1. GENERAL

1.1 Work Included

.1 Supply and application of all factory applied prime coats and factory applied finish coats.

1.2 Submissions

.1 With the shop drawings, the Contractor shall submit details of the coating systems to be applied.

1.3 Quality Assurance

.1 This specification is intended to be a minimum reference standard. The supplier may submit for review alternative coating systems for specific items of equipment, which provide equal or better corrosion protection and maintenance service than those specified herein.

2. PRODUCTS

2.1 Surface Preparation

.1 After degreasing, all ferrous components shall be dry blasted to a near white finish in accordance with SSPC-SP10 to a degree of cleanness in accordance with NACE #2 and obtain a 50 micron blast profile.

2.2 Prime Coating

.1 All ferrous surfaces are to be coated before the blasted surfaces deteriorate.

.2 Ferrous surfaces shall be coated with organic zinc primer, containing a minimum of 50% solids by volume, applied to a minimum dry film thickness of 50 - 75 micron.

2.3 Finish Coats

.1 Finish coats shall be fusion bonded epoxy coating to AWWA C213-85.

2.4 Assembly

.1 Items, which are to be bolted together before shipment shall have their surfaces cleaned and coated before the parts are assembled.

.2 All welded connections are to be continuous weld, sealing the mating surface completely. On completion of the welding and fettling all weld seams are to be treated with phosphoric acid solution, rinsed and thoroughly dried before the primer is applied.

.3 Where dissimilar metals are mated such as aluminum and steel, the mating surfaces shall be insulated from one another to provide protection against galvanic or other corrosion. Bolts,

nuts, washers and rivets shall be similarly insulated. The means of providing this protection shall be submitted to the Contract Administrator for review.

.4 All nuts, bolts, washers and similar fittings shall be 314 stainless steel or better.

3. EXECUTION

3.1 Inspection

.1 The supplier shall notify the Contract Administrator two weeks before commencing the protective coating in order to facilitate the inspection by the Contract Administrator of the surface preparation and protective coating application.

3.2 Protection

.1 All coated equipment shall be protected adequately against damage, dust, moisture and scratching during shipment, off-loading and storage on site. If, in the opinion of the Contract Administrator, the coating is damaged during shipment to the extent that touch up would not be satisfactory, the equipment shall be returned and re-coated at the Contractor's cost.

.2 Damage to coatings occurring at any time shall be made good prior to the application of any further coatings.

3.3 Application Condition

.1 All factory-applied coatings shall be carried out under controlled conditions. The atmosphere shall be dust free and kept at a temperature of between 10°C and 20°C. The relative humidity should not exceed 80%.

END OF SECTION