

SPECIFICATIONS - DETAILED PROVISIONS
Section 09940 - Epoxy Coating

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**SECTION 09940
EPOXY COATING**

PART 1 - GENERAL

1.01 REQUIREMENT

Where specified or shown, an epoxy coating shall be applied as specified herein.

PART 2 - PRODUCTS

2.01 MATERIAL

The material used shall be 100 percent (100%) powder epoxy and shall be Dow Corning DC 3100, Furane Plastics Co. No. 268, Three-M Company "Scotchcoat," Michigan Chrome and Chemical Company "Micron 650 or 651," or approved equal.

PART 3 - EXECUTION

3.01 SURFACE PREPARATION

The surface shall be blast-cleaned in accordance with SSPC-SP-5 (White Metal Blast Cleaning). The grit size used shall be as recommended by the epoxy manufacturer.

3.02 APPLICATION

Application of the epoxy coating shall be in accordance with the manufacturer's instructions.

3.03 THICKNESS OF COATING

The minimum dry coating thickness shall be 8 mils, provided, however, that the thickness of coating in the grooves for valves or fittings designed to receive a rubber gasket shall be approximately 5 mils.

3.04 INSPECTION

Coating thickness shall be checked with a nondestructive magnetic type thickness gage. Coating integrity shall be tested with a spark testing unit operating at approximately 2,000 volts. All pinholes shall be marked, repaired, and retested. No pinholes or other irregularities will be permitted in the final coating.

3.05 FIELD REPAIRS

If small local repairs are necessary, they shall be made using Keysite 740, or approved equal. The surface must first be solvent-cleaned in accordance with SSPC-SP-1 (Solvent Cleaning).

END OF SECTION 09940

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