

DIN EN 10339:2007-05 (E)

Steel tubes for onshore and offshore water pipelines - Internal liquid applied epoxy linings for corrosion protection

Contents		Page
1	Scope	4
2	Normative references	4
3	Terms and definitions	5
4	Symbols and abbreviations	5
5	Lining materials	5
5.1	General	5
5.2	Technical specification	5
5.3	Packaging	8
6	Information to be supplied by the purchaser	8
6.1	Mandatory	8
6.2	Options to be indicated by the purchaser	8
7	Surface preparation and application of the lining	8
7.1	Surface preparation	8
7.2	Application of the lining	9
8	Requirements of the applied lining	10
8.1	General	10
8.2	Appearance and continuity	10
8.3	Minimum dry film thickness of the lining	10
8.4	Hardness measured by Buchholz indentation	11
8.5	Non porosity	11
8.6	Adhesion	11
8.7	Cut back lengths	11
8.8	Summary of the required properties	12
9	Repairs	12
10	Marking	13
11	Handling, transportation and storage	13
11.1	Handling and transportation to the storage area	13
11.2	Storage	13
11.3	Loading of tubes for delivery	13
Annex A (normative) Adhesion test - Resistance to removal		14
A.1	General	14
A.2	Apparatus	14
A.3	Procedure	14
A.4	Results	15
Bibliography		16