ISO 21809-2:2026-02 (E)

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

Contents

Page

Foreword ..... **v**

1 Scope **1**

2 Normative references **1**

3 Terms and definitions **2**

4 Symbols and abbreviated terms **6**
4.1 Symbols 6
4.2 Abbreviated terms 6

5 General requirements **7**
5.1 Rounding 7
5.2 Conformity to requirements 7

6 Information supplied by the purchaser **7**
6.1 General information 7
6.2 Additional information 8

7 Coating classification **8**

8 Qualification processes **9**
8.1 General 9
8.2 Qualification scheme 9
8.3 Coating qualification (CQ) 10
8.3.1 General 10
8.3.2 Properties of epoxy powder 11
8.3.3 Requirements for epoxy powder 12
8.3.4 Repair material 13

9 Application of coating **13**
9.1 General 13
9.2 Surface preparation 14
9.2.1 Initial evaluation and surface preparation 14
9.2.2 Abrasive blast cleaning 14
9.2.3 Surface dust contamination 14
9.2.4 Surface cleanliness and pretreatment 14
9.3 Coating application and curing temperature 15
9.3.1 General 15
9.3.2 Recycled powder 15
9.4 Coating thickness 15
9.5 Cutback 15

10 Qualification of coating application and coating system **16**
10.1 General 16
10.2 Application procedure specification (APS) 16
10.3 Inspection and testing plan (ITP) 17
10.4 Procedure qualification trial (PQT) 17
10.5 Coating system qualification (CSQ) 18
10.6 Pre-production trial (PPT) 19
10.7 Inspection and testing during production 19
10.8 Minimum requirements for qualification and production 20

11 Inspection and testing **23**
11.1 General 23
11.2 Testing of incoming epoxy powder 23
11.3 In-process and finished product testing requirements 23
11.3.1 General 23
11.3.2 Holiday inspection 23
11.3.3 Production test rings 24
11.4 Test results 24

12 Repair of coated pipe **25**
12.1 General 25
12.2 Repair of holidays 25
12.2.1 Pinholes and small holidays 25
12.2.2 Large defects 25
12.2.3 Inspection of repaired area 25
12.3 Stripping and recoating 25

13 Markings **25**
13.1 General 25
13.2 Required markings 25

14 Handling and storage in the coating area **26**
14.1 Handling 26
14.2 Storage 26

15 Test reports and inspection documents **26**
15.1 General 26
15.2 Common requirements for reports 27
15.3 Specific requirements for test reports 28
15.4 Specific requirements for sampling reports 28
15.5 Reporting statements of conformity 28
15.6 Reporting opinions and interpretations 29
15.7 Amendments to reports 29

Annex A (normative) **Inspection of thickness** **30**
Annex B (normative) **Holiday detection test** **31**
Annex C (normative) **Cure time of the epoxy powder** **33**
Annex D (normative) **Thermal analysis of epoxy powder and cured coating film** **36**
Annex E (normative) **Resistance to impact of the coating** **43**
Annex F (normative) **Dry adhesion test** **45**
Annex G (normative) **Particle size of epoxy powder** **46**
Annex H (normative) **Cathodic disbondment test** **47**
Annex I (normative) **Flexibility of the coating** **56**
Annex J (normative) **Gel time of the epoxy powder** **58**
Annex K (normative) **Total volatile or moisture content of the epoxy powder — Mass loss** **60**
Annex L (normative) **Hot-water adhesion of the coating** **62**
Annex M (normative) **Density of the epoxy powder** **64**
Annex N (normative) **Interface contamination of the coating** **66**
Annex O (normative) **Porosity of the coating** **70**
Bibliography **72**