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SPECIALTY POLYMER COATINGS, INC. (SPC)

BRUSH GRADE APPLICATION SPECIFICATION – ACCELERATED CURE FOR COATING OF GIRTH WELDS WITH SPC POTABLE WATER COATINGS

I. GENERAL

- 1.1 This specification outlines the procedures and methods for preheating the pipe surface of girth welds and applying brush grade kits to facilitate rapid curing of Specialty Polymer Coatings, Inc.'s pipeline coatings.
- 1.2 This specification is utilized when coating girth welds in cold ambient temperature environments or when an accelerated coating cure is required to enable the pipeline to be quickly backfilled and put into service.
- 1.3 This specification is applicable to the following SPC coating systems:
 - SP-1386® DW NSF
 - SP-7888® NSF
- 1.4 Refer to Specialty Polymer Coatings, Inc.'s Brush Grade Application Specification for the specific coating system in use, and follow the requirements of the specification.

II. PROCEDURES

- 2.1 If ice, snow or moisture is present, preheat the weld area with a propane torch to a temperature between 25°C and 35°C (77°F and 95°F). Ensure heat is applied uniformly around the circumference of the pipe, that all snow and ice have been removed, and that the pipe surface to be coated is 3°C above the dew point.
- 2.2 Abrasive blast the weld area to a near-white condition and the required surface profile and cleanliness.
- 2.3 Using an induction coil or catalytic indirect propane heater ("Ciscan"), preheat the weld area to a temperature between 110°C and 115°C (230°F and 240°F). Ensure heat is applied uniformly around the circumference of the pipe. 3LPE & HPCC coatings should not exceed a preheat temperature of 90°C

BRUSH GRADE APPLICATION SPECIFICATION – ACCELERATED CURE

(194°F). If a propane torch is used on steel substrates a sweep blast must be done post heating to remove open flame contaminates.

II. PROCEDURES (cont.)

- 2.4 Allow the weld area to cool between 80°C and 95°C (175°F and 205°F).
 - 2.5 Using multiple light layers, apply the SPC pipeline coating brush grade kit to the weld area to the required coating thickness. It is recommended that two coaters be used to roll/brush the coating-one on each side of the pipe.
 - 2.6 Post heating may be required in areas of extreme cold and windy conditions. An insulation blanket can also be used to insulate the weld area to prevent rapid cooling of the applied coating.
 - 2.7 Allow the applied coating to cure to a dry hard condition.
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