

DIN EN ISO 21809-2:2025-01 (E)

Erscheinungsdatum: 2024-12-06

Oil and gas industries including lower carbon energy - External coatings for buried or submerged pipelines used in pipeline transportation systems - Part 2: Single layer fusion-bonded epoxy coatings (ISO/DIS 21809-2:2024); English version prEN ISO 21809-2:2024

Contents

	Page
Foreword.....	v
Introduction.....	vi
1 Scope.....	1
2 Normative references.....	1
3 Terms and definitions.....	2
4 Symbols and abbreviated terms.....	5
4.1 Symbols.....	5
4.2 Abbreviated terms.....	6
5 General requirements.....	6
5.1 Rounding.....	6
5.2 Conformity to requirements.....	6
6 Information supplied by the purchaser.....	6
6.1 General information.....	6
6.2 Additional information.....	7
7 Coating classification.....	8
8 Qualification processes.....	8
8.1 General — Qualification scheme.....	8
8.2 Coating material Qualification (CQ).....	10
8.2.1 General.....	10
8.2.2 Properties epoxy powder.....	11
8.2.3 Requirements epoxy powder.....	12
8.2.4 Repair material.....	13
9 Application of coating.....	13
9.1 General.....	13
9.2 Surface preparation.....	13
9.2.1 Initial evaluation and surface preparation.....	13
9.2.2 Abrasive blast cleaning.....	13
9.2.3 Surface dust contamination.....	14
9.2.4 Surface cleanliness and pretreatment.....	14
9.3 Coating application and curing temperature.....	14
9.3.1 General.....	14
9.3.2 Recycled powder.....	15
9.4 Coating thickness.....	15
9.5 Cutback.....	15
10 Qualification of coating application.....	15
10.1 General.....	15
10.2 Application procedure specification (APS).....	15
10.3 Inspection and Testing Plan (ITP).....	16
10.4 Procedure Qualification Trial (PQT).....	17
10.5 Pre-production Trial (PPT).....	18
10.6 Inspection and testing during production.....	18
10.7 Minimum requirements for qualification and production.....	19
11 Coating System Qualification (CSQ).....	21

12	Inspection and testing	22
12.1	General	22
12.2	Testing of incoming epoxy powder	22
12.3	In-process and finished product testing requirements	23
	12.3.1 General	23
	12.3.2 Holiday inspection	23
	12.3.3 Production test rings	23
12.4	Test results	24
13	Repair of coated pipe	24
13.1	General	24
13.2	Repair of holidays	24
	13.2.1 Pinholes and Small holiday	24
	13.2.2 Large defects	24
	13.2.3 Inspection of repaired area	24
13.3	Stripping and recoating	24
14	Markings	25
14.1	General	25
14.2	Required markings	25
15	Handling and storage in the coating area	25
15.1	Handling	25
15.2	Storage	25
16	Test reports and inspection documents	25
	Annex A (normative) Inspection of thickness	27
	Annex B (normative) Holiday detection test	29
	Annex C (normative) Cure time of the epoxy powder	31
	Annex D (normative) Thermal analysis of epoxy powder and cured coating film	34
	Annex E (normative) Resistance to impact of the coating	40
	Annex F (normative) Dry adhesion test	42
	Annex G (normative) Particle size of epoxy powder	44
	Annex H (normative) Cathodic disbondment test	45
	Annex I (normative) Flexibility of the coating	54
	Annex J (normative) Gel time of the epoxy powder	56
	Annex K (normative) Total volatile/moisture content of the epoxy powder — Mass loss	58
	Annex L (normative) Hot-water adhesion of the coating	60
	Annex M (normative) Density of the epoxy powder	62
	Annex N (normative) Interface contamination of the coating	64
	Annex O (normative) Porosity of the coating	65
	Bibliography	68