

Installation Guide For CR Tape

1. Installation environment requirements

1.1 Temperature during construction period shall be over the dew-point temperature about 3 degrees. Under the bad weather situations, such as sandstorm, snow and rain , if there is no reliable preventive protection, site-construction should not be carried out.

2. Surface Pre-treatment requirements

2.1 Before the implementation of rust removal processing on the surface of steel pipe, welding slag and vein which exist on the surface of pipe shall be cleaned out firstly combined with appropriate methods to clean up oil, grease and any other impurities.

2.2 For the external anti-corrosion coating rehab processing within different kinds of pipelines, in terms of petroleum asphalt anti-corrosion coating, epoxy coal tar pitch anti-corrosion coating and polyethylene adhesive tape. All of the old anti-corrosion coating layers, especially for the surfaces shall be clear cleaned through root out, kerosene cleaning, and scrub methods,etc. For the used FBE external coating pipe and PE anti-corrosion coating pipe, clear water shall be used to remove dirt on the surface of pipelines.

2.3 Powertool cleaning method shall be taken for removing the rust on the surface of steel pipe. Rust removal ability should attach St2 grade.

2.4 After the processing of rust removal, the sharp prat may wound coating and should be polished combined with dust-free.

2.5 The time interval between the pretreatment of steel pipe surface approach and brush CR primer should be controlled within 4 hours, and the surface of the steel pipe should be ddprevented from wetting and polluting. Before brushing CR primer, if the return of rust happens or surface contamination appears, pretreatment work must be taken place immediately.

3. Technology requirements for CR primer using

3.1 Before start the CR primer brushing procedure, CR primer shall be fully uniform mixing. If the CR primer is over storage period or clot appear, the CR primer must stop use. No paint thinner is allowed to put into the CR primer.

3.2 Using appropriate tools for the uniform coating adhesive without leakage of coating, clots and sagging situations. Color uniform coverage without leakage of the background color, the thickness of dry film of the CR primer is no less than 25 μ m.

3.3 CR anti-corrosion tape shall be wrapped after the CR primer is completely dry for the purpose of surface pollution prevention.

4. CR anti-corrosion tape wrap

4.1 It is advisable to use winding machine to bind CR anti-corrosion tape, if in the impossible to implement mechanical bind processing, manual winding can be used for a small range. When implement the binding procedure, the tension should keep coincident and make the tape elongation to reach 2-3% as possible. The weld seam should be wrapped before the weld place is filled with paste. When the spiral seam tube is wrapped with CR anti-corrosion tape, the winding direction should be consistent with the direction of the weld seam.

4.2 Based on the previous selected technics, in accordance with requirements to wrap CR anti-corrosion tape on the coated steel pipe, tape initial end lap length shall no small than $\frac{1}{4}$ of tube circumference, and no less than 100mm length. Two winding lap joints should be staggered, the lap width should be in accordance with the design requirements. The tape overlap should be parallel while the winding processing, no twisted wrinkles and tape ends shall be pressed to keep no raising.