General

BC Pipe Dressing-22 (PD-22) is a surface-drying type anti-corrosive coating possessing outstanding resistance to high temperature. As such, it is particularly suitable for steam lines, windlass cylinder blocks, deck winch and etc.

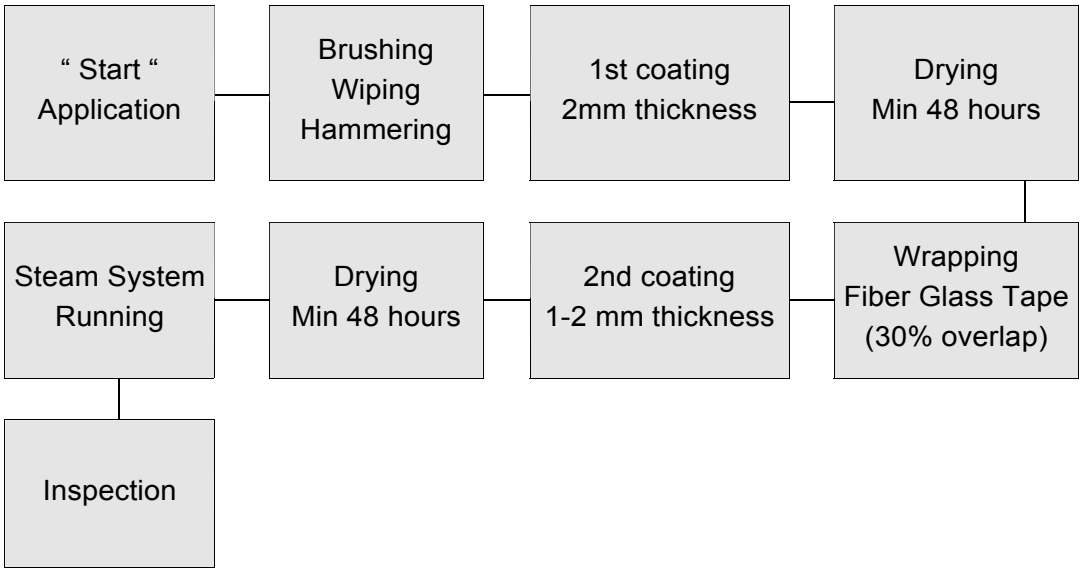
Characteristics

- **S**uperior long-term corrosion protection.
- **G**reat efficiency with quick & easy application.
- **N**o changes in quality under extremely high temperatures.
  (temperature range -60 ~ 230℃)
- **C**ontains no solvents.
- **H**ygienically harmless and non-polluting.

Physical Properties

- **D**rying Time: 48 hours (surface drying)
- **S**pecific Gravity: 0.940
- **C**one Penetration: 310 ~ 340mm
- **C**overage: 0.5m^2/kg at 2mm thickness
  0.33m^2/kg at 3mm thickness
- **T**emperature Suitability: -60℃ to 230℃
- **C**olor/Consistency: Caramel/Rubbery
- **R**ecommended Thickness: 3 ~ 4mm
- **P**acking: 16kg/pail
- ISSA NO. 75.552.01 & IMPA NO. 45.07.91

Application Procedure



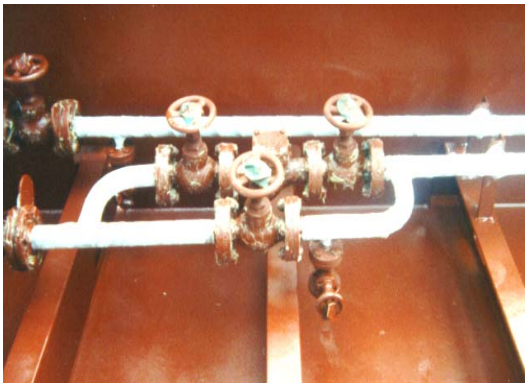
□ **SURFACE PREPARATION**: By scraping and brushing, remove scale, dust, loose rust & other foreign matters and keep the space dry. (Standard of surface is equivalent to SIS St2). **Make certain the surface is dry, clean, and "at normal air temperature"**.

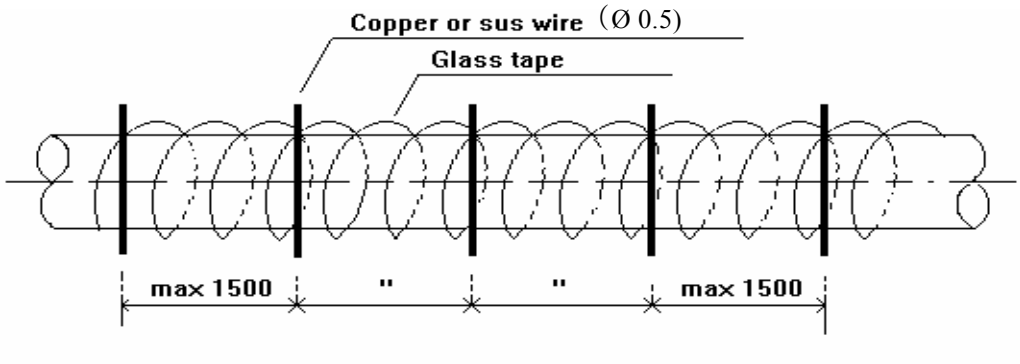
□ **THE FIRST COATING**: The first coat should be applied about 2~3 mm thickness by hand or spatula, using a pair of rubber gloves **under normal temperature and humidity**. After the application of the first coating, **minimum 48 hours' drying time** is required. Check first coating by set-to-touch test to determine drying condition of the surface

For an indoor use, the drying time is about 96 hours because of poor ventilation.

1) The surface to be applied must be at normal temperature and PD-22 should be applied at normal temperature as well.
2) Caution must be paid not to create any air bubble in the coating film.
3) Do not apply PD-22 on a rainy day, and heating from outside on this procedure is prohibited.

□ **FIBER GLASS TAPE**: Cover the surface of coating with fiber glass tape according to the following table (max. 1500mm) for insulation & superior flexibility, which allows the tape to withstand pipelines' vibration, impact, expansion and contraction without loss of adhesion. This is highly recommended to perform best anticorrosive property of PD-22 on severe vessel's condition.





¤ The ratios to be used to overlap glass tape

Pipe Dia	Fiber glass tape size	Overlapping
25A	0.32t x 24mesh x 50mm	30%
40A-65A	0.32t x 24mesh x 100mm	25%
80A-250A	0.32t x 24mesh x 150mm	20%

Required tape length can be figured out by the following formula

$$\frac{\text{O. Dia. of Pipe (mm) x 3.14 x length of Pipe (m)}}{\text{Tape Width (mm) - Overlap Width (mm)}} \times 1.1$$

□ **THE SECOND COATING**: Just after wrapping of fiber glass tape, apply the final PD-22 coating at 1~2mm thick again.

After application of the final coating, minimum of 48 hours' drying time is needed.
For indoor use, the drying time is about 96 hours because of poor ventilation.

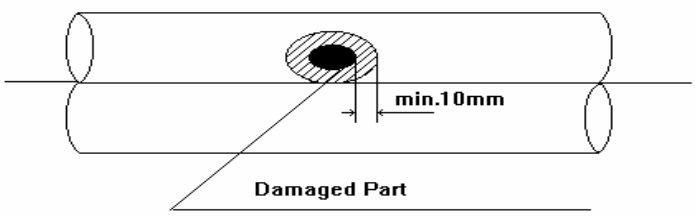
Inspection

□ After the drying time of minimum 48 hours, run steam through the pipes and check for blistered holes. If blistered holes are found, press the hole in the PD-22 coating in order to remove the air.

□ If the thickness of the PD-22 film is found to be insufficient, apply additional coating until the required thickness is obtained.

Repair Method

□ Scrape off the damaged film with a putty knife and touch up the damaged parts of the PD-22 coating, being sure to overlap more than 10mm.



Precaution

- The coating must be applied under **"the normal atmospheric temperature".**
- Leave PD-22 coating film "**for 48 hrs of drying time"** before putting into service.
- Careful attention must be paid during application not to be contaminated with water and not to create bubbling. The contamination & bubbling cause a shortening of the coating life.
- Approx. 48 hrs after applying the coating, the surface becomes dry. But, the coating is still wet underneath. Therefore, please **"refrain from mechanical impact & any contact thereon"**.

Information

Q'ty needed for 10 meter length of pipe (3mm thickness)

Pipe Nominal Diameter		Surface Area	BC PD-22	Pipe Nominal Diameter		Surface Area	BC PD-22
(MM)	(INCH)	(M^2)	(KG)	(MM)	(INCH)	(M^2)	(KG)
10 A	3/8	0.54	1.6	125 A	5	4.39	13.0
15 A	1/2	0.68	2.0	150 A	6	5.19	15.3
20 A	3/4	0.85	2.5	175 A	7	5.99	17.7
25 A	1	1.07	3.2	200 A	8	6.79	20.0
32 A	1 1/4	1.34	4.0	250 A	10	8.40	24.8
40 A	1 1/2	1.52	4.5	300 A	12	10	29.5
50 A	2	1.90	5.6	350 A	14	11.17	32.9
65 A	2 1/2	2.40	7.1	400 A	16	12.76	37.6
80 A	3	2.80	8.3	450 A	18	14.36	42.3
90 A	3 1/2	3.17	9.4	500 A	20	15.95	47.0
100 A	4	3.59	10.6	600 A	24	19.14	56.3