

Scrubber outlet (Overboard Pipe and Surrounding Hulling)

Application: Protective double-layer coating, resistant

to scrubber washing water and other

harsh environment.

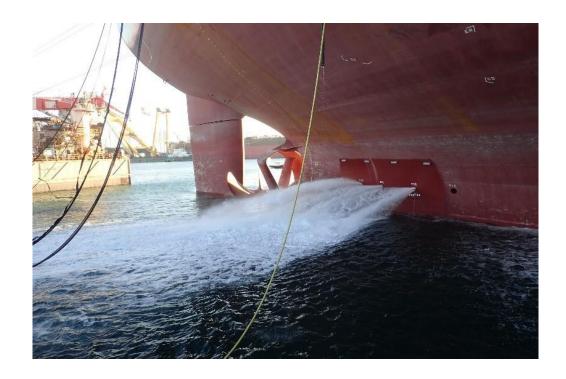
Drydock World Dubai

Place: December 2019

Date: Job, DWD - Report, Wencon

Job and report done by: supervising consultant

Wencon products used: Wencon Hi -Temp





1st stage:

Surface Preparation Comply to ISO8501

- Clean and degrease all surfaces, including cut-outs, rat holes and welds shall be rounded to a radius of at least 2 mm, weld splatter removed
- 2. Weld seams burned, and rusty areas blast cleaned to min ISO-Sa 2½ or power tool cleaned to min SPSS-Pt3 prior grit blasting
- Rough to an angular profile between 75 100 microns (in accordance with ISO 8503 parts 1 and 2)
- Abrasive blasting to a cleanliness of white metal (Sa3/SP5) or near-white metal (Sa 2½/SP10) followed by removal of all abrasive residues
- 5. The purity of the sandblasting is visually checked
- Bressler Sampler test for measuring soluble salts/chlorides in the steel surface (ISO 8502-6) limit value <20 mg m2
- 7. Distance to dew point of minimum 3 degrees Celsius throughout the application process
- 8. Optionally measurement of any acid contamination of the steel surface is measured (iron sulfate) with KTA scat test kit, limit value is <10 micrograms / cm²





Atmospheric conditions throughout the application:

- No final blast cleaning shall be performed if the humidity at the surface is above 85%.
- No coating shall be applied when the relative humidity of the air is outside the limits given by the coating manufacturer.
- No coating shall be applied and dried during fog, mist, rain, when the steels temperature is below the coating manufacturer's specification/recommendations, or if the steel surface temperature is less than 3°C above the dew point.

2nd stage:

Wencon Product application:

- 1. Surface to be applied shall appear dust and grease free before applying the products
- 2. Stripe coat of edges and welding's recommended if considered beneficial by applicator.
 - Edges of beams, all sharp edges, excessively irregular welds, etc. shall be stripe coated.
 - Stripe coating shall be prior to each coat.
- 3. Wencon Coatings is recommended to be applied as a double coat system. The overcoating time can vary from one to three hours depending on temperature.
- 4. The second coat must be applied while the first coat is still tacky (wet in wet application).
- Curing will take place in 6 -24 hours at 20°C (68°F) and faster by higher temperatures.



Application of first layer of Wencon coating is in progress



Application of first layer coatings completed



Application of second layer completed



3rd stage:

Overcoating

- Wencon's epoxies are in general compatible with other epoxy-polyamide / amine paint's and polyurethane coatings substrates bond well to each other if the surfaces are clean and slightly abraded.
- 2. Over & recoating is optimally performed in the timeframe between tack free and cured.
- 3. Recement recoat interval at (20°C/68°F)
 - Min: 4 hours
 - Maximum: 8 hours
 - Time interval are extended at lower temperatures and shortened at higher temperatures.
- 4. In case curing takes place before over/recoat, it is recommended to roughen the surface rye as possible to ensure optimum adhesion under the circumstances.
- 5. Overcoating using foreign paints and coatings, it is recommended to consult the supplier to obtain recommendations for overcoating of Wencon epoxy coatings.

