

NAPCA Bulletin 6-69-94-1

SUGGESTED PROCEDURES FOR HAND WRAPPING FIELD JOINTS USING HOT ENAMEL

1. **General**

- a. These specifications may be used in whole or in part by anyone without prejudice, if recognition of the source is included. The National Association of Pipe Coating Applicators (NAPCA) assumes no responsibility for the interpretation or use of these specifications.
- b. The intended use of these coatings is to provide corrosion protection for buried pipelines. Above ground storage of coated pipe in excess of 6 months without additional Ultraviolet protection is not recommended.
- c. The following definitions apply:
 - i. Applicator - The contractor who applies the coating to the pipe.
 - ii. Company - The purchaser of the coated pipe or the entity for whom the Applicator coats the pipe.
 - iii. SSPC - The Steel Structures Painting Council.
 - iv. NACE - NACE International.
 - v. Manufacturer - The company that makes the coating materials which are applied to the pipe.

2. **Scope**

- a. The Applicator shall furnish all labor, equipment and material required, shall prepare all surfaces to be coated and shall apply the coating to all surfaces to be coated.
- b. These specifications are intended to cover the minimum requirements for application of hot coal tar enamel to field welds during pipeline construction.

3. **Coating Material**

- a. All coating materials, including repair or patch materials, purchased or used under these specifications, shall be packaged in suitable and approved containers. The containers shall be plainly marked with the name of the Manufacturer, type of material and batch or lot number where applicable. Bulk shipments shall be allowed provided the above information is included in the bill of lading.
- b. The coating material shall be packaged in containers suitable to keep the contents clean and dry during handling, shipping and storage. Storage and handling conditions shall be in accordance with the Manufacturer's recommendations.
- c. Precautions shall be taken during the handling, shipping and storage of all materials to prevent damage to the containers that would result in contamination of the coating materials. All contaminated, or otherwise damaged materials shall be discarded.

4. **Surface Preparation**

- a. The surface to be coated must be cleaned of all rust, mud, oil, grease, moisture, mill lacquer or other deleterious substances. Wire brushing and/or solvent washing is sufficient in most instances. Weld splatter should be removed by filing.

