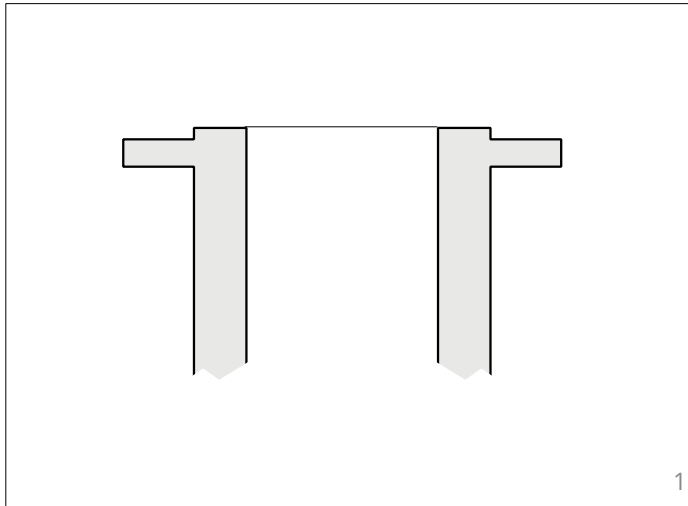


Pipe ends and flanges - coating

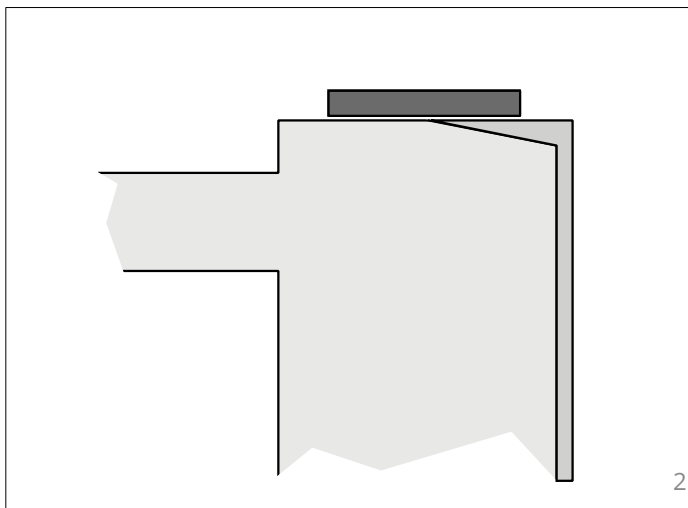
APPLICATION DATA SHEET No. 106



1

For extension of lifetime, the pipe ends can be coated internally. The coating must be done carefully, and according to below instructions.

1. Determine how far into the pipe, the coating has to be applied. Clean the surface acc. to Wencon surface preparation next page.
2. Before applying the Wencon Coating the innermost edge of the packing surface must be ground as shown in the diagram. It is important that the seal and the coating overlap, so as to avoid the untreated portion of the packing surface becoming wet. Apply the coating as shown in illustration 2. Please refer also to the directions for use of Wencon Coating.

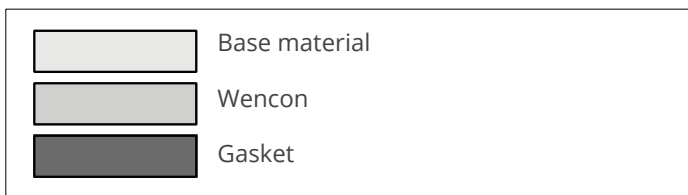


2

After curing, grind or turn to obtain a smooth packing surface.

This operation can be avoided if, before curing, a template/matrice is fitted tightly on to the flange. This template/matrice must be given a coat of Wencon Release Agent or be made of plastic.

When assembling the pipe, it is of great importance that the gasket does not press on the innermost edge of the flange (see diagram).



Alternative products:
Wencon Ceramic Coating, Wencon UW Coating
or Wencon Hi-Temp Coating

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.