

MASTIC COATING FOR WELD-NECK FLANGES AND UNCOATED IRREGULAR SURFACES

1.0 SCOPE OF WORK

1.1 THIS SPECIFICATION IS USED IN CONJUNCTION WITH BARE STEEL AND FACTORY COATED PIPE, SUCH AS, BUT NOT LIMITED TO: TAPE, COAL TAR ENAMEL, EXTRUDED POLYETHYLENE, OR FUSION BONDED EPOXY. THE MATERIAL IS USED IN THE FOLLOWING AREAS:

- A> BENDS, ELBOWS, TEES
- B> FIELD FABRICATED PIPE WITH FLANGES, VALVES, DRESSER COUPLINGS.
- C> COMPRESSOR AND PUMP STATION PIPING
- D> PATCHING OF FACTORY APPLIED COATINGS
- E> RECONDITIONING OF INSTALLED PIPELINES

2.0 REFERENCES

2.1 THIS WORK SHALL COMPLY WITH THE APPLICABLE PROVISIONS OF THE FOLLOWING:

2.1.1 STEEL STRUCTURES PAINTING COUNCIL (SSPC)

- A> SP-1 SOLVENT CLEANING
- B> SP-2 HAND TOOL CLEANING
- C> SP-3 POWER TOOL CLEANING

2.1.2 OPTIONAL

- A> SP-6 COMMERCIAL BLAST CLEANING

3.0 MATERIALS

3.1 TC MASTIC - BRUSH APPLIED

3.2 TAPECOAT MASTIC SHIELD

4.0 SURFACE PREPARATION

4.1 ALL BARE STEEL SHALL BE FREE OF DUST, DIRT, GREASE, OIL AND OTHER FOREIGN MATTER. PRACTICAL REMOVAL CAN BE DONE BY EITHER POWER OR HAND WIRE BRUSHING. GREASE AND OIL CAN BE REMOVED BY USE OF A SOLVENT THAT LEAVES NO OILY OR DUSTY FILM REMAINING ON THE STEEL SURFACE.

4.2 WELDS AREAS SHALL BE CLEANED OF ALL WELDING SLAG, SPLATTER, AND SCALE. SHARP EDGES OR BURRS SHALL BE REMOVED BY GRINDING OR FILING.

4.3 THE WELD AREAS SHALL BE NO MORE THAN "WARM TO THE TOUCH" BEFORE APPLYING TC MASTIC.

4.4. MOISTURE, IF PRESENT, SHALL BE REMOVED BEFORE APPLYING TC MASTIC.

5.0 METHOD OF APPLICATION

5.1 THREE OR FOUR INCH WIDE BRUSH SHALL BE USED. USE A MEDIUM TO STIFF BRISTLE BRUSH.

5.2 APPLY TC MASTIC IN TWO HEAVY COATS OF APPROXIMATELY 20 WET MILS EACH. NO WAITING TIME BETWEEN COATS.

6.0 ROCKSHIELD

6.1 TAPECOAT MASTIC SHIELD SHALL BE USED OVER THE FINAL COAT, WHERE IT HAS BEEN DETERMINED THAT THE BACKFILL, HANDLING OR INSTALLATION WILL BE DETRIMENTAL TO THE TC MASTIC.

7.0 BACKFILL

7.1 NO BACKFILLING SHALL PROCEED UNTIL AT LEAST 12 HOURS HAVE ELAPSED OR TAPECOAT MASTIC SHIELD HAS BEEN APPLIED OVER THE FINAL COAT AND PROVIDING THE AMBIENT TEMPERATURE IS 70°F. (21°C.) OR ABOVE.

7.2 IF TEMPERATURE IS BELOW THE DEGREES STATED IN 7.1, THEN BACKFILLING MAY NOT TAKE PLACE UNTIL 24 HOURS HAVE ELAPSED UNLESS TAPECOAT MASTIC SHIELD IS USED.

7.3 BACKFILL ADJACENT TO THE COATED PIPE SHALL BE FREE OF SCRAP, STICKS, LARGE STONES, ROCKS OR OTHER DEBRIS WHICH WOULD TEND TO DAMAGE THE COATING.