

The KEMA COATINGS LIMITED MAINLINE COATING TRANSITION PROCEDURE USING KEMA 250-12 COLD APPLIED SEALANT

This specification describes the technical requirements for coating Mainline Coating Transition Sites.

These sites result on buried steel pipelines throughout North America after the pipeline owner recoats a length of earlier- coated pipe with a new replacement coating and/or when the owner must replace a section of earlier-coated pipe with bare pipe requiring a new coating.

The inherent chemical differences between the older coating i.e. asphalt or tape and a new coating like epoxy cannot produce a strong, reliable bond between them.

The KEMA cold applied system behaves like a permanent cast to strengthen the transition site and provide greater protection to the pipe where the new coating overlaps the old.

SCOPE:

This specification shall be used by the pipeline's employees and all prime sub contractors employed by it. The specification shall be used on all activities related to mainline coating transitions throughout North America.

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BRIEF DESCRIPTION OF CHANGES:

This specification is revised to take advantage of the addition of new instructional photos and graphics.

SAFETY:

1. The Contractor shall maintain copies of the Material Safety Data Sheets (MSDS) for all controlled substances found at site and he shall ensure that his employees are familiar with the precautions of the MSDS regarding hazards, necessary protective equipment, first aid measures and be trained in the handling and the use of these products.
2. Work gloves and safety glasses shall be worn.

APPROVED MATERIALS:

Coating Component:

Top Coat
(K250-12)

Approved Coating:

KEMA 250-12 – 4”
p/n 752 GHA 1760

Approved Manufacturer:

KEMA Coatings Limited

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STORAGE:

Maintain KEMA 250-12 at temperatures between 15C. and 30C. for at least 8 hours immediately prior to use.

Avoid freezing.

SURFACE PREPARATION:

Remove dirt, dust, moisture, oil, grease and all other contaminants found on both old and new coating surfaces.

KEMA 250-12 TOP COAT APPLICATION:

Refer to photographs and instructions that follow in this specification.



KEMA 250-12 is packaged in cardboard cartons. There are four rolls each in a carton each measuring 4" wide x 20 feet long. Total coating length per carton: 80 feet.



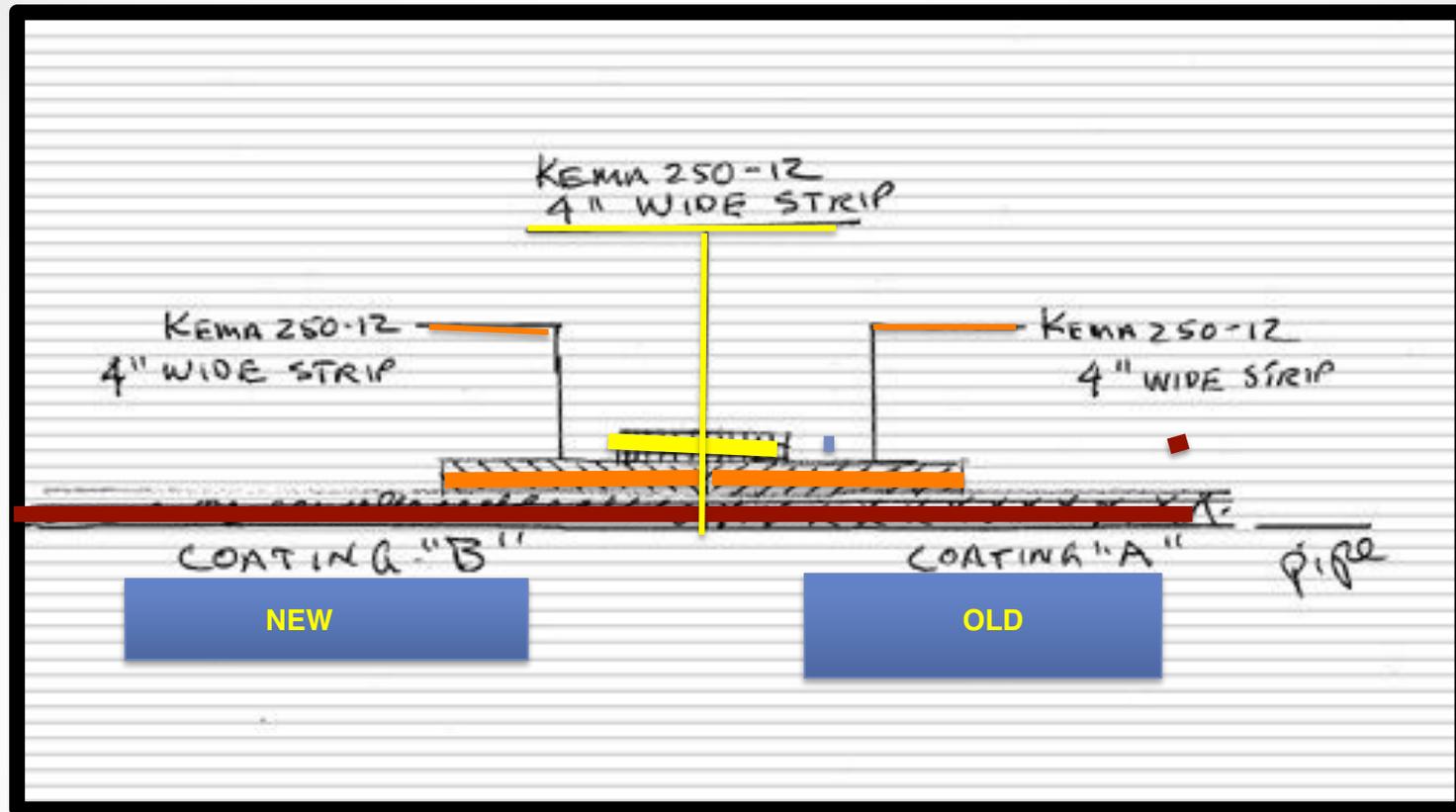
The rolls are ¼” thick with a 10-12 mils thick HDPE film laminated to one side. Each comes with a removable, paper interleaf (release liner) that protects the adhesive side until use.



Individual rolls are usually precut to the correct length. It is **important** to note that Applicators shall not attempt to overlap this material onto itself by any more than 1-2 inches. It is too thick and unwanted channeling, voids and air pockets can result where such an effort is tried.



Begin by finding the point on the newly recoated pipe where the old and the new coatings meet or overlap. This shall be referred to as the **“Transition Point”** and is shown as the yellow line in the above photo.



Measure the circumference of the pipe. Cut two strips of 4" wide KEMA 250-12 (**Orange lines**) that are only 1" longer than the pipe measurement. These will be the two base or initial strips applied as shown in the above diagram. Cut a third strip that is 2" longer (**Yellow line**) than the first two. This will be the centre top coat strip as shown above.

The first strip shall be applied on either the left "NEW" or right "OLD" side of the Transition Point. The second strip shall be applied immediately beside the first so that one butts up against the other all around the pipe.



After both strips have been applied side by side pinch the open seam between them closed using thumb and forefinger. Continue this all around the pipe. Use hand or roller to secure to pipe.



Apply third and final strip of KEMA 250-12 so that 2" of the width of the 4" wide top coat falls on either side of the pinched seam all around the pipe. The 1"-2" extra length shall be pressed onto itself to seal the centre strip only.



Apply a medium pressure using only your hand or roller to secure the finished coating system. Inspect your work. Site can be backfilled immediately following inspection. A protective wrap of a HDPE rock shield mesh material can be applied over top of the transition coating in especially loose, rocky backfill conditions.

KEMA COATINGS LIMITED

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