (see Figure 3).
2. Smooth the surface of the applied coating with your hand applying pressure to it in order to make the coating fit the possible unevenness of the protected element.
3. Wrap the ANTICOR Plast 732-08 tape under tension, with 50% overlap, around the entire surface of the coating that was previously formed with the ANTICOR Plast 701-40 tape. Tension of the tape should ensure its adhesion to the previously applied coating without wrinkles and air pockets (see Figure 3).

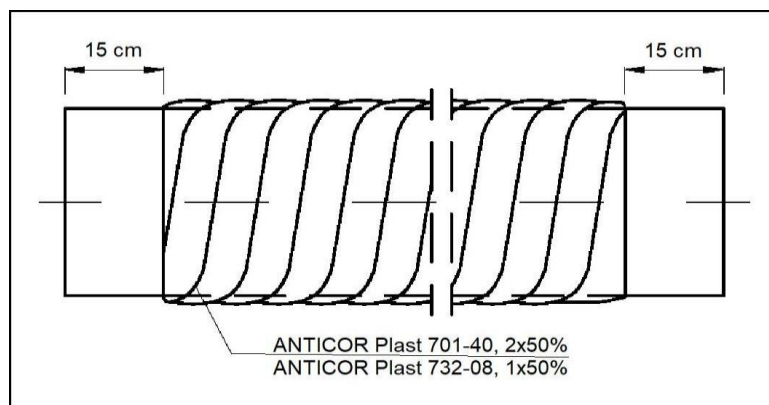


Figure 3. Steel pipe diagram

### Notes :

- Application conditions: ambient temperature:  $-5\pm 30^{\circ}\text{C}$ .
- Insulating materials should be conditioned at the temperature  $10\pm 25^{\circ}\text{C}$  before application.

## 5.3 Acceptance of coating

Tightness of the ANTICOR Plast coating should be verified using a spark holiday detector. Test voltage 15 kV, in accordance with the PN12068 standard.

**Health and safety rules should be followed while operating the holiday detector.**