

GENERAL SPECIFICATION

CORROSION

GS EP COR 250

**Friction-reduction internal coatings for pipelines
transporting non-corrosive gases**

03	10/2012	Internal coating is compulsory in dry gas trunk lines
02	10/2008	Minor changes
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Friction-reduction internal coatings for pipelines transporting non-corrosive gases		
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1. Scope

This specification covers requirements and methods of tests for liquid epoxy paints and internal coatings of such paints in pipes and fittings for the conveyance of non corrosive gas. It also deals with the application and inspection of the paint. Other paints or paint systems are not excluded provided they comply with the requirements given in this specification.

The coating consists of one layer, which is normally shop applied on blast cleaned steel by airless spray or conventional spray techniques. **The applied and cured paint film must be smooth to give the desired reduction in friction. To that respect and if needed, more specific requirements will be documented for each project leading to more stringent application procedure (with regards to surface preparation and/or dry film thickness).**

Brush application shall be used only for repairs. Unless otherwise agreed, the coating shall be suitable for operating temperatures between –20°C and +110°C.

The present general specification makes reference to and fully endorses the [ISO 15741](#), with the restrictions listed below.

Internal flow coating in dry gas trunk lines is mandatory (ref [GS EP PLR 100](#) and [GS EP PLR 502](#)) for the following reasons:

- Reduce internal corrosion in the pipeline during transport and storage and thereby reduce the amount of particles which can create production upsets during start-up
- Improve the dewatering and drying process
- Improve flow rates by reducing the friction

For other types of dry gas pipelines, such as for instance gas injection pipelines, internal flow coating may be applied.

2. Reference documents

The reference documents listed below form an integral part of this General Specification.

External Documents

Unless otherwise stipulated, the applicable version of these documents, including relevant appendices and supplements, is the latest revision published at the effective date of this document.

Reference	Title
ASTM D4940	Standard Test Method for Conductimetric Analysis of Water Soluble Ionic Contamination of Blasting Abrasives
ISO 15741	Paints and varnishes : Friction-reduction coatings for the interior of on and off shore steel pipelines for non corrosive gases
ISO 2409	Paints and varnishes - Cross cut test
ISO 2431	Paints and varnishes - Determination of flow time by use of flow cups