

Pipe Coatings

Standard Pipe Coating - CW & ERW Pipe (Black Acrylic Water Base Paint)

A special quick drying black water based paint is sprayed around the outside of the as-welded pipe. This coating acts as a barrier and insulates the steel from the surrounding atmosphere, thereby providing about 6 months rust protection to the OD during outside storage, depending on weather conditions. Some end users paint directly over the water based paint, after light surface preparation¹.

Bare Pipe - No Coating

The as welded pipe is not protected at all against rust and will in fact be rusty upon arrival.

Pickled & Oiled – Procedure @ Sharon Tube

Pipe is pickled in a dilute sulfuric acid tank to remove the scale from the steel surface, then double rinsed and dipped into a 12% to 16% soluble oil tank (the remaining % is water). This provides about 1 month inside storage protection from rust (depending on conditions). This coating is not intended to protect the pipe against rust if stored outside. Wheatland stocks very little of this P&O pipe due to the short shelf life.

Pickled & Oiled – Including Phosphate – Procedure @ Sharon Tube

Pipe is pickled in a dilute sulfuric acid tank to remove the scale from the steel surface, double rinsed and then dipped in a phosphate tank to provide extra protection against rust. Then the pipe is dipped into a 12% to 16% soluble oil tank (the remaining % is water). This provides about one to two months inside storage protection from rust (depending on conditions). This coating is not intended to protect the pipe against rust if stored outside. Wheatland stocks very little of this P&O (including phosphate) pipe due to the short shelf life.

Galvanized Pipe

Wheatland's hot-dipped galvanizing process is fairly straight forward. The pipe is submerged in a pickle tub to remove all the scale and rust, both inside and out. The pipe is rinsed and then dunked in a pre-flux to ensure good adhesion of the zinc. The bare pipe is then submerged into a kettle of molten zinc. It then passes through an outside diameter air wiper for a uniform finish. The inside diameter is then blown clean with a blast of hot steam. The pipe cools on a cooling rack on the way to the white rust inhibitor bath.

Painting Recommendations

The black water based coating can be painted with a wide range of topcoats. In all cases the surface of the coated pipe should be thoroughly cleaned to remove oil, dirt, grease, and any other debris prior to applying a topcoat. Please refer to any and all guidelines on surface preparation, application, and compatibility supplied by the topcoat manufacturer.