

July 3, 2017

**Title:** Application Specification for repair of Powercrete R-65/F-1 and R-95 for damage coatings applied and damaged in the field.

**Scope:** Field Repair procedure for use of Powercrete Coatings on Field Joint Coatings (FJC's), Specials and Fittings.

**Coating Materials:** Powercrete Coatings consisting of Powercrete J, PC R-60, PC R-65/F-1 and PC R-95.

**Repair Materials:** Powercrete R-65/F-1 and/ or Powercrete R-95 in 50 ml cartridges.

**Detail conditions of Field coating defects:**

1. Pinholes. Less than 0.25" in diameter.
2. Defects approximately 1.0" in diameter.
3. Defects approximately 2.5" in diameter.
4. Defects larger than 2.5 " in diameter.

**Repair Procedures:**

**Point No. 1-3 Defects:** For all defects as noted in Items 1-3, the following procedure applies. Clean the metal surface with a wire brush to obtain a clean metal surface. Do not remove the surface profile. With light sand of 60 to 80 grit paper clean the Powercrete coating outside the defect area: followed by wiping the surface clean with MEK or Acetone solvent to remove cleaning debris. Apply the Powercrete R-65/F-1 or R-95 from the cartridge and apply to the surface of the metal in the center of the pinhole or defect. Apply sufficient material to cover the metal surface and onto the Powercrete coating by 1" diameter. Using a trowel spread the applied Powercrete over the treated surface. Insure that the Powercrete is smooth and the coating thickness is equal to the applied Powercrete coating thickness outside the defect area. Allow sufficient time for the repair area to cure. Test for hardness as per the Powercrete Application Specification. Holiday test the repair to ensure that there is no holiday present. For Holiday inspection, it is recommended to use NACE standard and an applied voltage of 125 volts per mil for testing. Record the defect and repair procedure in the construction journal.

**Point No. 4 Defects:** Determine from the end-user coating and construction specification and procedure if defects on FJC, Fittings and Specials in this category are to be repaired or the coating is removed and re-coated. If the end-user specifically allows for a repair, use a 1 pound kit to do the repair. Follow the procedure as noted above using the 1 pound kit.

## References:

Powercrete Data Sheet for Powercrete J, R-60. R-65/F-1 and R-95.

Powercrete Application Specification for Powercrete J, R-60. R-65/F-1 and R-95.

Powercrete cure charts for Powercrete J, R-60. R-65/F-1 and R-95.

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Sincerely,



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