

PROCEDURES

COATING / WRAPPING

6.0 PURPOSE

It is the purpose of this section to provide minimum requirements and information on the equipment, material and methods utilized for protective coatings and field wrapping of steel and other metallic pipe and fittings.

Each segment of metallic pipe, new or replacement shall have a protective coating.

6.1 SCOPE

This section covers the following:

- A. Field Wrapping Steel Pipe
- B. Shrink Sleeve
- C. Protective Coating of Valves and Irregular Fittings
- D. Painting

6.2 FIELD WRAPPING

The cleaning and application of plastic tape for use in the gas piping system is essential for corrosion protection.

The following products are acceptable for field-installed:

- A. For pipe and transition fittings, Polyken 1027 primer and 930 cold tape or approved equivalent products may be utilized.
- B. For weld joints the application, appropriate sized and thickness, of heat shrink sleeve may applied.
- C. For irregular shaped fittings and valves, Trenton Temcoat grease and Trenton polyply wrap or approved equivalent products may be utilized.

Each product shall be applied in accordance with the manufacturer's instructions.

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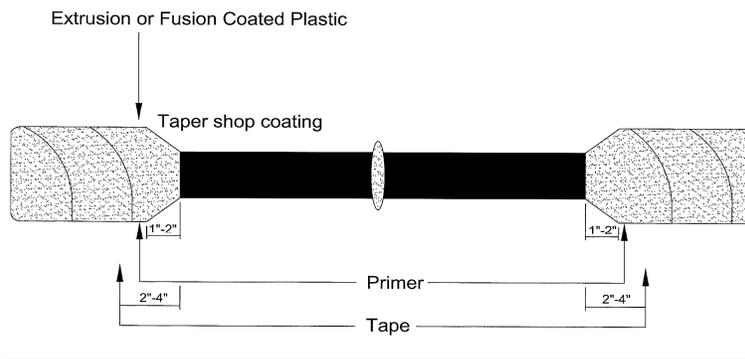
6.3 PLASTIC TAPE METHOD

- A. A holiday will be considered sufficiently cleaned if:
1. All loose coating has been removed.
 2. The edges of shop coating are tapered.
 3. Exposed metal area has approximate diameter of not less than 1/2" on any size pipe.
 4. The exposed area and immediate surroundings shall be cleaned of dirt, loose coating loose rust.
- B. All steel surfaces to which plastic tape is to be applied shall be clean and free of sharp points or foreign substances so that coating will adhere and not be damaged.
- C. Primer must be thoroughly mixed before applying to steel surfaces.
- D. Tape shall be applied to the primed surface when the primer is tacky to touch. The wrapping shall be in spiral with an overlap equal to 1/2 the width of the tape, extending 2" to 4" beyond bare metal or within 1" of a stopcock on a riser.

The following figures give the requirements for wrapping joints, damaged factory wrap, bends or prefab risers.

FIGURE 1

Extrusion and Fusion-Type Coatings

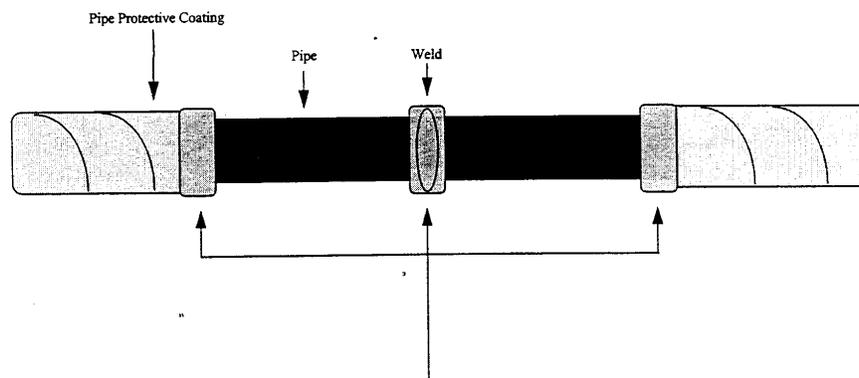


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NOTE: When field wrapping a transition to PE, neither primer nor tape should be applied within 1/4" of the PE. Electrical tape should be applied to the remainder of the fitting. All transition fittings after welding will have the entire steel portion wrapped.

FIGURE 2



Wrap tape on end of pipe coating and on weld, making at least 1 1/4 turns, keeping tape under tension, and then 1/2 turn with no tension on tape. This coating of tape will minimize effect of rough edges.

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FIGURE 3

Installation on Damaged Factory Wrap

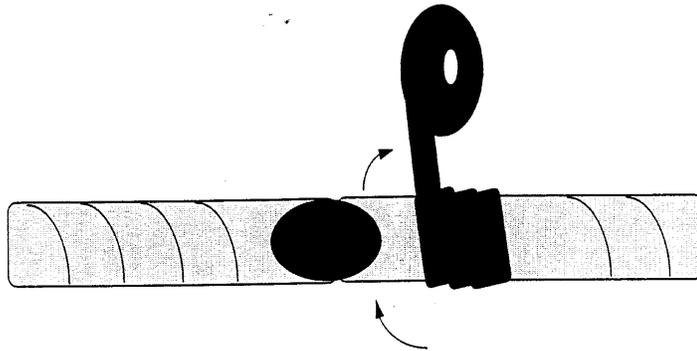
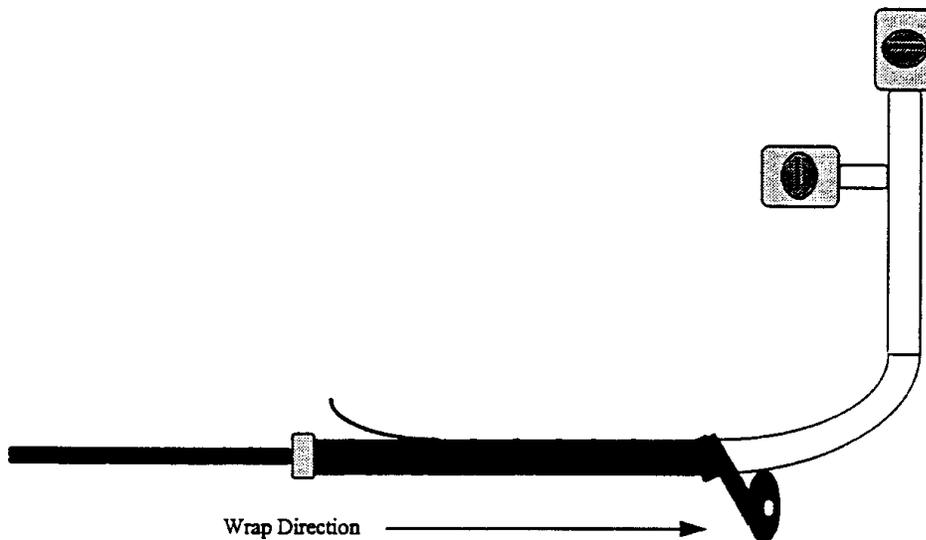


FIGURE 4

Installation on Shopbuilt Rise or Bends



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6.4 VALVES AND OTHER IRREGULAR SHAPED FITTINGS

- A. Wax Tape:
1. Prepare surface to be coated by cleaning with wire brush and wiping clean so that it is free from loose coating, rust, scale and other foreign matter. Surface should be wiped as dry as possible.
 2. Apply wax tape primer to surface by brush or hand (gloved). Only a thin film of primer is necessary and no cure time is required.
 3. If fill putty is necessary, apply directly by hand working the putty material onto the metal surface insuring that the putty is “wetting” and adhering to the surface. Apply the putty material in and around the voids contours and crevices to build up an even surface.
 4. Apply Trenton #1 Wax Wrap, or other engineers approved equal material, allowing for at least a 1” overlap. The wax wrap should overlap at 3” to 6” over any existing coating.
 5. Visually inspect tape application for deficiencies such as overlap voids and air pockets. If present, correct by manually smoothing out seams and air pockets.
 6. Backfill may take place immediately after application. No drying or cure time is required.
- B. Grease Wrap:
1. Prepare surface to be coated by cleaning with wire brush and wiping clean so that it is free from loose coating, rust, scale and other foreign matter. Surface should be wiped as dry as possible.
 2. Coat pipe and fitting with grease.
 3. Apply polyply wrap around entire surface coated with grease.
 4. Use sufficient electrical tape to secure polyply wrap.
 5. Visually inspect tape application for deficiencies such as voids and air pockets. If present, correct by manually smoothing out seams and air pockets.
 6. Backfill may take place immediately after application. No drying or cure time is required.

6.5 PAINTING

- A. Store paint in cool dry place in manufactures container only.
- B. Do not use after expiration date.

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- C. Prepare surface by removing excess rust, scale, dirt, oil soap and other contaminants.
- D. Use 120 grit sandpaper and/or wire brush.
- E. Clean and dry.
- F. Primer and Paint Application:
 - 1. Touch up factory paint only (Do Not paint entire surface)
 - 2. Paint bare metal and rusted areas
 - 3. Apply two layers of primer ensuring each is dry / tack free
 - 4. Apply two layers of approved paint
 - 5. Finish coat should be uniform
 - 6. Prevent overspray
 - 7. Do not paint index glass, gauges, instruments, etc...
 - 8. Approved primer – Rustoleum red (model V2169838) or gray (model V2182838)
 - 9. Approved paint – Rustoleum dark machinery gray (model V2187838) for meter set assemblies. Rustoleum tan (model V2171838) for regulator stations.
- G. When painting in enclosed spaces always check and eliminate possible ignition sources, leave doors and windows open and ensure adequate ventilation.