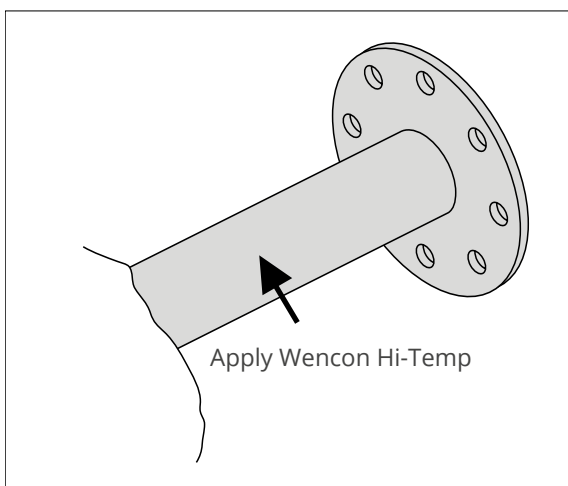
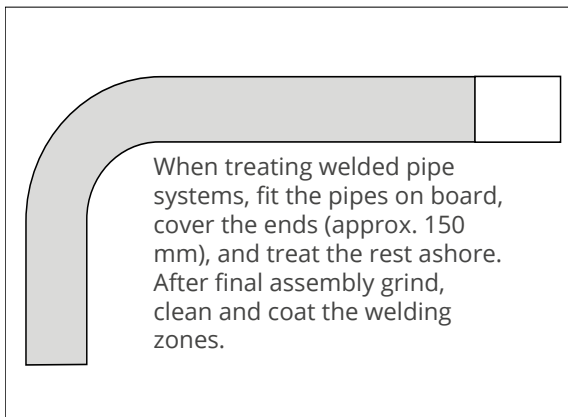
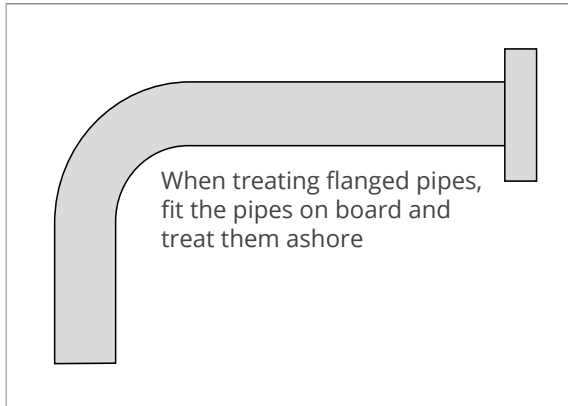


## Hot pipes - protection

APPLICATION DATA SHEET No. 115



Hot-water, hot-oil or steam pipes will often be exposed to corrosion on the outer side, due to moisture or water in the insulation. Wencon can eliminate this breakdown with a coat of Wencon Hi-Temp.

Wencon Hi-Temp is a two-component fluid. It can be applied with a paint brush, and quite exceptionally it can be applied at temperatures of over 120°C (248°F).

The cured coating can withstand temperatures up to 160-200°C (320-424°F).

The coating is very simple to apply and can be made either before or after the pipes have been installed. The most common method, especially with new buildings, is that the pipes are first fitted on board, then removed ashore to be grit-blasted and coated. The only hindrance to making this operation on board is the lack of space.

One of the big advantages with the coating is that damages on the finished coating are easily repaired. The repair is limited to grinding the damaged area and applying a new coat.

Consumption of material. See chapter 1 in the Wencon Repair Manual.

For this application use radiator brushes with half the bristles cut off. This makes the brush well suited to the consistency of Wencon Hi-Temp.

1. Grit blast or grind a belt around the area to be repaired, and clean acc. to Wencon surface preparation, next page.
2. Apply the first layer of Wencon Hi-Temp yellow and let it semi-cure.
3. While the first layer is still tacky, apply the next layer of Wencon Hi-Temp Green.
4. The repair can be reinforced by using Wencon Reinforcement Tape wrapped tight in the wet Hi-Temp.
5. The finished layer thickness shall be 600-800 microns.

## 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.