

NAPCA BULLETIN 16-94

NAPCA RECOMMENDED PRACTICE FOR SURFACE CONDITION OF PIPE AS RECEIVED AT THE COATING PLANT

1. **General**

- a. This Recommended Practice may be used in whole or in part by anyone without prejudice, if recognition of the source is included. The National Association of Pipe Coating Applicators (NAPCA) assumes no responsibility for the interpretation or use of this recommended practice.
- b. By the nature of the situation, pipe surface condition is a subjective issue. The practices contained in this document cannot replace the good intent of all parties involved. This Recommended Practice is not intended to replace those issues that are properly addressed in a purchase order, customer specifications, or in a pre-production meeting. It is highly recommended that commercial issues such as financial liability due to surface contamination or imperfections be addressed in Customer specifications and the purchase order and clarified in pre-production meeting.

2. **Definitions**

The following definitions apply to this Recommended Practice:

- a. Applicator - The contractor that applies the coating to the pipe.
- b. Customer - The purchaser of the coated pipe or the entity for whom the Applicator coats the pipe.
- c. Coating Material Manufacturer - The company that makes the coating materials which are applied to the pipe.
- d. Pipe Supplier - The company that supplies the pipe to the Applicator.
- e. API - The American Petroleum Institute.
- f. NACE - NACE International.
- g. SSPC - The Steel Structures Painting Council.
- h. NAPCA - The National Association of Pipe Coating Applicators.

3. **Scope**

- a. It is the intent of this document to establish recommended practices governing pipe surface conditions on pipe as received at the Applicator's facility and prior to any treatment at the facility.
- b. These practices do not address pipe surface conditions after the surface has been prepared by the Applicator for coating application. Those conditions are covered in other specifications such as those by SSPC, NACE, and API.
- c. These practices do not supersede or duplicate other NAPCA specifications but are intended to supplement them.

4. **Pipe Inspection**

- a. Pipe inspection relevant to this document refers to that inspection necessary to

determine the suitability of pipe received at the Applicator's facility for processing and coating.

- b. The pipe surface shall be inspected as soon as practicable after receipt of pipe at the Applicator's yard for surface contamination or surface imperfections. Generally, Applicator surface inspection should apply only to those surfaces to be coated. However, other damage to the pipe such as that caused by rail or truck transportation should also be noted and inspection reports generated.
- c. It is left to the Applicator's discretion as to the method and degree of inspection to be used. However, the inspection should be of a level to give the Applicator a reasonable degree of comfort that the pipe will proceed through its process at a normal production rate and at a normal quality level. The inspection activity should not interfere with the normal flow of pipe from the Pipe Supplier to the Applicator.
- d. If problems with the pipe are excessive, or if any pipe cannot be coated, or is otherwise questionable, the Applicator should notify the Customer and/or Pipe Supplier in a timely manner.
- e. Pipe Supplier representatives, third party inspectors, and Customer representatives may participate in this inspection.

5. **Pipe Surface Contamination**

- a. Surface contamination as applicable to this recommended practice shall mean any foreign material on the pipe surface that would not be removed in the Applicators normal process and that would be detrimental to the finished coating.
The following items are considered detrimental when occurring in amounts that cannot be handled by normal processing:
 - i. Organic contaminants such as oils, lubricants, or greases. Particular attention must be paid to the excessive presence of soluble oils such as used in pipe hydrotesters and expanders.
 - ii. Previously applied coatings.
 - iii. Stencil media.
 - iv. Soluble salts (may require special testing other than visual for detection and quantification).
 - v. Adhesive type material such as tape or stickers.Surface contamination that can't be easily detected visually, such as soluble salts, may require other types of inspection or testing for detection.
- b. If pipe is received containing oil, grease, and other surface contaminants, a course of action should include one or more of the following:
 - i. Immediate notification to the Customer and/or Pipe Supplier. This is necessary so that sources of contamination may be identified and corrected.
 - ii. Removal of the contaminants by cleaning with an acceptable solvent. Criteria of acceptance for a solvent include safety considerations and ability to remove contaminant without leaving a hydrocarbon residue.
 - iii. Exposure of pipe to the open atmosphere for a sufficient period of time for the pipe surface to weather (development of a light rust).
 - iv. Use of an acid wash pretreatment prior to coating.
 - v. Other processes preferred by the Applicator which will remove