# SEALID®-Tape All-in-1

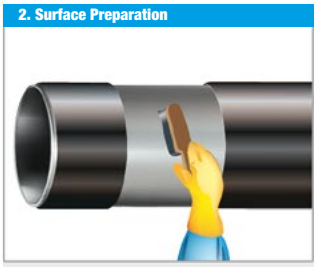
## Notes

- Prepare the surface appropriately
- Steel surface
  Cleanliness (ISO 8501-1) min. ST2/SA2½
  Roughness (ISO 8503-1) 50–100 µm
- The pipeline section must be coated immediately after blasting and no more than two hours later.
- For tape widths >50mm we recommend the use of DEKOMAT® wrapping machine for easier application.
- The following application instruction can also be transferred to the wrapping of full pipe length or pipe bends.
- Meet the standards:
  - Minimum overlap
    ISO 21809-3, Type 12A-2: min. 50%
    EN 12068, Classe C50: min. 67%
  - The characteristic values were determined in accordance with the standards on a blasted surface (SA 2½).
- In order to avoid wrinkling due to thermal elongation of the carrier film, the temperature difference between pipe surface (before and after tape application) and tape roll should be max. +25°C (+45°F).
  In the case of several days of strong sunlight exposure, the finished wrapping should be covered with a suitable material (e.g. BUTYLEN-DRM PP Rockshield).

## 1. Cleaning and Drying

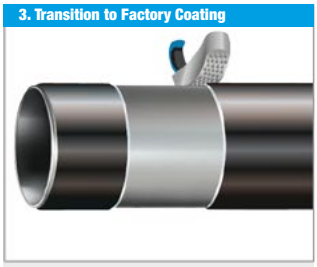

- The areas to be coated (steel surface and adjacent factory coating) have to be clean, dry, and free from grease and dust.
- Humidity and ice have to be removed by drying with a torch flame.
- All contamination which might act as a release agent (e.g. grease, oil, varnishes, temporary protecting paints, coupling agents) have to be completely removed prior to tape application.

## 2. Surface Preparation



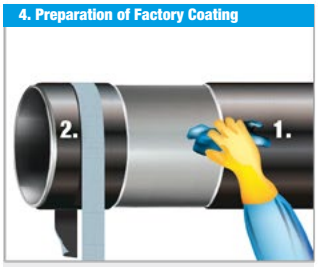
- The surface must be adequately prepared and have a degree of cleanliness of at least ST2/SA2½ (do not polish the surface)
- Any existing mill scale has to be removed by abrasive blast cleaning.

## 3. Transition to Factory Coating



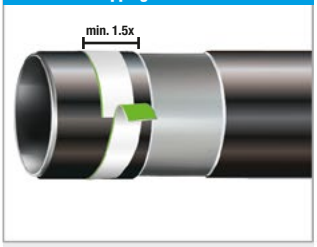
- Transitions to adjacent factory coating should be bevelled by use of a round shaped rasp (recommended angle: ≤ 30°).
  Remove grinding dust.

## 4. Preparation of Factory Coating



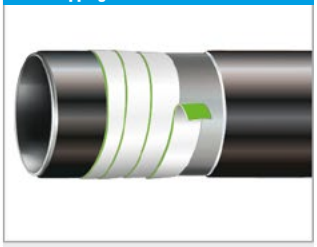

- Adjacent factory coating has to be circumferentially roughened as minimum in double tape width with coarse emery cloth.
- Remove grinding dust and then clean properly.

## 5a. Initial Wrapping Position




- Wrap with the green side of the tape facing the surface of the pipe under uniform tension.
- Sufficient tape tension is applied if tape width is narrowed by app. 1% during application.
- Remove release liner.
- The tape is applied to the factory coating with the outer edge of the tape at a distance of at least 1.5 times the tape width from the surface of the steel pipe. The start of the tape must point to the underside of the pipe (8-10 o'clock position).
- **The first wrap must be done with a complete overlap (100%).**

## 5b. Wrapping

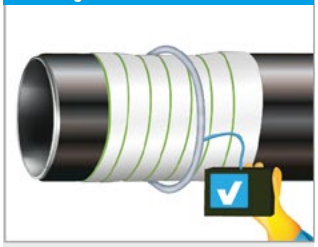


- Spirally apply the following wraps with the above-mentioned minimum overlap.

## 5c. Final Wrapping Position


- The end of the wrapping is done on the factory coating with the outer edge of the tape at a distance of at least 1.5 times the tape width from the surface of the steel pipe.
- The last wrap has to be done with a complete overlap (100%). The tape must end at the same level as the tape started but on the opposite side of the pipe.

## 6. Testing



- No wrinkles are allowed in the finished wrapping based on visual inspection.
- The wrapping has to be tested for absence of porosity with high voltage holiday detector. Test voltage: 5 kV + 5 kV per mm of coating thickness, max. 25 kV.

| Product | Coating application temperatures °C *(°F)* | | | Max. temperature difference between the surface and the material °C *(°F)* | Storage temperature °C *(°F)* |
|---|---|---|---|---|---|
| | Material | Pipe surface | Environment | | |
| **SEALID®-Tape** | +20 to +50 *(+68 to +122)* | > +5 *(+41)* and min. +3 (+5,4) above dew point | -40 to +60 *(-40 to +140)* | < +25 *(< +45)* | ≤ +40 *(≤ +104)* |
| **Surface preparation** | The specific application instructions must be followed. | | | | |
| **Health, safety & environmental protection** | The application must comply with all environmental & safety regulations locally applicable.<br>All safety and environmental instructions on product labels and safety data sheets must be applied.<br>Wear personal protective equipment such as safety goggles, safety gloves and appropriate work clothing.<br>Cover the ground to protect against contamination. | | | | |

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