

TEMPORARY PAINTING/COATING OF FABRICATED PIPING

Prepared by

Pipe Fabrication Institute Engineering Committee



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TEMPORARY PAINTING/COATING OF FABRICATED PIPING

1. Scope

- 1.1 This standard describes painting methods and safety precautions normally used to shop coat fabricated pipe assemblies to provide surface protection during short-term periods of outside storage. (Also see paragraph 6.0)

2. Preparation of Surface to be Painted

- 2.1 Unless otherwise specified, surface preparation will consist of removing oil, grease, and all non-adhering materials to provide a surface suitable for the shop coating.

3. Painting Standard (non-welding surfaces)

- 3.1 The paint or coating used shall be compatible with previously applied lacquer or paint and normally be solvent reducible alkyd or water base, lead free and in accordance with OSHA guidelines to permit in-shop application. Lead not only produces hazardous fumes, but also has adverse affects on weld quality.
- 3.2 If painting of a mechanically joined end is required, coating thickness should not exceed manufacturer's recommended tolerances.

4. Painting of Surfaces to be Welded (end preparations)

- 4.1 Paint shall meet OSHA guidelines and also have approved weld-through properties.
- 4.2 Normally the non-welding surfaces to be shop coated terminate approximately two (2) inches from end preparations or field weld areas to insure that welding is not contaminated.

5. Painting Methods

- 5.1 Shop coats are normally applied by one or more of the following methods:
 - Hand brushing
 - Hand roller or applicator pad
 - Spray

6. Special Painting and/or Surface Preparation

- 6.1 Special painting and surface preparation are subject to prior agreement between the purchaser and fabricator.
- 6.2 Coatings that do not meet OSHA guidelines for in-shop open-spray application shall be avoided wherever possible (see paragraph 8.0). These coatings will require special equipment such as ventilated spray booths and added personal protection. In many cases coatings require special surface preparation and cleaning prior to paint application. This cleaning can be performed in accordance with PFI Standard ES-29.

7. Color & Film Thickness

- 7.1 Color selection shall be at the fabricator's option unless otherwise stipulated in the purchase specification.
- 7.2 Identification color markings shall be a matter of prior agreement between fabricator and purchaser.
- 7.3 Unless otherwise stipulated in the purchase specification, a one-coat application in accordance with the paint manufacturer's guidelines shall be considered satisfactory.

8. Safety Precautions

- 8.1 Normal safe shop operating procedure should be followed when applying any paint or coating material. As a minimum the following guidelines should be followed:
 - 8.1.1 No paint or coating may be applied without OSHA form "Material Safety Data Sheet / Safety Data Sheet (MSDS/SDS)" on file and having been reviewed for:
 - A. Hazardous chemicals, compounds or elements such as but not limited to lead or inorganic compounds of lead, mercury and compounds of mercury, arsenic and compounds of arsenic, chromate compounds, diisocyanates, chlorinated hydrocarbons, toluene, xylene, benzene, ethyl acetate, methyl ethyl ketone, and methyl isobutyl ketone.