

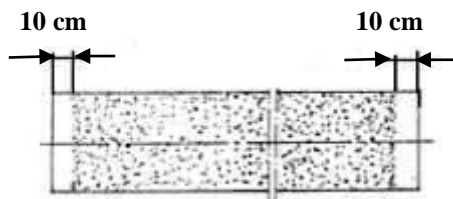
ANTICORWrap

MONOTAPE – ANTICORWrap 755-20 COATING TECHNOLOGY

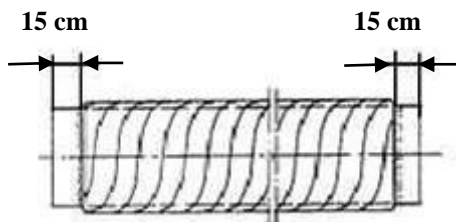
C O R R O S I O N P R O T E C T I O N

APPLICATION PROCESS

Primer application



Tape application



COMPONENTS OF THE SYSTEM:



1. Preparation of steel surfaces:
Remove rust, welding contaminations, dust, oil, grease, water and other contaminants from the pipe surface. It is recommended to prepare the surface to achieve the Sa 2½ standard of cleanliness according to ISO 8501. Remove remainders of abrasive materials and dust caused by abrasive blasting. Use a fat-free solvent to degrease the surface (isopropyl alcohol, extraction naphtha, etc.) **Caution! These are flammable materials!** To remove eventual surface-moisture, the surface may be slightly heated up with a burner or a blowpipe flame – keep in mind, during the primer application, the surface temperature should not exceed 40°C. In exceptional circumstances, surface may be prepared to the St 3 standard with the use of special powered rotating brushes.
2. Preparation of existing factory-coatings:
Clean the existing coating, roughen the surface by using abrasive cloths (grit 40) and degrease at a length of ca. 20 cm beyond its edges. Remove any remainders of abrasive materials! If the edges of the adjacent insulation are not bevelled, prepare 15° bevels or smooth the edges using ANTICOR MASTIC, after primer application.
3. Application of ANTICORWrap Primer 727:
Apply the primer on the surface, including the cleaned areas of existing insulation. The temperature of the surface should be at least 3°C higher than the dew point. Wait until the primer layer reaches the dust dryness condition (simple touch test: The layer is viscous but no soil sticks to your fingers). The time required to reach the condition depends on the temperature and ambient humidity. Use always primers and tapes supplied by the same vendor.
4. If the surface of the weld protrudes excessively, level the surface using ANTICOR MASTIC (after primer application).
5. Complete a 4-layers anticorrosion coating by wrapping the tape ANTICORWrap 755-20 2x spirally (manually or using a wrapping tool) with an overlap 50%, so as to cover the existing coating at sections of ca. 10 cm. Note: The width of tape overlap should be at least 20 mm.
6. Apply the tape with some initial tension. At a correct tension value, the width of the tape is reduced by about 1–2%. Control tape tension! The temperature of the tape during its application may not be lower than +5°C. At low outdoor temperatures store the tape in a heated room. A higher strength is needed to stretch the tape at low temperatures.
7. Check the tightness of the completed coating using a spark flaw detector. Touch the coating surface with the test electrode. Test voltage is 5kV per 1 mm of coating thickness but not more than 15kV according to EN12068.

Strictly follow the rules for spark flow detector operations!

