

SYSTEM 10

SUBSEA EQUIPMENT



DOMESTIC FLEET

AREAS TO BE COATED:

Subsea equipment - riser joints, BOP's, etc.

SURFACE PREPARATION:

1. If equipment has a pre-existing and failing coating system, commercial blast (SSPC-SP-6) to remove all corrosion and old coatings.
2. Pressure detergent wash entire surface to remove all surface contaminants. Freshwater rinse to remove all soap residues.
3. Abrasive blast to Near White Metal (SSPC-SP10) to an anchor profile of 2-3 mils.

Coating System								
Coating Sequence	Product Identification	Film Thickness Per Coat		Overcoat interval @ 70°F		Thinner	VOC	% Solids
		Wet	Dry	Min.	Max.			
1st Coat	Amercoat 240 Buff	8 to 10	7 to 9	9 hrs	3 mos	#65	1.2	87
Stripe Coat	Amercoat 240 Haze Gray	8 to 10	7 to 9	9 hrs	3 mos	#65	1.2	87%
2nd Coat	Amercoat 240 White	8 to 10	7 to 9	9 hrs	3 mos	#65	1.2	87%

1. Stripe coat is mandatory. Stripe coat all weldseams, edges, lips, crevices, nuts and bolts, pitting and hard to get areas.
2. Wet film thickness and VOC is calculated without thinner.