

COATING SPECIFICATION

COATING PROCEDURES FOR CLEAN SKIN STEEL PIPE PERMANENTLY EXPOSED TO ATMOSPHERE

COATING SPECIFICATION: M3

ISSUE: 4

DATE: OCTOBER 2022

1.0 SCOPE

This document summarises the coating procedure for the following scenarios as shown in **Figure 1**.

- (1) Carbon Steel, requiring no colour.
- (2) Carbon Steel, requiring colour.

The recommended Water Corporation Specifications for the carbon steel pipes are as follows:

Scenario 1:

- Clean skin carbon steel pipe permanently exposed to atmosphere requiring no colour.

A1 -	Surface Preparation for the Application of Protective Coatings on Steel or Cast Iron
B1 -	Inorganic Zinc Silicate Coating on Steel or Cast Iron

Scenario 2:

- Clean skin carbon steel pipe permanently exposed to atmosphere requiring a colour top coat.

Scenario 2:

A1 -	Surface Preparation for the application of Protective Coatings on Steel or Cast Iron
C2 -	Zinc Rich Epoxy Primer, Epoxy Mastic Coat, Polyurethane Top Coat on Steel or Cast Iron

Note:

If anti-graffiti properties are required, replace the specified top coat with 2 coats of 50 microns nominal dry film thickness “Anti-graffiti Polyurethane” with a total thickness of 100 microns as described in Corporation Coating Specification J1.

Refer Design Standard, DS 95 (Standard for the Selection, Preparation, Application, Inspection and Testing of Protective Coatings on Water Corporation Assets) for additional information or clarification.

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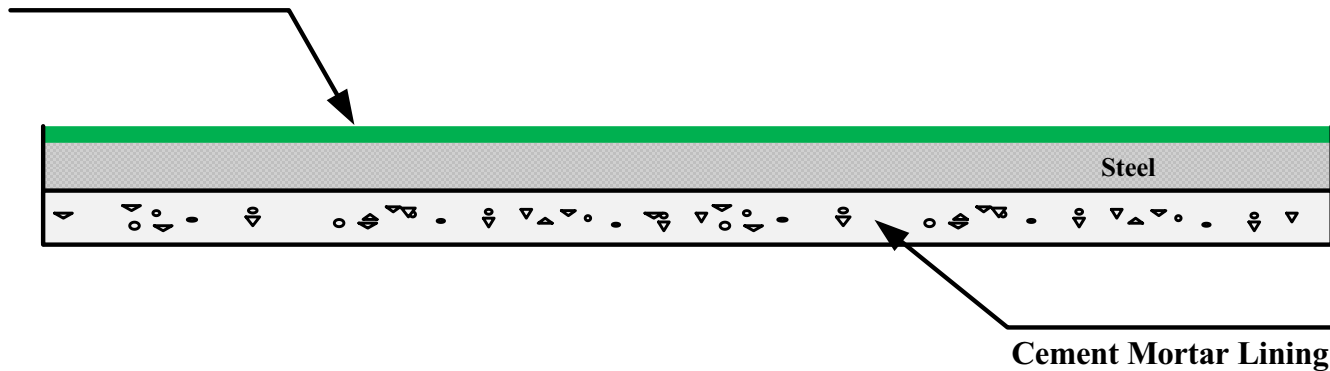
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On Steel Surface:

Surface Preparation Spec : A1

Coating Spec on Steel Pipe: B1 (IZS Grey colour Primer coat only)

Coating Spec on Steel Pipe: C2 (When colour top coat is required)



Note: Colours in the above diagram is indicative only, standard pipeline coating colours to be used.

Figure 1 - Coating for clean skin steel pipe permanently exposed to atmosphere.

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Document Revision History					
Sect	Ver / Rev	Date	Revision Description	RVWD	APROV
1	1/0	13/10	Formating update	AO	SS

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