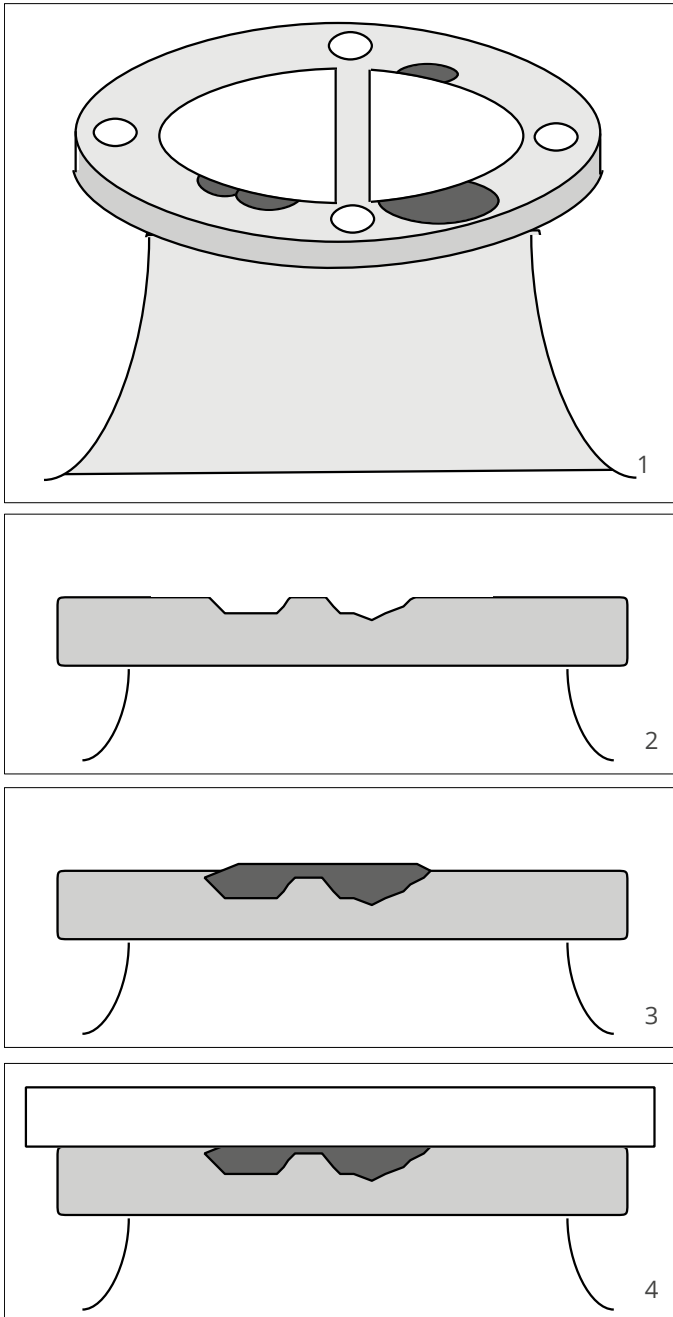


Flange - corrosion

APPLICATION DATA SHEET No. 126



1. Corroded flanges can be repaired, using Wencon Cream or Wencon Rapid. The optimal surface preparation is to grit blast the flange, applying Wencon Cream or Wencon Rapid. Then letting it cure, and machine the flange to size. But optimal conditions are not always available, therefore below is a guide on how to do the application **on site**.
2. Dismantle the flange, clean and degrease the affected areas thoroughly using Wencon Cleaner, and any method available to get the surface roughened.
3. Apply a suitable layer of Wencon Cream or Wencon Rapid on the corroded area.
4. Mount and hold a template/matrice to the flange until it has fully cured. The template can be made in thick plastic plate (polyethylene) to avoid the use of release agent. If it is made of metal, use Wencon Release Agent on the template to avoid adhesion.
5. After curing, remove the template, and re-shape the holes in the flange using a round file.

If a number of flanges on i.e. a manifold needs repair, it is important that the entire surface is in line. Use a large enough template to cove all flanges at the same time. It is also possible to use the engine, as the mating surface/template.

NB: It is important to use Wencon Release Agent when using a template or matrice, or the two surfaces will be fused together. And after curing to remove any excess material.

Alternative products: Wencon Ceramic products

Wencon surface preparation

Choose the relevant surface preparation, depending on the nature of the job.

Surface preparation using dry blasting methods:

Application with Wencon products on a dry surface, at minimum 3°C above dew point.

1. Blast the machine part to SA 2,5 using sharp-edged blasting media, to a roughness of min. 75 microns.
2. Leave the part for sweating out salts in a warm place for at least 12 hours or heat it up to 30 - 40°C (86-104 °F) using gas torches.
3. Blast again to SA 2,5, prior to the application.
4. For parts containing a lot of water and salt, it may be necessary to repeat point 2 and 3, until the surface remains light grey, for at least 2 hours after blasting.
5. For optimal adhesion of Wencon products, always use Wencon Bio Cleaner or Wencon Cleaner prior to application. Follow one of below two methods:
 - 5.1 **Wencon Bio Cleaner**
Wet surface: Apply Wencon Bio Cleaner and let it work for 5-10 min. If necessary use a brush, to make sure the surface is clean. Rinse off with clean water and wipe off with an absorbing cloth.

Dry surface: Apply Wencon Bio Cleaner and let it work for 5-10 min. If necessary use a brush, to make sure the surface is clean. Rinse off with clean water and dry with an absorbing cloth or with compressed air for a completely dry surface. Hereafter any Wencon products can be applied.
 - 5.2 **Wencon Cleaner**
After surface preparation, apply Wencon Cleaner with a brush and allow the product to evaporate before applying other Wencon products. Wencon Cleaner is non-flammable. Use only in large or well ventilated rooms.

Surface preparation using wet/damp methods:

Water jet the entire surface with water and sand to a standard equal, to SA 2,5 as described above.

If the surface is left wet after surface preparation, is it important to dry out the surface or alternatively use a Wencon UW product.

Surface preparation for emergency/temporary applications:

If above surface preparation methods are not possible, it may be necessary to use one of below methods:

- Blasting
- Grinding
- Needle Gunning

In emergency / temporary applications it may be difficult to prepare the surface according to above methods. In any case, it is important to clean the surface to SA 2,5 and 75 microns roughness. If possible dry the surface before applying. If not possible, use Wencon UW products.

For further information on Wencon surface preparation, please contact our Area Sales Managers.