



Protal 7125

Brush Application Specifications

1.0 Scope

- 1.1 This specification covers the external surface preparation and coating of pipelines for rehabilitation, girth welds, directional drill pipe, fittings and fabrication.

uniform gray appearance of a white metal blast-cleaned surface as defined by Swedish Pictorial Surface Preparation Standard Sa 2 1/2 or SSPC VIS-1.

2.0 Material and Storage

- 2.1 Material shall be Denso Protal 7125 liquid coating system as manufactured by Denso North America, 9747 Whithorn Drive, Houston, TX 77095 (Tel) 281-821-3355 (Fax) 281-821-0304 or 90 Ironside Crescent Unit 12, Toronto, Ontario, Canada M1X1M3 (Tel) 416-291-3435 (Fax) 416-291-0898. E-mail: info@densona.com.
- 2.2 Material shall meet the physical properties of the Protal 7125 product data sheet.
- 2.3 Storage of the material shall be in a dry room with temperatures between 33°F (0.5°C) and 80°F (27°C). These containers shall be stored up right. Do not allow to freeze.

- 4.3 Edges of the existing coating shall be roughened by power brushing or by sweep blasting the coating for a distance of 1" (25 mm) minimum.
- 4.4 All contaminants shall be removed from the steel surface to be coated. Oil and grease should be removed in accordance with SSPC SP-1 using non-oily solvent cleaner (i.e., xylene, MEK, ethanol, etc).
- 4.5 The Contractor shall check the surface profile depth by using a suitable surface profile gauge (Press-O-Film Gauge or equal).
- 4.6 Metal areas that develop flash rust due to exposure to rain or moisture shall be given a sweep blast to return them to their originally blasted condition.

3.0 Equipment

- 3.1 For mixing, use strong wooden stir sticks or power drills with appropriate mixing paddle.
- 3.2 For application, use 4" (100 mm) wide brushes or Denso applicator pads for small diameter pipe and/or 1/4" (6.3 mm) nap rollers for large diameter applications.
- 3.3 Wet film thickness gauges.

5.0 Application

4.0 Surface Preparation

- 4.1 Material for abrasive cleaning shall be the appropriate blend of grit to produce an angular surface profile of 2.5 - 5 mils (0.063 - 0.125 mm).
- 4.2 All surfaces to be coated shall be grit blasted to a near-white finish (SSPC SP-10, NACE No. 2 or Sa 2 1/2). *Note: Near-white finish is interpreted to mean that all metal surfaces shall be blast cleaned to remove all dirt, mill scale, rust, corrosion products, oxides, paint and other foreign matter. Very light shadow, very light streaks or slight discolorations shall be acceptable; however, at least 95% of the surface shall have the*

- 5.1 The surface shall have no condensation, precipitation or any other forms of contamination on the blasted surface prior to coating.
- 5.2 The substrate temperature range for application of Protal 7125 is -4°F (-20°C) to 68°F (20°C). The substrate temperature must be a minimum of 5°F (3°C) above the dew point temperature before proceeding with the coating operation. Preheating may be accomplished with propane torch or induction coil prior to abrasive blasting.
- 5.3 Protal shall be applied to the specified Dry Film Thickness (DFT) using a brush, Denso applicator pad or roller. Wet film measurements shall be performed to ensure close adherence to the thickness specification.
- 5.4 Mixing: Make sure the part A (Resin) and Part B (Hardener) components match in both material and size as specified on the containers. Mix the B component first, independent of the resin. Pour the contents into the part A (Resin) component. Mix at a slow speed so as not to create a vortex that could introduce air into the product until a uniform color is achieved making sure to scrape the bottom and sides of the container (approximately 2 minutes). No streaks shall be visible.

- 5.5 APPLICATION SHALL TAKE PLACE IMMEDIATELY AFTER MIXING. Pour the product onto the surface and spread down and around the surface in bands beginning from the leading edge of the material to as far under the pipe as can be reached. Overlap the bands and onto the existing coating a minimum of 1" (25 mm). Applicators shall use a brush to smooth out any obvious sags or rough edges, valleys or drips. Special attention shall be given to weld buttons and bottom surfaces.
- 5.6 The thickness of Protal 7125 shall be checked periodically by wet film gauge to achieve the minimum and maximum wet film thickness specified. After the Protal 7125 has cured, the owner's representative and/or contractor's inspector should measure the film thickness by magnetic gauge and notify the applicator of their acceptance. Notification to the applicator of any inadequately coated sections must be made immediately.
- 5.7 Over-coating, when necessary, shall take place within 1 hour at 50°F (10°C). If the time has lapsed, The surface shall be roughed prior to application of the topcoat using 80 grit sand paper or by sweep blasting.

6.0 Inspection/Testing for Backfill

- 6.1 The finished coating shall smooth and free of protuberances or holidays. All surfaces shall have the required minimum/maximum DFT. Inspection of brush application is best performed immediately after application.
- 6.2 Backfill time shall be determined by the "thumb nail test". The thumb nail test is defined by when one can no longer make a permanent indentation in the coating with his or her thumb nail. *Note: A full and/or chemical cure may not be achieved by backfill time.*
- 6.3 An acceptable field test to check to see if the coating has a full chemical cure, a solvent such as Xylene, MEK or Toluene can be rubbed on to the coating. If the gloss/sheen is removed the coating is not fully cured.
- 6.4 Spark testing shall be performed to ensure proper film thickness and for holiday inspection. The voltage used for testing weld joints and field applications shall be equal to that used for testing the mainline coating in the field or 125 volts/mil (4,920 V/mm).
- 6.5 The owner's representative immediately upon completion of the work shall make final inspection of the completed application. Notification of all defects must be made within a reasonable time frame from completion of the work to allow for all repairs within the allowed time frame for the project.

7.0 Repairs

- 7.1 For small pinhole repairs: Surfaces of repair up to 1/16 inch (2 mm) in diameter, roughen the surface of the parent coating, to remove gloss, around the holiday for at least 1 inch (25 mm). Use 80 - 120 grit sandpaper or light sweep blasting.
- 7.2 Medium sized repairs: Surfaces of repair areas up to 4 in² (25 cm²) in size, shall be prepared by abrasive blasting, as specified in Section 11, or by power tool cleaning in accordance with SSPC- SP 11 to remove dirt, scale, rust, damaged coating and any other foreign material to a bare metal condition and retain or produce the surface profile required by Section 4.0.
- 7.3 Large repairs: Surfaces of repair areas exceeding 4 in² (25 cm²) shall be repaired by abrasive blast cleaning as specified in Section 4.0.
- 7.4 The adjacent parent coating and any holidays or damaged coating adjacent to the cutback area shall be roughened for at least 1 inch (25 mm) around the repair and the edges shall be feathered.
- 7.5 After abrading, all dust shall be removed from the prepared areas using compressed air, a clean, dry bristle brush, a clean dry cloth or removed in accordance with SSPC-SP-1 using acetone, xylene or MEK.
- 7.6 Refer to "Protal 7125 Product Data Sheet" for additional information.

8.0 Safety Precautions

- 8.1 Follow the guidelines detailed in the Safety Data Sheets (SDS).
- 8.2 Keep containers closed when not in use. In case of spillage, absorb with inert material and dispose of in accordance with applicable regulations.
- 8.3 Always refer to project specifications as they may supersede Denso specifications.



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