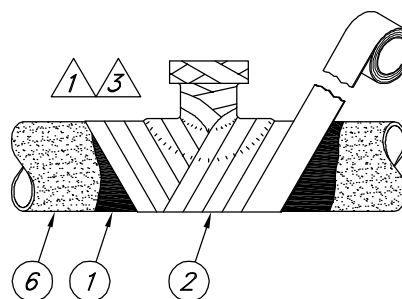
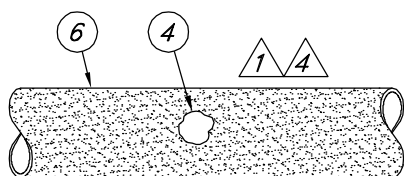


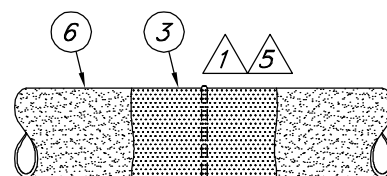
SHRINK SLEEVE APPLIED TO WELD-JOINT



WAX TAPE APPLIED TO IRREGULAR FITTING



COATING REPAIR WITH HOT MELT STICK



EPOXY COATING APPLIED TO WELD JOINTS ON POWERCRETE COATED PIPE

MATERIAL LIST

| QTY | DESCRIPTION | STOCK NO. | QTY | DESCRIPTION | STOCK NO. |
|-----|------------------------------|-----------|-----|------------------------------|-----------|
| 1 | WAX PRIMER | 2500104 | 5 | SHRINK SLEEVE | |
| 2 | WAX TAPE, 4" | 2500105 | | 4" x 11" | 202758 |
| | WAX TAPE, 6" | 2500106 | | 6" x 11" | 202760 |
| 3 | EPOXY COATING | | | 8" x 11" | 202764 |
| | 4 LB. KIT | 2503029 | | 10" x 11" | 202768 |
| | | | | 12" x 11" | 202772 |
| | | | | 16" x 11" | 202776 |
| 4 | EPOXY PATCH - HOT MELT STICK | 208649 | 6 | GAS MAIN WITH COATING INTACT | |

GENERAL NOTES

- SURFACE PREPARATION - APPLIES TO ALL CASES
PREPARE METAL SURFACE TO BE COATED BY SCRAPING, WIPING AND WIRE BRUSHING AS NEEDED. WASH AWAY ANY DIRT, OIL OR SOAP RESIDUE FROM LEAK TESTING. FOLLOW THE SAME PROCEDURE TO PREPARE OUTER SURFACE OF EXISTING COATING 6" BACK FROM EXPOSED AREA. HEAT SURFACES WITH A TORCH FLAME TO REMOVE ANY MOISTURE IF NEEDED. DO NOT BURN EXISTING COATING.
- COATING WELD-JOINTS WITH SHRINK SLEEVES
PREHEAT BARE STEEL AREA, THEN WRAP SHRINK SLEEVE AROUND MAIN, CENTERED OVER THE WELD-JOINT. USE A TORCH TO HEAT THE SLEEVE SIDE TO SIDE, ROTATING AROUND MAIN SLOWLY TO EVENLY HEAT ALL SIDES UNTIL SLEEVE IS UNIFORMLY TIGHT. MAKE SURE TO HEAT ENTIRE SURFACE OF SLEEVE (FRONT, BACK, TOP AND BOTTOM) IN ORDER TO ADHERE SLEEVE TO BARE METAL AND EXISTING COATING. DO NOT BURN. NOTE: ON 2" PIPE JOINTS, USE A 4" SLEEVE AND TRIM TO FIT.
- COATING IRREGULAR FITTINGS WITH WAX TAPE.
APPLY WAX PRIMER TO EXPOSED STEEL AND OVERLAP ONTO EXISTING COATING, FILL ALL IRREGULAR SHAPES AND CREVASSES WITH PRIMER. THEN WRAP WITH WAX TAPE IN A 50% OVERLAPPING PATTERN AS SHOWN ABOVE. BACKFILL AS SOON AS DESIRED.
- REPAIRING SMALL COATING BREAKS USING HOT MELT STICK
CLEAN AND ROUGHEN AREA 1" BEYOND BREAK IN COATING WITH A METAL FILE. MELT STICK WITH TORCH AND DAB HOT MATERIAL ON ENTIRE AREA. ALLOW TO COOL.
- COATING WELD JOINTS WITH EPOXY COATING
MIX EPOXY COATING PER MANUFACTURERS INSTRUCTIONS, THEN APPLY UNIFORM LAYER ON EXPOSED STEEL AND EXISTING COATING. ALLOW COATING TO CURE BEFORE BACKFILLING.

CONSTRUCTION STANDARD
CITY UTILITIES OF
SPRINGFIELD, MISSOURI

PROTECTIVE COATINGS
FOR STEEL PIPING