

[SURFACE PREPARATION & PAINTING (COATING) PROCEDURE]

PROJECT TITLE: FADHILI GAS INCREMENT PROJECT PKG1
PROJECT NUMBER: SG7061
SE&A P.O. NUMBER: 5000103311
SA DUMMY P.O. NUMBER: CFIK-D43-34(2)-A027-DA
REQUISITION DESCRIPTION: CONTROL VALVE, GLOBE (GENERAL)
REQUISITION NUMBER: KAR511 - MR-135
ITEM DESCRIPTION: CONTROL VALVE
ITEM NUMBER COMMON
COMPANY DOC.NUMBER SG7061-KAR511-01-001-K0PNT001-010
SE&A DOC. NUMBER: SG7061-KAR511-01-001-K0PNT001-010
NMR NUMBER: 001




SENA Review code: B
See comments

ISSUED

29-Mar-2025

DARVICO

FOR APPROVAL

				<input type="checkbox"/> Approved			PM
				<input checked="" type="checkbox"/> Approved with comment			
B	29-Mar-2025	FOR APPROVAL	Ajay	<input type="checkbox"/> Approved with comment Haridas			
A	26-Feb-2025	FOR APPROVAL	Ajay	<input type="checkbox"/> Rejected Resubmit Haridas			
REV.	DATE	DESCRIPTION	MADE BY	CHECKED BY	APPROVED BY		
				<input type="checkbox"/> Reviewed with Comment / Resubmit		10 Apr 2025	
 				This approval or review does not relieve the vendor/resubmitter of his responsibility to meet all requirements of the purchase order.			
				ORIGINAL		CHECKED	
				CHECKED		CHECKED	
SAMSUNG E&A				SAMSUNG ENGINEERING CO., LTD.			
SAUDI ARABIAN OIL COMPANY							




شركة الرشيد درسر للصمامات والأجهزة المحدودة

Dresser Al Rushaid Valve & Instrument Co., Ltd.

س.ت. ٢٠٥٥٠١١١١ - رأس المال المدفوع ٢,٠٠٠,٠٠٠ ريال سعودي
C.R. 2055001111-Paid up Capital SR. 2,000,000
تلفون : ٣٤١٠٢٧٨ (٠٣) - فاكس : ٣٤١٧٦٢٤ (٠٣)
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Masoneilan®

OPERATING PROCEDURE	Effective Date Feb 26, 2025	INSTRUCTION NO. QAOP 37
	Rev. No. A	Page 1 of 6
Painting Specification for Control Valve	Originating Dept.	QA
	Prepared by	Nataraj (Technical – In-Charge)
	Approved by	Fahad (QA – In-Charge)
Section I	REFERENCE	
Section II	SCOPE OF WORKS	
Section III	SURFACE PREPARTATION	
Section IV	COATING SYSTEM	
Section V	TECHNICAL SPECIFICATION	
Section VI	INSPECTION & TESTING	
Section VII	ACCEPTANCE CRITERIA	

 OPERATING PROCEDURE	Effective Date Feb 26, 2025	Instruction No. QAOP 37
	Rev. No. A	Page 2 of 6
Subject: PAINTING SPECIFICATION FOR CONTROL VALVE	Originating Dept.	QA
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Section I

Reference

1. PO 5000103311
2. SAES-H-001_ 10 April 2011
3. SAES-H-101V_ 9 October 2012
4. 34-SAMSS-711 _ 16 January 2020
5. SAES-J-700 _ 02 October 2022
6. APPROVED DATA SHEETS
7. APROVED DRAWINGS
8. 175-091900_ 22 May 2011


Section II

Scope

This specification define the requirements for applying primer, top coat, method of application, color and finish requirement of coating system as applicable to Dresser Masoneilan products. This Painting specification is prepared in compliance with requirements specified in SAES-H-001, SAES-H-101V and P.O 5000103311.

2.1 General

- a) The types of paint described herein are two components (Resin and Curing agent) system.
- b) All paint material shall be stored in conditions recommended by the paint manufacture.
- c) All paint material shall be lead free.
- d) No paint shall be used beyond its shelf life (Recommended by paint manufacturer/SAES-H-101V)
- e) Any paint which has gelled or settled during shortage shall not be used.
- f) All paint material shall be supplied to the work site/ paint booth in original unopened and clearly identifiable containers.
- g) MTC's for Paints & Abrasive Type Analysis

 OPERATING PROCEDURE	Effective Date Feb 26, 2025	Instruction No. QAOP 37
	Rev. No. A	Page 3 of 6
Subject: PAINTING SPECIFICATION FOR CONTROL VALVE	Originating Dept.	QA
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2.2 Application Methods

a) All painting system will be applied according to the paint manufacture's recommendations. The paint is applied using an airless spray system in paint booths.

b) Apply primer and top coat with an airless system. The applied coats shall be a continuous full bodies film covering all surfaces, and shall be sprayed into corners, depressions etc. completely cover bolt heads, nuts, all ferrous surface, and other areas not protected or masked. Finished surfaces shall be uniform in color free from pin holes, sags, runs, dripping, orange peel effect, or other imperfection. Surfaces, which will be top coated to their attachment.

Section III. Surface Preparation

3.1 Scope Of Work For Surface Preparation

This specification establishes the surface preparation of control valve, Level transmitter, and accessories at DARVICO premises.

a) Prior to the application of coating, all surfaces shall be cleaned free from dirt, grease, oil etc. with NAVI WASHER 99330 or equivalent, weld flux, rust, scale or other substance detrimental to the coating process shall be removed by suitable mechanism, blast cleaning method shall be applied wherever required.

b) The cleaning process used shall be compatible with the alloys, coatings, and material of all parts of an assembly. Care shall be taken to not injure or impair any prior coating or surface treatments.

c) Suitable precautions shall be taken to maintain maximum cleanliness of the assembly throughout the entire painting process.

d) Mechanism of parts which are exposed eg., threaded rods or shafts used for adjustments or setting and mechanical linkages, shall be suitably masked or protected from paint coating insofar as the paint would interfere or restrict their operational and function.

e) Identification plates, instruction plates, scale plates, etc. permanently affixed to the assembly shall be suitably protected or masked to prevent defacement by paint. Holes and other opening shall be plugged or masked when topcoat or primer should be excluded from entry.

f) Abrasive (Garnet) blasting shall be applicable before first coat or wherever valve surfaces so dirty or corroded but which shall be done only after protected of Identification plates, instruction plates, scale plates, arrow plates, stud holes, studs and nuts and other opening etc. These can be protected by plugged or suitable masked. The abrasive material is Australian Garnet 30/60. The reference standards for abrasive blasting shall be SIS 05-59-00 and SSPC-Vis 1.

h) The surface cleanliness finish shall be minimum as advised in the Paint Manufacturer datasheet.



Effective Date
Feb 26, 2025

Instruction
No. QAOP 37

OPERATING PROCEDURE

Rev. No. A

Page 4 of 6

Subject:

PAINTING SPECIFICATION FOR CONTROL VALVE

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QA

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**Fahad
(QA – In-Charge)**

3.2 Pre-blast Check

1. The coating inspector shall decide if the substrate requires solvent or detergent cleaning before abrasive blasting.
2. Prior to blasting, rough welds and cut-offs shall be ground to a minimum radius to ensure proper coating application. Weld spatter shall be removed.
3. Abrasive blasting shall be carried out only when the steel surface is at least 3°C (5°F) above the Dew Point.
4. Surface profile check with replica tape if the shot blast is done per blast cleanliness level SSPC-SP10
5. Atmospheric & weather condition check e.g. ambient temperature, substrate temperature, humidity, dew point.

Section IV. Coating system

For projects ARAMCO, Masoneilan standard shall follow according to **applicable operating temperature** due applied.

The coating shall be as per applicable painting system.

4.1 Paint Preparation

- a) Thoroughly mix base (Resin), Hardener (curing agent) and solvent as instructed by paint manufacture.
- b) Adjust viscosity of tope coat preparation for the particular method application used, at ambient temperature by using solvent. The type and quantity of solvent should be as described in manufacture data sheet.
- c) Do not use paint under 10degC/50F or over 38degC/100F. Preferred temperature is in the range of 24degC/ 75F.
- d) Paint mixture shall be thoroughly stirred and allow to keep 10 minutes before use.
- e) Pot life. : Shall be as recommended by Paint Manufacturer.
- f) Cleaned surfaces shall be primed or coated before the surface condition degrades below the specified cleanliness level requirement
- g) Abrasive blast cleaned surfaces shall be re-inspected prior to priming or coating if the surfaces are held for more than 4 hours after blasting

Note:-

- 1) Painting system shall be followed as per Document No. P.O. 5000103311
- 2) For ARAMCO projects where ever APCS is specified, the same shall be followed.
- 3) Optional top coat paint shall be used on special request.
- 4) Abrasive Quality: - Batch certification shall be provided to ensure the quality of abrasive.
- 5) Calibration of instrument and equipment shall be provided for review.
- 6) Testing Equipment's:- Surface profile thickness gauge shall be provided for review.
- 7) Surface preparation profile preparation shall be done before coating.
- 8) In multi-coat applications, primer, intermediate coat, and topcoats shall be of contrasting colors and from the same coating manufacturer [SAES-H-001 § 9.2.2].
- 9) Repair & Maintenance: - Repair & maintenance coatings shall be selected as per the SAES-H-001/002/003, relevant APCS approved paint Manufacturer's datasheets in SAES-H-101V/002V and as per requirements specified in this project.



Effective Date
Feb 26, 2025

Instruction
No. QAOP 37

OPERATING PROCEDURE

Rev. No. A

Page 5 of 6

Subject:
**PAINTING SPECIFICATION
FOR CONTROL VALVE**

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Section V

Technical Specification

5.1 Painting (Actuator)

Hand Wheel	Black, APCS-1D RAL 9005, min. 50µm D.F.T.
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All coating shall be using approved products per SAES-H-101V.

Primer – First Coat

Surface Profile: 40-65 microns

Reference	ARAMCO standard APCS – 1D
Type of coating	Epoxy / Polyurethane Coating System for Atmospheric Service (with Inorganic Zinc Primer)
Surface Cleaness	Sa. 2 ½
Priming	HEMPEL'S GALVOSIL 15780
Dry Film Thk.	65 microns
Application	Airless spray

Intermediate

Reference	ARAMCO standard APCS – 1D
Type of coating	Epoxy / Polyurethane Coating System for Atmospheric Service (with Inorganic Zinc Primer)
Product	HEMPADUR MASTIC 45881
Dry Film Thk.	100 to 110 microns
Application	Airless spray

Top Coat

Reference	ARAMCO standard APCS – 1D
Type of coating	Epoxy / Polyurethane Coating System for Atmospheric Service (with Inorganic Zinc Primer)
Product	HEMPATHANE TOPCOAT 55210
Dry Film Thk.	50 microns
Shade / Colour	RAL 1023 / SAFETY YELLOW
Application	Airless spray

Minimum System Dry Film Thickness: 225 microns (refer product MSDS for DFT ranges)

NOTE:- In multi-coat applications, primer, intermediate coat, and topcoats shall be of contrasting colors and from the same coating manufacturer [SAES-H-001 § 9.2.2]



Effective Date
Feb 26, 2025

Instruction
No. QAOP 37

OPERATING PROCEDURE

Rev. No. A

Page 5 of 6

Subject:
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5.2 Painting Valve Body

Steam out temperature need to be considered for painting, hence for some valves, painting system is changed to APCS-11C. Please add APCS-11C painting details.

Carbon Steel and Alloy Steel shall be painted as per below table, considering the service temperature.

Service Temperature: 79.5 0 C / 175 0 F up to 120 0 C / 248 0 F

Primer – First Coat

Surface Profile: 40-65 microns

Reference	ARAMCO standard APCS-1A
Type of coating	Epoxy Coating (Inorganic Zinc-Priming)
Surface Cleaness	Sa. 2 ½
Priming	HEMPEL's GALVOSIL 15780 (Solvent based)
Dry Film Thk.	65 microns
Application	Airless spray

Intermediate

Reference	ARAMCO standard APCS-1A
Type of coating	Epoxy Coating Polyamide cured
Product	HEMPADUR MASTIC 45881
Dry Film Thk.	100-110 microns
Application	Airless spray

Top Coat

Reference	ARAMCO standard APCS-1A
Type of coating	Epoxy Coating Polyamide cured
Product	HEMPADUR MASTIC 45881
Dry Film Thk.	100-110 microns
Shade / Colour	RAL 9006 / Aluminum
Application	Airless spray

Minimum System Dry Film Thickness: 265 microns (refer product MSDS for DFT ranges)

NOTE:- In multi-coat applications, primer, intermediate coat, and topcoats shall be of contrasting colors and from the same coating manufacturer [SAES-H-001 § 9.2.2]



Effective Date
Feb 26, 2025

Instruction
No. QAOP 37

OPERATING PROCEDURE

Rev. No. A

Page 5 of 6

Subject:
PAINTING SPECIFICATION
FOR CONTROL VALVE

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5.3 Painting Valve Body

Insulated carbon Steel and Alloy Steel shall be painted as per below table, considering the service temperature.

Service Temperature: up to 90 0 C / 194 0 F

Primer – First Coat

Surface Profile: 40-65 microns

Reference	ARAMCO standard APCS-2A
Type of coating	Epoxy Coating System for General Immersion Service
Surface Cleaness	Sa. 3
Priming	Hempadur 85671
Dry Film Thk.	100 microns
Application	Airless spray

Intermediate


Reference	ARAMCO standard APCS-2A
Type of coating	Epoxy Coating System for General Immersion Service
Product	Hempadur 85671
Dry Film Thk.	100 microns
Application	Airless spray

Top Coat

Reference	ARAMCO standard APCS-2A
Type of coating	Epoxy Coating System for General Immersion Service
Product	Hempadur 85671
Dry Film Thk.	100 microns
Shade / Colour	RAL 9006 / Aluminum
Application	Airless spray

Minimum System Dry Film Thickness: 300 microns (refer product MSDS for DFT ranges)

NOTE:- In multi-coat applications, primer, intermediate coat, and topcoats shall be of contrasting colors and from the same coating manufacturer [SAES-H-001 § 9.2.2]

 OPERATING PROCEDURE	Effective Date Dec 28, 2024	Instruction No. QAOP 37
	Rev. No. A	Page 6 of 6
Subject: PAINTING SPECIFICATION FOR CONTROL VALVE	Originating Dept.	QA
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Section VI. Inspection & Testing

Requirements in this section refer only to coating in the following categories:

- a) New construction
- b) Major renovation

The requirements of SAEP-316 apply to these categories when the coating is performed in Saudi Arabia.

Coating inspector, Blaster, Supervisor and Applicators shall have approval from Aramco in accordance with approved project painting specification. Third Party Training Company certification (NACE, SSPC or equivalent) or Saudi Aramco approved coating supplier for the type of coating to be applied."

Quality Control Equipment :

The coating contractor shall have the quality control equipment listed in (Attachment A of SAES-H-001) on site for the inspection of surface preparation and coatings application.

Quality Control Records :

Quality Control Equipment Check Sheet – (Attachment B of SAES-H-001) :

This form shall be completed prior to job start-up. It shall be completed and signed by the coating contractor supervisor and then signed by the Saudi Aramco Inspector. No work is allowed until this form is completed.

Daily Job Log:

The coating contractor supervisor shall fill out a log, on a daily basis, recording all problem areas, delays, non-compliances, and corrective actions taken for Saudi Aramco inspector witnessing and surveillance.

In-process Inspection Sheet – (Attachment C of SAES-H-001) :

This form shall be completed and signed every work-day by the contractor supervisor. The Saudi Aramco inspector shall initial each item marked with an asterisk before work is allowed to begin on subsequent items.

Coatings and Equipment Log – (Attachment D of SAES-H-001) :

This form shall be completed and signed by the coating contractor supervisor and verified and signed by the Saudi Aramco inspector.

Non Conformance Report :

The non-conformance report shall be issued whenever any defect is resulted by coating materials deficiencies or/ and application malfunctioning. Remedial action and method of repair shall be defined and agreed. The Saudi Aramco inspector shall ensure that report copies have been routinely circulated and remedial actions have been implemented correctly.

Additional Inspection Requirements Applicable to Purchase Orders :

Saudi Aramco Form 175-091900 applies whenever this Standard is referenced in a Purchase Order.

Section VII. Acceptance Criteria

1. Check painting thickness at 5 points minimum and ensure the average points are according to standard film thickness specified in the painting procedure.

VALVE BODY / ACTUATOR / HANDWHEEL - PAINTING SYSTEM										
SL.No	Qty	Train-6	Train-7	Train-8	MATERIAL	Insulation	Operating Temperature Deg F	Painting System-Body	Painting System-Actuator	Painting System-Handwheel
1	3	D43-361-FV-6029	D43-367-FV-7029	D43-368-FV-6029	A216 gr WCC	NO	140 <small>Steam out condition @ 300degF</small>	APCS-1A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
2	3	D43-361-FV-6030	D43-367-FV-7030	D43-368-FV-6030	A216 gr WCC	NO	140 <small>Steam out condition @ 300degF</small>	APCS-1A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
3	3	D43-361-FV-6062	D43-367-FV-7062	D43-368-FV-6062	A216 gr WCC	NO	140	APCS-1A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
4	3	D43-361-FV-6096A	D43-367-FV-7096A	D43-368-FV-6096A	A216 gr WCC	YES	140 <small>Steam out condition @ 300degF</small>	APCS-2A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
5	3	D43-361-FV-6096B	D43-367-FV-7096B	D43-368-FV-6096B	A216 gr WCC	YES	140 <small>Steam out condition @ 300degF</small>	APCS-2A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
6	3	D43-361-PV-6503	D43-367-PV-7503	D43-368-PV-6503	A352 gr LCC	YES	65.4 <small>Steam out condition @ 300degF</small>	APCS-2A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
7	3	D43-361-PV-6507	D43-367-PV-7507	D43-368-PV-6507	A352 gr LCC	YES	85	APCS-2A (RAL 9006,Aluminum)	APCS-11C (RAL 9006, Aluminum)	-
8	3	D43-361-PV-6508	D43-367-PV-7508	D43-368-PV-6508	A352 gr LCC	YES	86 <small>Steam out condition @ 300degF</small>	APCS-2A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
9	3	D43-361-TV-6041A	D43-367-TV-7041A	D43-368-TV-6041A	A216 gr WCC	YES	144 <small>Steam out condition @ 300degF</small>	APCS-2A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
10	3	D43-361-TV-6041B	D43-367-TV-7041B	D43-368-TV-6041B	A216 gr WCC	YES	144 <small>Steam out condition @ 300degF</small>	APCS-2A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	APCS-1D (RAL 9005, Black)
11	3	D43-362-FV-6009	D43-372-FV-7009	D43-382-FV-6009	A216 gr WCC	NO	140	APCS-1A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
12	3	D43-362-PV-6525	D43-372-PV-7525	D43-382-PV-6525	A352 gr LCC	YES	84.95	APCS-2A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
13	3	D43-364-PV-6052	D43-374-PV-7052	D43-384-PV-6052	A352 gr LCC	NO	120 <small>Steam out condition @ 300degF</small>	APCS-1A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	APCS-1D (RAL 9005, Black)
14	3	D43-364-PV-6053	D43-374-PV-7053	D43-384-PV-6053	A352 gr LCC	NO	120 <small>Steam out condition @ 300degF</small>	APCS-1A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	APCS-1D (RAL 9005, Black)
15	3	D43-364-PV-6070	D43-374-PV-7070	D43-384-PV-6070	A216 gr WCC	NO	127	APCS-1A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
16	3	D43-365-LV-6011	D43-375-LV-7011	D43-385-LV-6011	A216 gr WCC	YES	227 <small>Steam out condition @ 300degF</small>	APCS-2A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
17	3	D43-365-LV-6025	D43-375-LV-7025	D43-385-LV-6025	A216 gr WCC	YES	227	APCS-2A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
18	3	D43-363-LV-6028	D43-373-LV-7028	D43-383-LV-6028	A352 gr LCC	YES	141.4 <small>Steam out condition @ 300degF</small>	APCS-2A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-
19	3	D43-363-LV-6002	D43-371-FV-7026	D43-383-LV-8002	A352 gr LCC	YES	141.4	APCS-2A (RAL 9006,Aluminum)	APCS-1D (RAL 1023,Traffic Yellow)	-

specify the Applicable code and acceptance criteria for each Inspection & test.

-salt/dust/profile/cleanliness
-DFT/ Adhesion

ISO8502-3 Dust Level
ISO8502-6 salt test



شركة الرشيد درسر للصمامات والأجهزة المحدودة
Dresser Al Rushaid Valve & Instrument Co., Ltd.

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Tel.: (013) 341-0278 - Fax:(013) 341-7624

من.ت ٢٠٥٥٠٠١١١١ - رأس المال المدفوع ١٠,٠٠٠,٠٠٠ ريال سعودي
تلفون: ٣٤١-٠٢٧٨ (٠١٣) - فاكس: ٣٤١-٧٦٢٤ (٠١٣)

PAINTING REPORT

CUSTOMER: SAIPEM
CUSTOMER P.O.: 1421673

Painting System : APCS-2A
Dresser Ref.DMN8-01744/22

Valve Tag No.	Surface Profile	Thickness (Avg.microns)		Top coat	Avg. Thickness	Painting System		COLOUR		
		Primer	Indermediate			Body-Bonnet				
H49-046-PV-0576	59	108	118	105	331	APCS-2A	APCS-2A	LIGHT GREY 7035		
H49-046-PV-0476	57	105	113	102	320	APCS-2A	APCS-2A	LIGHT GREY 7035		
Primer Coat : HEMPADUR 85671		Mid Coat: HEMPADUR 85671			Top Coat : HEMPADUR 85671 RAL 9006					
Manufacture : HEMPEL		Manufacture : HEMPEL			Manufacture : HEMPEL					
Batch No.: 732100150		Batch No.: 732110583			Batch No.: 732110660					
Expiry Date : Oct-23		Expiry Date : Nov-23			Expiry Date : 23-Nov					
<u>Atmospheric Condition:</u>		<div>Q. A. ENGINEER</div>								
<u>Substrate Temp. Ts</u>									30.5 °C	
<u>Air Temperature:Ta</u>									26.3 °C	
<u>Dew Point : Td</u>									15.2 °C	
<u>Relative Humidity RH % :</u>									50.70%	
<u>Compressed Air Supply Blotter Test : Good</u>										
<u>Residual Chloride Found:Satisfactory</u>										
<u>Adhesion Test Result: Satisfactory</u>										
<u>Degree of Cleaness :Sa 3 (ISO 8501-1)</u>										

Q. A. ENGINEER
QA-3

Notes: Salt contamination ,Chloride content correct value is achieved astisfactory in accordance with ISO 8502-6. ,

Dust Level achived as per SAES H001 & Adhesion Test conducted and found satisfactory as required in the SAMSS

DATE: 12/05/2023

SAMPLE SURFACE PREPARATION REPORT



شركة الرشيد درسر للصمامات والأجهزة المحدودة
Dresser Al Rushaid Valve & Instrument Co., Ltd.
 C.R. 2055001111-Paid up Capital SR. 2,000,000 رأس المال المدفوع ٢,٠٠٠,٠٠٠ ريال سعودي
 Tel.: (03) 341-0278 - Fax: (03) 341-7624 تليفون: ٣٤١٠٢٧٨ - فاكس: ٣٤١٧٦٢٤ (٠٣)



SURFACE PREPARATION REPORT

CUSTOMER:

DATE:

CUSTOMER P.O.:

Dresser Ref.:

PROJECT NAME:

Valve Tag No.	Part	Substrate Temperature (°C)	Relative Humidity (%)	Dew Point (°C)	Anchor Profile (µm)	Degree of Cleanliness
J55-PCV-1017A	BODY	25.62	53.62	13.3	52	SSPC-SP-10/SA 2 1/2
J55-PCV-1018A	BODY	24.99	51.22	13.3	49	SSPC-SP-10/SA 2 1/2
J55-PCV-1019A	BODY	26.83	50.78	13.3	50	SSPC-SP-10/SA 2 1/2
J55-PCV-1023A	BODY	27.42	53.29	13.3	52	SSPC-SP-10/SA 2 1/2
J55-PCV-1043A	BODY	25.19	56.23	13.3	52	SSPC-SP-10/SA 2 1/2
J55-PCV-1053A	BODY	23.67	54.21	13.3	51	SSPC-SP-10/SA 2 1/2
J55-PCV-1073A	BODY	24.55	53.76	13.3	49	SSPC-SP-10/SA 2 1/2
J55-PCV-1083A	BODY	24.52	58.55	13.3	53	SSPC-SP-10/SA 2 1/2
J55-PCV-1093A	BODY	26.30	54.19	13.3	53	SSPC-SP-10/SA 2 1/2
J55-PCV-1113A	BODY	26.51	56.32	13.3	52	SSPC-SP-10/SA 2 1/2
J55-PCV-1153A	BODY	26.33	55.11	13.3	49	SSPC-SP-10/SA 2 1/2
J55-PCV-1153B	BODY	27.82	51.00	13.3	52	SSPC-SP-10/SA 2 1/2
J55-PCV-1173A	BODY	26.87	54.68	13.3	51	SSPC-SP-10/SA 2 1/2
J55-PCV-2023A	BODY	26.73	56.32	13.3	50	SSPC-SP-10/SA 2 1/2
J55-PCV-3003A	BODY	23.57	53.55	13.3	51	SSPC-SP-10/SA 2 1/2
J55-PCV-2048	BODY	24.55	54.98	13.3	52	SSPC-SP-10/SA 2 1/2
J55-PCV-2068	BODY	24.93	50.49	13.3	49	SSPC-SP-10/SA 2 1/2

Remarks:-

All accessible cast surface are examined and found meeting the requirements of MSS SP 55 example A requirements
 All blast surfaces are checked and ad found meeting SSPC-SP-10 requirements.

Salt Contamination test conducted. Salt content:0.8 mg/cm2

Q.A.Inspector
Fahad Ahamad

Customer Inspector



Certificate of Proficiency

CSWIP CERT NO 547931

This is to certify that

Fahad Ahmad

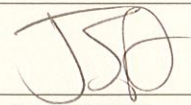
Date of birth: 5 March 1989

has demonstrated proficiency as a BGAS-CSWIP Painting Inspector Grade 2 in accordance with CSWIP requirements published in Document BGAS-CSWIP-BG-22-12, 2nd Edition, April 2019 and amendments in force on the examination date.

Date of Issue: 14 November 2023

Date of Expiry: 24 August 2028

Signed


(For CSWIP)

SIGNATURE OF HOLDER

(Person named above)

Date

**NEW EMPLOYERS SHOULD ALWAYS ASK TO SEE THE CERTIFICATE HOLDER'S
TWI CERTIFICATION LTD IDENTITY CARD, AND VERIFY CERTIFICATE VALIDITY AT WWW.CSWIP.COM**

PLEASE READ THE NOTES OVERLEAF

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This certificate is the property of TWI Certification Ltd and must be surrendered on request

Hempel's Galvosil 15780

Product characteristics

Description

Hempel's Galvosil 15780 is a two-component, medium-zinc, solvent-borne, selfcuring inorganic zinc silicate coating. Applicable by airless spray.

Hempel's Zinc metal pigment 97170 is in full compliance with ISO 3549 and ASTM D520 type II.

Recommended use

As a general purpose rust-preventing primer in paint systems for long-life protection of steel exposed to moderately to severely corrosive environment. In compliance with SSPC-Paint 20, type 1, level 2.

Service temperature:

- Without topcoat: maximum, dry, atmospheric exposure: 540°C [1004°F].
- Wet service temperatures: Please consult the Chemical protection guide at hempel.com.

Product safety

Flash point 14°C [57°F]

VOC content mixed product

Legislation	Value
EU	471 g/L [3.93 lb/US gal]
US (coatings)	471 g/L [3.93 lb/US gal]
US (regulatory)	471 g/L [3.93 lb/US gal]
China	471 g/L [3.93 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website. According to EPA Method 24.

Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

Product data

Product code

15780

Product components

Base 15789
Zinc 97170

Standard shade / code

Grey 19840

Gloss

Flat

Volume solids

62 ± 2%

Specific gravity

2.3 kg/L [19 lb/US gal]

Reference dry film thickness

50 micron [2.0 mils]

Surface preparation

Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.

New build:

- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

Maintenance and Repair

- According to Hempel's Specification.

Roughness

- Surface profile Medium (G) (ISO 8503-2).

Consult Hempel's separate Surface Preparation Guidelines for more details.

Hempel's Galvosil 15780

Application

Mixing ratio

Base 15789 : Zinc 97170
(4.2 : 5.8 by weight)

Products containing floating or settling particles/pigments need to be continuously stirred during application. This is especially important in case of heavy thinning.

Thinner

Hempel's Thinner 08700
Hempel's Accelerator & Thinner 0870M

Cleaner

Hempel's Thinner 08700

Pot life

Product temperature	20°C [68°F]
Pot life	4 hours

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	10%	Nozzle pressure: 100 bar [1500 psi] Nozzle orifice: 0.019-0.023"
Air spray	10%	Not Applicable.
Brush	10%	Not Applicable.

To minimise dry spray at high temperatures, extra thinning may be necessary. If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

Film thickness

Specification range	Low	High	Recommended
Dry film thickness	50 micron [2.0 mils]	80 micron [3.1 mils]	50 micron [2.0 mils]
Wet film thickness	80 micron [3 mils]	130 micron [5 mils]	80 micron [3 mils]
Theoretical spreading rate	12 m²/L [490 sq ft/US gal]	7.7 m²/L [310 sq ft/US gal]	12 m²/L [490 sq ft/US gal]

Application conditions

- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above 0°C [32°F] during application and curing.
- Surface temperature must be below 40°C [104°F] during application and curing.

Relative Humidity:

- Relative humidity must be above 50% during curing.

Application remarks

- Consult Hempel's Application Guidelines and Instructions for more details.

Drying and overcoating

Product compatibility

- Previous coat: None.
- Subsequent coat: According to Hempel's Specification.

Drying time

Surface temperature		20°C [68°F]
Touch dry	min	15
Fully cured	hours	16

Determined for dry film thickness 50 micron [2.0 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Overcoating

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

Hempel's Galvosil 15780

Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

Overcoating details

- Remove zinc salts or other contamination before overcoating.
- Flash-coat technique is recommended when overcoating Galvosil qualities.
- Inorganic zinc silicates must be fully cured before overcoating.

Storage

Shelf life

Ambient temperature	25°C [77°F]
Base	6 months
Zinc	36 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

Storage conditions

- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.
- Must be stored under absolutely dry conditions, protect against seeping humidity.

Additional documents

Additional information is available at the Hempel website <https://www.hempel.com/service-and-support/technical-guidelines> or at your local Hempel website:

- Explanatory Notes for Product Data Sheet.
- Application methods.
- General Application Guidelines

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3.	PDS	This document
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5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

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Hempadur Mastic 45881

Product characteristics

Description

Hempadur Mastic 45881 is a polyamide curing, high solids epoxy paint. It forms a hard and tough coating, and has good wetting properties.

Complies with EU Directive 2004/42/EC, The Paints Directive on the limitation of volatile organic compounds: subcategory j.

Recommended use

Hempadur Mastic 45881 is recommended as a self-primed, surface tolerant paint system, or as an intermediate or a topcoat in heavy duty paint systems where low VOC and high film build are required. The product can be used where extended recoating properties for polyurethane topcoats are requested. It may also be used directly on zinc silicate or spray metallized surfaces. The product can be used for minor repairs in immersed areas.

Service temperature:

- Maximum, dry exposure only: 120°C [248°F].

Certificates / Approvals

- EC-type examined as a low flame spread material when used as part of a predefined paint system. Please refer to "Declaration of Conformity" on hempel.com for further details.
- Complies with US FDA and EU food regulations for contact with dry foodstuff. Consult Hempel for details.

Features

- Versatile.
- High surface tolerance.

Product safety

Flash point 39°C [102°F]

VOC content mixed product

Legislation	Value	5% thinning, by volume	Limit value, phase II (2010) ^a
EU	218 g/L [1.82 lb/US gal]	250 g/L [2.09 lb/US gal]	500 g/L [4.17 lb/US gal]
US (coatings)	218 g/L [1.82 lb/US gal]	-	-
US (regulatory)	218 g/L [1.82 lb/US gal]	-	-
China	218 g/L [1.82 lb/US gal]	-	-

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9. ^aEU Directive 2004/42/CE.

Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

Product data

Product code

45881

Product components

Base 45889

Curing Agent 95881

Standard shade* / code

Light grey 12170 **

Gloss

Semi-gloss

Volume solids

80 ± 2%

* Other shades are available, including shades containing MIO. Please contact your local Hempel representative.

** Slight discolouration may occur. This does not affect the performance of the coating.

Hempadur Mastic 45881

Specific gravity

1.5 kg/L [12 lb/US gal]

Reference dry film thickness

125 micron [4.9 mils]

Aluminium shade / code

Aluminium grey 19002 *

Gloss

Please consult Hempel's Guideline on aluminium pigmented coatings.

Volume solids

72 ± 2%

Specific gravity

1.3 kg/L [11 lb/US gal]

Reference dry film thickness

125 micron [4.9 mils]

Surface preparation

Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.

New build:

- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Concrete: According to Hempel's Specification.
- Remove dust, blast media and loose materials.

Maintenance and Repair

- Spot abrasive blasting to min. PSa 2 (ISO 8501-2) / SP 6 (SSPC).
- Minor areas may be hand or power tool cleaned instead of abrasive blasting.
- Water jetting to min. Wa 2 (ISO 8501-4).
- Flash rust degree of maximum FR M (ISO 8501-4).
- Remove dust, blast media and loose materials.

Roughness

- Surface profile Medium (G) (ISO 8503-2).

Consult Hempel's separate Surface Preparation Guidelines for more details.

Application

Mixing ratioBase 45889 : Curing Agent 95881
(3 : 1 by volume)

Stir well before use.

Thinner

Hempel's Thinner 08450

Cleaner

Hempel's Tool Cleaner 99610

Pot life

Product temperature	20°C [68°F]	30°C [86°F]
Pot life	2 hours	1½ hours

Application method

Tool	Application parameters
Airless spray	Nozzle pressure: 250 bar [3600 psi] Nozzle orifice: 0.017-0.023"
Brush	Not Applicable.
Roller	Not Applicable.

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

Hempadur Mastic 45881

Film thickness

Specification range	Low	High	Recommended
Dry film thickness	100 micron [3.9 mils]	200 micron [7.9 mils]	125 micron [4.9 mils]
Wet film thickness	125 micron [5 mils]	250 micron [10 mils]	150 micron [6 mils]
Theoretical spreading rate	8 m ² /L [330 sq ft/US gal]	4 m ² /L [160 sq ft/US gal]	6.4 m ² /L [260 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. For best performance, avoid excessive film thickness.

Application conditions

- Temperature of product must be above 15°C [59°F] during application.
- Surface temperature must be above 15°C [59°F] during application and curing.
- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.

Relative Humidity:

- Relative humidity must be below 85% during drying and curing.

Drying and overcoating

Product compatibility

- Previous coat: None or according to Hempel's specification.
- Subsequent coat: None or according to Hempel's specification.

Drying time

Surface temperature		20°C [68°F]
Hard dry	hours	4
Fully cured	days	7

Determined for dry film thickness 125 micron [4.9 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		20°C [68°F]	30°C [86°F]	40°C [104°F]
Atmospheric medium				
Hempadur Mastic 45881	Min Max	7 h Ext*	5½ h Ext	3½ h Ext
Hempathane HS 55610	Min Max	6 h Ext*	5 h Ext	3 h Ext
Atmospheric severe				
Hempadur Mastic 45881	Min Max	10 h Ext*	8 h Ext	5 h Ext
Hempathane HS 55610	Min Max	10 h 72 h	8 h 54 h	5 h 36 h

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

Overcoating details

- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- The surface must be dry and clean prior to application.

Other remarks

- Epoxy coats have an inherent tendency of chalking in outdoor exposure. This does not affect the performance of the coating.
- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Hempadur Mastic 45881

Storage

Shelf life

Ambient temperature	25°C [77°F]
Base	36 months
Curing Agent	36 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

Storage conditions

- Product must be stored according to local legislation, at 40°C [104°F] without direct sunlight and protected from rain and snow.

Additional documents

Additional information is available at the Hempel website <https://www.hempel.com/service-and-support/technical-guidelines> or at your local Hempel website:

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- Application methods.
- General Application Guidelines

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Hempathane Topcoat 55210

Product characteristics

Description

Hempathane Topcoat 55210 is a glossy polyurethane topcoat that is cured with aliphatic isocyanate and delivers good gloss and colour retention.

Complies with EU Directive 2004/42/EC, The Paints Directive on the limitation of volatile organic compounds: subcategory j.

Recommended use

Hempathane Topcoat 55210 is recommended as a finishing coat for protection of structural steel in severely corrosive atmospheric environment, where colour fastness and gloss retention are required.

Service temperature:

- Maximum, dry exposure only: 120°C [248°F].

Certificates / Approvals

- EC-type examined as a low flame spread material when used as part of a predefined paint system. Please refer to "Declaration of Conformity" on hempel.com for further details.
- Complies with the European Fire Standard EN 13501-1, reaction to fire classification, when used as part of a predefined paint system. B-s1, d0.

Features

- For severely corrosive atmospheric environment.
- The minimum temperature for curing is -10°C [14°F].
- Glossy with good gloss and colour retention.

Product safety

Flash point 33°C [91°F]

VOC content mixed product

Legislation	Value	10% thinning, by volume	Limit value, phase II (2010) ^a
EU	446 g/L [3.72 lb/US gal]	483 g/L [4.03 lb/US gal]	500 g/L [4.17 lb/US gal]
US (coatings)	446 g/L [3.72 lb/US gal]	-	-
US (regulatory)	446 g/L [3.72 lb/US gal]		
China	446 g/L [3.72 lb/US gal]		

According to specific legislation, see details in the Explanatory Notes available at Hempel website, hempel.com or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9. ^aEU Directive 2004/42/CE.

Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

Product data

Product code

55210

Product components

Base 55219
Curing Agent 95370

Standard shade* / code

White 10000 **

Gloss

Glossy

Volume solids

51 ± 2%

* Wide range of colours is available via Hempel's Multi-Tint® system.

** Colour stability may be affected by exposure to harsh chemical and/or high temperatures.

Hempathane Topcoat 55210

Specific gravity

1.2 kg/L [10 lb/US gal]

Reference dry film thickness

50 micron [2.0 mils]

Aluminium shade / code

Aluminium grey 19002

Gloss

Please consult Hempel's Guideline on aluminium pigmented coatings.

Volume solids

48 ± 2%

Specific gravity

1.1 kg/L [9 lb/US gal]

Reference dry film thickness

50 micron [2.0 mils]

Surface preparation

Cleanliness

- According to Hempel's Specification.

New build:

- According to Hempel's Specification.

Maintenance and Repair

- According to Hempel's Specification.

Consult Hempel's separate Surface Preparation Guidelines for more details.

Application

Mixing ratioBase 55219 : Curing Agent 95370
(7 : 1 by volume)

Stir well before use.

Thinner

Hempel's Thinner 08080

Cleaner

Hempel's Thinner 08080

Hempel's Thinner 08510

Pot life

Product temperature	10°C [50°F]	20°C [68°F]	30°C [86°F]
Pot life	6 hours	4 hours	2½ hours

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	10%	Nozzle pressure: 150 bar [2200 psi] Nozzle orifice: 0.017-0.019"
Air spray	10%	Not Applicable.

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. To comply with Korean VOC regulation, thinning is limited to max. vol. 1%. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

Hempathane Topcoat 55210

Film thickness

Specification range	Low	High	Recommended
Dry film thickness	40 micron [1.6 mils]	80 micron [3.1 mils]	50 micron [2.0 mils]
Wet film thickness	80 micron [3 mils]	150 micron [6 mils]	100 micron [4 mils]
Theoretical spreading rate	13 m ² /L [530 sq ft/US gal]	6.4 m ² /L [260 sq ft/US gal]	10 m ² /L [410 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. For best performance, avoid excessive film thickness.

Application conditions

- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above -10°C [14°F] during application and curing.
- The film formation may be adversely affected by light rain, high humidity and/or condensation during application and the following interval after application: "10 hours, 20°C/68°F".

Relative Humidity:

- Relative humidity must be below 85% during curing.

Application remarks

- Two coats of the topcoat may be necessary to obtain full hiding power.

Drying and overcoating

Product compatibility

- Previous coat: According to Hempel's Specification. Recommended products are: Hempaprime Multi 500 45950/3, Hempadur Quattro series, Hempadur Avantguard series.
- Subsequent coat: None.

Drying time

Surface temperature		-10°C [14°F]	0°C [32°F]	20°C [68°F]	40°C [104°F]
Touch dry	hours	2½	1½	¾	½
Surface dry	min	-	-	60	-
Fully cured	days	-	-	7	-

Determined for dry film thickness 50 micron [2.0 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		-10°C [14°F]	0°C [32°F]	20°C [68°F]	40°C [104°F]
Atmospheric medium					
Hempathane Topcoat 55210	Min Max	30 h Ext*	18 h Ext	6 h Ext	100 min Ext

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.
- Condensation on the freshly applied coating should be avoided.

Overcoating details

- The surface must be dry and clean prior to application.

Other remarks

- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Hempathane Topcoat 55210

Storage

Shelf life

Ambient temperature	25°C [77°F]
Base	36 months
Curing Agent	24 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

Storage conditions

- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.
- The curing agent is sensitive to moisture. Store in a dry place and keep the can tightly closed until use.

Additional documents

Additional information is available at the Hempel website <https://www.hempel.com/service-and-support/technical-guidelines> or at your local Hempel website:

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- Application Instruction for this product.

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Hempadur 85671

Product characteristics

Description

Hempadur 85671 is an amine adduct cured, phenolic epoxy (novolac) coating with very good adhesion and excellent chemical and high temperature resistance.

Recommended use

Lining: As interior lining in tanks, pipelines, railcars, etc. for hot water, brine, crude oil, vegetable oils and other chemicals as per the Chemical protection guide (only valid for shades 11150 & 50900).

Process vessels and pipework: As external coating for the protection of insulated (CUI) and uninsulated process pipework and vessels including cryogenic conditions.

Subsea equipment: As corrosion protection for hot subsea equipment and structures according to NORSOK system 7C.

Service temperature:

- From -196°C [-321°F] up to 205°C [401°F] for dry or dry/wet exposure.
- Maximum, in water (no temperature gradient): 95°C [203°F].
- Other liquids: Please contact Hempel.
- Please consult the Chemical protection guide at [hempel.com](https://www.hempel.com).

Certificates / Approvals

- Approved by WRAS for contact with potable water. Please consult <https://www.wrasapprovals.co.uk/approvals-directory/?search=Hempel&page=0> for detailed information.
- Complies with US FDA and EU food regulations for contact with liquid and dry foodstuff. Consult Hempel for details.
- Meets requirements to NORSOK M-501 when used as part of a predefined paint system. Edition 6, System 3C, 3D, 3E, 3F, 7C.
- Tested and assessed according to Aramco SAES-H-101. APCS 2A, 2B, 2C.

Product safety

Flash point 26°C [79°F]

VOC content mixed product

Legislation	Value
EU	317 g/L [2.65 lb/US gal]
US (coatings)	317 g/L [2.65 lb/US gal]
US (regulatory)	317 g/L [2.65 lb/US gal]
China	317 g/L [2.65 lb/US gal]

According to specific legislation, see details in the Explanatory Notes available at Hempel website, [hempel.com](https://www.hempel.com) or at your local Hempel website. VOC values may vary with shade, please consult the Safety Data Sheet, section 9.

Handling

Handle with care. Before and during use, observe safety labels on packaging and paint containers and follow all local and national safety regulations. Always consult Hempel's Safety Data Sheet for this product along with the Product Data Sheet.

For professional use only.

Product data

Product code

85671

Product components

Base 85675
Curing Agent 97371

Standard shade* / code

Light grey 11150 **

Gloss

Flat

Volume solids

68 ± 2%

Specific gravity

1.7 kg/L [14 lb/US gal]

Reference dry film thickness

100 micron [3.9 mils]

* Other shades are available, please contact your local Hempel representative.

** Slight discolouration may occur. This does not affect the performance of the coating.

Hempadur 85671

Aluminium shade / code

Aluminium grey 19000

Gloss

Please consult Hempel's Guideline on aluminium pigmented coatings.

Volume solids

67 ± 2%

Specific gravity

1.7 kg/L [14 lb/US gal]

Reference dry film thickness

100 micron [3.9 mils]

Surface preparation

Cleanliness

- Remove oil, grease and other contaminants by suitable detergent cleaning.
- Remove salts, detergents and other contaminants by high pressure fresh water cleaning.
- Concrete: According to Hempel's Specification.

New build:

- Abrasive blasting to min. Sa 2½ (ISO 8501-1) / SP 10 (SSPC).
- Remove dust, blast media and loose materials.

Maintenance and Repair

- Spot abrasive blasting to min. PSa 2½ (ISO 8501-2) / SP 10 (SSPC).
- Water jetting to Wa 2½ (ISO 8501-4).
- Flash rust degree of maximum FR M (ISO 8501-4).
- Remove dust, blast media and loose materials.

Roughness

- Surface profile Medium (G) (ISO 8503-2).

Consult Hempel's separate Surface Preparation Guidelines for more details.

Application

Mixing ratio

Base 85675 : Curing Agent 97371
 (8.8 : 1.2 by volume)

Stir well before use.

Thinner

Hempel's Thinner 08450
 Hempel's Thinner 08630

Cleaner

Hempel's Tool Cleaner 99610

Pot life

Product temperature	15°C [59°F]	20°C [68°F]	30°C [86°F]
Induction time	20 min	15 min	5 min
Pot life	3½ hours	3 hours	1 hour

Application method

Tool	Thinning max vol.	Application parameters
Airless spray	10%	Nozzle pressure: 200 bar [2900 psi] Nozzle orifice: 0.017-0.021"
Brush	10%	Not Applicable.

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. As tank lining, brush and roller application must only be limited to stripe coating and touch up areas or minor repairs. Spray data are indicative and subject to adjustment. Pressure is for a material temperature of 20°C [68°F].

Hempadur 85671

Film thickness

Specification range	Low	Recommended	High
Dry film thickness	90 micron [3.5 mils]	100 micron [3.9 mils]	160 micron [6.3 mils]
Wet film thickness	130 micron [5 mils]	150 micron [6 mils]	230 micron [9 mils]
Theoretical spreading rate	7.5 m ² /L [310 sq ft/US gal]	6.8 m ² /L [280 sq ft/US gal]	4.2 m ² /L [170 sq ft/US gal]

Product may be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate, drying and curing time and overcoating interval. For best performance, avoid excessive film thickness.

Application conditions

- Temperature of product must be above 15°C [59°F] during application.
- To avoid condensation, apply on a clean and dry surface with a temperature that is at least 3°C [5°F] above the dew point.
- Surface temperature must be above 10°C [50°F] during application and curing.

Relative Humidity:

- Relative humidity must be below 80% during curing.
- Relative humidity must be below 80% during application.

Drying and overcoating

Product compatibility

- Previous coat: None or according to Hempel's specification.
- Subsequent coat: None or according to Hempel's specification.

Drying time

Surface temperature		10°C [50°F]	20°C [68°F]	30°C [86°F]	40°C [104°F]
Touch dry	hours	6	2	1½	1
Surface dry	hours	6	3	1½	1
Hard dry	hours	11	6½	3	1½
Fully cured	days	13	7	5	3

Determined for dry film thickness 100 micron [3.9 mils] at standard conditions, see Hempel's Explanatory Notes for details.

Overcoating

Hempel's specification supersedes any guidelines indicated in the overcoating table

Quality name		10°C [50°F]	20°C [68°F]	30°C [86°F]	40°C [104°F]
Atmospheric severe					
Hempadur 85671	Min	25 h	16 h	8 h	5 h
	Max	47 d	21 d	10 d	6½ d
Immersion					
Hempadur 85671	Min	25 h	16 h	8 h	5 h
	Max	47 d	21 d	10 d	6½ d

Overcoating times are indicative for products of the same generic chemistry. Consult Hempel's specification for more information.

Drying conditions

- To obtain the drying time stated, it is important to maintain sufficient ventilation during application, drying and curing.

Overcoating details

- If the maximum overcoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.
- The surface must be dry and clean prior to application.

Other remarks

- Epoxy coats have an inherent tendency of chalking in outdoor exposure. This does not affect the performance of the coating.
- Hempel's Specification supersedes any recommendations given in the Product Data Sheets.

Storage

Shelf life

Ambient temperature	25°C [77°F]	35°C [95°F]
Base	12 months	9 months
Curing Agent	12 months	8 months

Shelf life from date of production, when stored in original, unopened containers. Thereafter, the product quality must be re-inspected. Storage at elevated temperatures may reduce shelf life. For advice, please consult Hempel.

Hempadur 85671

Storage conditions

- Product must be stored according to local legislation, at maximum 40°C [104°F], without direct sunlight and protected from rain and snow.

Additional documents

Additional information is available at the Hempel website <https://www.hempel.com/service-and-support/technical-guidelines> or at your local Hempel website:

- Explanatory Notes for Product Data Sheet.
- Application methods.
- General Application Guidelines

This Product Data Sheet ("PDS") relates to the supplied product ("Product") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at www.hempel.com (the "Additional documents"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from www.hempel.com.

Hempel shall not be liable for defects where the application of the Product has not been made fully in accordance with the recommendations and requirements set out in the relevant PDS and the Additional Documents. The information and terms of this disclaimer apply to this PDS, the Additional documents and any other documents supplied by Hempel in respect of the Product. In addition, the Product is supplied and all technical assistance is given subject to Hempel's General Conditions of Sale, Delivery and Service, unless otherwise expressly agreed in writing.