

GENERAL SPECIFICATION

CORROSION

GS EP COR 250

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

05	11/2016	General revision
04	05/2015	Organisation change – January 2015
03	10/2012	Internal coating is compulsory in dry gas trunk lines
02	10/2008	Minor changes
00	10/2003	First issue
Rev.	Date	Purpose of the revision

Owning entity: DSO/TEC	Managing entity: DSO/TEC/COR
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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.

The coating shall be suitable for operating temperatures between -20°C and $+110^{\circ}\text{C}$.

The present general specification makes reference to and fully endorses the [ISO 15741](#), with the modifications listed below under each Clause of [ISO 15741](#).

All the clauses numbers reported below refer to the clauses numbers of [ISO 15741](#).

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 addendums, 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 Blast Cleaning Abrasives
ISO 11124 (All parts)	Preparation of steel substrates before application of paints and related products-Specifications for metallic blast-cleaning abrasives - All parts
ISO 11125 (All parts)	Preparation of steel substrates before application of paints and related products-Test methods for metallic blast-cleaning abrasives - All parts
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 2815	Paints and varnishes – Buchholz indentation test
ISO 6860	Paints and varnishes – Bend test (conical mandrel)
ISO 8501-1	Preparation of steel substrates before application of paints and related products - Visual assessment of surface cleanliness - Part 1 rust grades and preparation grades of uncoated steel substrates and of steel substrates after overall removal previous coatings

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Reference	Title
ISO 8502-3	Preparation of steel substrates before application of paints and related products - Tests for the assessment of surface cleanliness - Part 3: Assessment of dust on steel surfaces prepared for painting (pressure-sensitive tape method)
ISO 8503-4	Preparation of steel substrates before application of paints and related products - Surface roughness characteristics of blast-cleaned steel substrates - Part 4: Method for the calibration of ISO surface profile comparators and for the determination of surface profile - Stylus instrument procedure

Total General Specifications

Unless otherwise stipulated, the applicable version of these documents, including relevant appendices and addendums, is the latest revision published.

Reference	Title
Not applicable	

3. Terms and definitions

As per ISO 15741.

PPT: Pre-Production Tests

4. Coating materials

In order to get Company approval, a full qualification dossier shall be submitted to Company for approval. This dossier shall include all tests references within ISO 15741, plus track record and field proven experience of the coating. Coating materials with no field experience will not be accepted.

Only Company qualified coating line shall be used to coat pipes as per this general specification

The qualification of a new coating line shall consist in a full PQT (Procedure Qualification Trial) as per Clause 5 of this General Specification, using coating materials qualified as per Clause 4.2 to Clause 4.8 of the ISO 15741 including the amendments below.

In addition, the ability of the coating to sustain regular pigging shall be documented. Any pigging restriction shall be clearly stated in the coating qualification dossier.

Once qualified, the Applicator is notified in writing. The need for new PQT is then waived.

The coating line remains qualified as long as no major modification have been implemented (the Applicator shall notify Company of such major modifications to the line)

Company reserves the right to cancel the qualification at any time due to reported quality issues or more than 5 years without coating for Company. The Applicator is notified in written.