VISCOTAQ®Corrosion Prevention Coating & Moisture Barrier for Insulated Girth Welds

VISCOTAQ® is a non crystalline a-polar viscous elastic solid polyolefin coating for protection against corrosion of underground and aboveground substrates. VISCOTAQ'S® molecular chemistry is unique and designed in such a way that the viscosity gives it permanent wetting characteristics; forcing the material to flow into the pores and anomalies of the substrate. The elasticity of the product gives it the strength and feeling of a solid. The product bonds at a molecular level creating an impermeable homogeneous corrosion prevention coating.

VISCOTAQ® ViscoWrap provides corrosion prevention at the pipe and girth welds as well as the vapor/moisture barrier for the insulation. VISCOTAQ® can be applied with minimal surface preparation, does not require primer and forms a homologue continuous, corrosion prevention & moisture barrier coating. VISCOTAQ® bonds at a molecular level creating an impermeable barrier to moisture & oxygen. VISCOTAQ® shows excellent adhesion to virtually all surfaces (pipe, cladding, other coatings, insulation) over a wide temperature range. VISCOTAQ® always remains in a semi solid state and in constant contact with the substrate. Ease of application and outstanding performance is what makes VISCOTAQ® an excellent technology for corrosion prevention and waterproofing.

General
Coating failure and a pervious insulation system can lead to CUI (corrosion under insulation) and often go undetected.

Materials necessary
- VISCOTAQ® VISCOWRAP
- VISCOTAQ® OUTER WRAP (10mil PVC for cold enviroments)

Surface preparation
- The surface area to be coated should be inspected prior to coating; known defects must be documented and photographed prior to application.
- In case of rehabilitation, the old coating should be removed. Remove loose parts, grease, debris and moisture.
- The minimum surface should be ST2/ SSPC-SP2 (Hand Tool Clean), however where possible prepare to ST3/SSPC-SP3 (Power Tool Clean). In order to obtain best values blast the pipe to a surface level near white metal SA 2.5/SSPC-10.
- Clean surface to be coated with denatured alcohol or acetone to remove any dust, grease and moisture.
- Prepare surface to be coated as well as overlap area. Overlap onto the existing pipe coating: < 30" O.D. pipe 4"overlap, > 30" O.D. pipe 6" overlap.
- Keep the working area clean and dry at all times. Avoid the presence of water.
- Regularly check to make sure the surface of the pipeline is 4°F+ above the dew point.
- Protect the working area from rain and other moisture.

VISCOTAQ® VISCOWRAP (corrosion prevention on pipe and sealing of insulation)
The existing factory coating must be beveled to an angle of 45 degrees (if applicable). In case of thick coatings, bitumen or coal tar enamel, a bridge should be made on the bare steel onto the coating transition with a first straight circumference wrap. This initial circumference wrap will allow for properly wrapping over the 45 degree angle.

- Begin wrapping from the bottom with VISCOTAQ, starting with a minimum of 4 inches overlap over the existing coating. (< 30" pipelines 4"overlap, > 30" pipelines 6" overlap.)
- First wrap should be a straight wrap onto the existing coating.

- Once initial straight circumference wrap is completed, wrap with slight tension up the pipe starting on the initial wrap.
- Wrap at an angle with slight tension to create a smooth overlap and to ensure no air pockets are formed during wrapping.
- Wrap the VISCOTAQ® ViscoWrap with slight tension and a minimum 1 cm/ 1/2" overlap.
- End wrapping of ViscoWrap when completed with a straight circumference wrap overlapping onto existing coating
- For difficult to reach areas or where wrapping is not possible; the ViscoWrap can be placed on the pipe/substrate in strips overlapping a min of ½".

Sealing termination of factory applied insulation with VISCOTAQ VISCOWRAP (optional)

- Wrap ViscoWrap from previously coated pipe overlapping a min of 2" and wrap towards cladding over exposed insulation.
- Mold ViscoWrap from pipe over the insulation transition to cladding/ outside layer.
- Pieces and strips can be cut placed and overlapping ≥1" to ensure complete coverage of the transition. One may cut and place in place of wrapping.

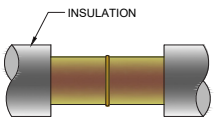
OUTER WRAP is applied for mechanical protection of the VISCOTAQ VISCOWRAP and to assure & accelerate adhesion.

Application of VISCOTAQ PVC Outer Wrap (10mil)

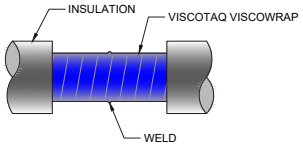
- PVC Outer Wrap must be wrapped with a 50% minimum overlap with tension.
- Wrap outer wrap starting from bottom wrapping upwards.
- Wrap in opposite direction of how the ViscoWrap was wrapped.
- The first wrap should be straight, then followed by wrapping with tension up the pipe. .
- The last section should end on a 4 o'clock position and be applied onto the pipe without tension.
- A 1/4" section of VISCOWRAP material should still be visible after the PVC/ PE Outer Wrap has been applied.

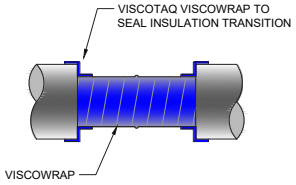
Install insulation over coated weld
Wrap VISCOTAQ VISCOWRAP from cladding to cladding over insulation to create a vapor barrier.
Wrap VISCOTAQ PVC Outer Wrap (10mil) over VISCOTAQ VISCOWRAP.
*apply VISCOWRAP & Outer Wrap as per guidelines previously covered in this document.
Apply cladding over weld pack (if desired).

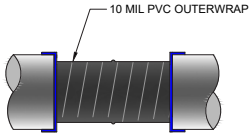
EXPOSED PIPE AT WELD-PACK



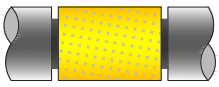
VISCOTAQ VISCOWRAP COATING APPLIED TO PIPE



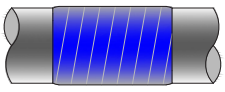


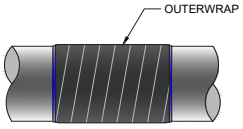


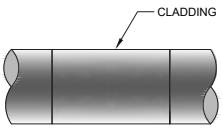
INSULATION REINSTALLED AT WELD-PACK



VISCOTAQ VISCOWRAP OVER WELD-PACK







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