

# Pipe Coatings

## Standard Pipe & Sprinkler Pipe Coating - SureThread CW & ERW Pipe (UV Coating)

A UV coating is applied to all sizes (1/2" through 6") of SureThread CW & ERW Pipe from both the Council Avenue & Warren plants. A black tinted UV curable coating is applied to the outside of the as-welded pipe and then cured with a UV lamp system. 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 UV coating, after light surface preparation<sup>1</sup>.

## Standard Pipe & Sprinkler Pipe Coating - 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 for some of our large diameter ( $\geq 8"$ ) pipe. This coating acts as a barrier and insulates the steel from the surrounding atmosphere, thereby providing about 6 months rust protection to the Outside Diameter (OD) during outside storage, depending on weather conditions. Some end users paint directly over the water-based paint, after light surface preparation<sup>1</sup>.

## 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

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.

## Galvanized Pipe

Wheatland's hot-dipped galvanizing process is 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 in a water tank before the white rust inhibitor is applied.

## Topcoats

The black water-based or UV coatings 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.