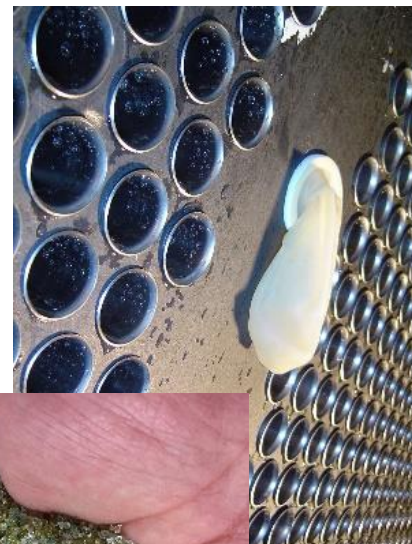


从甲方角度看涂装QA/QC

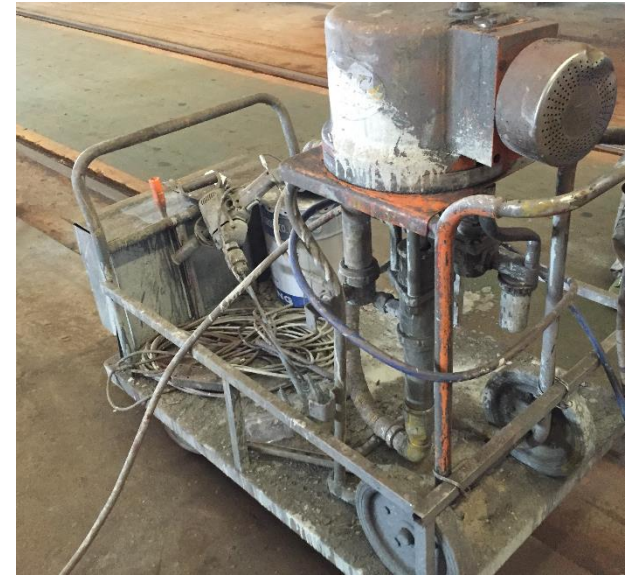
质量保证/质量控制

杨福辰
(NACE-CIP3)



满足合同要求

- 熟悉合同
- 熟悉涂层施工技术规格书
- 熟悉测试标准
- 熟悉测试及环境要求
- 熟悉涂层技术数据



Inspection and testing

Test type	Method	Frequency	Acceptance criteria	Consequence
Environmental conditions	Ambient and steel temperature. Relative humidity. Dew point.	Before start of each shift + minimum twice per shift.	In accordance with specified requirements	No blasting or coating
Visual examination	Visual for sharp edges weld spatter slivers, rust grade, etc. ISO 8501-3	100 % of all surfaces	No defects, see specified requirements	Defects to be repaired
Cleanliness	a) ISO 8501-1 b) ISO 8502-3	a) 100 % visual of all surfaces b) Spot checks	a) In accordance with specified requirements b) Maximum quantity and size rating 2	a) Reblasting b) Recleaning and retesting until acceptable
Salt test	ISO 8502-6 and ISO 8502-9	Spot checks	Maximum conductivity corresponding to 20 mg/m ² NaCl	Repeated washing with potable water and retesting until acceptable
Roughness	Comparator, stylus instrument or testex tape (see ISO 8503)	Each component or once per 10 m ²	As specified	Reblasting
Curing test (for Zn silicate).	ASTM D4752	Each component or once per 100 m ²	Rating 4 to 5	Allow to cure
Visual examination of coating	Visual to determine curing, contamination, solvent retention, pinholes/popping, sagging and surface defects	100 % of surface after each coat	According to specified requirements	Repair of defects
Holiday detection	ISO 29601. Voltage, see table 1	As per coating system specification	No holidays	Repair and retesting.
Film thickness	ISO 19840. Calibration on a smooth surface	ISO 19840	ISO 19840, and coating system data sheet	Repair, additional coats or recoating as appropriate
Adhesion	ISO 4624, using equipment with an automatic centred pulling force, and carried out when coating system are fully cured	Spot checks	See notes below	Coating to be rejected



- 不熟悉合同
- 不熟悉测试标准
- 不熟悉常规工业涂装要求

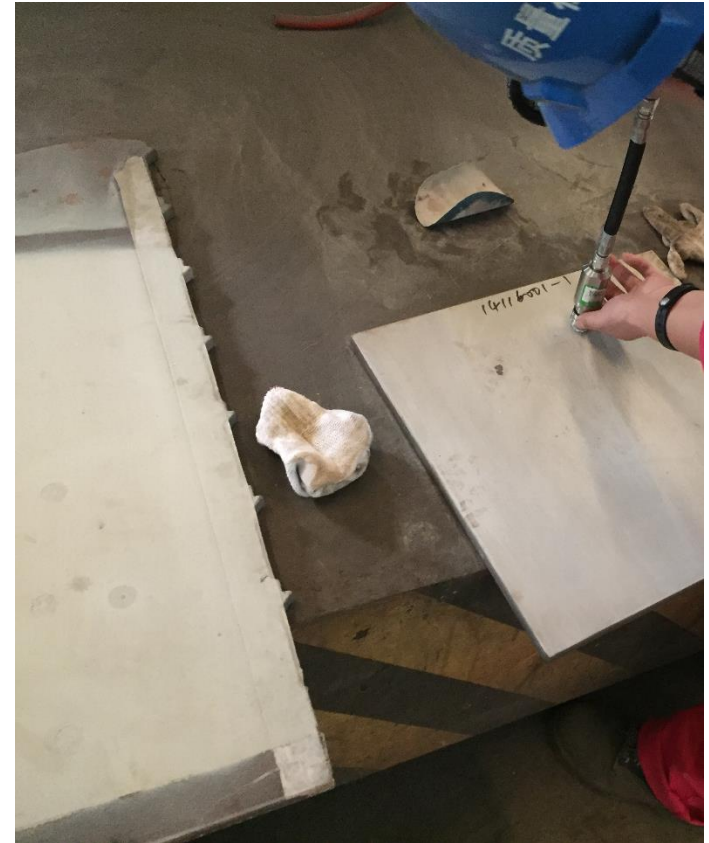


SSPC: The Society for Protective Coatings Paint Application Standard No. 2

Procedure for Determining Conformance to Dry
Coating Thickness Requirements



案例 -1



考虑按合同返工及
赔偿损失



- 不熟悉合同
- 不熟悉涂层技术规格书
- 不熟悉常规工业涂装要求



SSPC: The Society for Protective Coatings

SURFACE PREPARATION SPECIFICATION

SSPC-SP 16

Brush-Off Blast Cleaning of Coated and Uncoated
Galvanized Steel, Stainless Steels, and Non-Ferrous Metals





案例 -2



按合同返工及赔偿损失，除名





张文奇教授

