

MATERIAL AND EQUIPMENT STANDARD

FOR

COAL TAR PRIMER (COLD APPLIED)

FOR

USE WITH HOT APPLIED COAL TAR ENAMEL (IPS-M-TP-290)

CONTENTS :

PAGE No.

1. SCOPE	2
2. REFERENCES	2
3. UNITS	3
4. DEFINITIONS AND TERMINOLOGY.....	3
5. COMPOSITION	3
6. PROPERTIES.....	3
7. STORAGE LIFE, PACKAGING, SAMPLING.....	5
8. INSPECTION AND TESTING	6
9. LABELING.....	6

1. SCOPE

This Standard Specification covers the minimum requirements for the composition, properties storage life and packaging, inspection and labeling of coal tar primers grades a and b (cold applied) for use with hot applied coal tar enamel (IPS-M-TP-290). Primer grade a is intended for use with enamels grade 105/15 and 105/8 and primer grade b is intended for use with enamel grade 120/5, therefore the primer shall be selected according to the grade of enamel.

2. REFERENCES

Throughout this Standard the following standards and codes are referred to. The editions of these standards and codes that are in effect at the time of publication of this Standard shall, to the extent specified herein, form a part of this Standard. The applicability of changes in standards and codes that occur after the date of this Standard shall be mutually agreed upon by the Company and the Vendor:

ANSI (AMERICAN NATIONAL STANDARDS INSTITUTE)

Z 1291 "Precautionary Labeling of Hazardous Industrial Chemicals"

ASTM (AMERICAN SOCIETY FOR TESTING AND MATERIALS)

Test Methods for Properties

D 1296 "Odors of Volatile Solvents and Diluents"

BSI (BRITISH STANDARD INSTITUTION)

BS 4164 "British Standard Specification for Coal Tar Based Hot Applied Coating Materials for Protection Iron and Steel" Including suitable primers where required

IPS (IRANIAN PETROLEUM STANDARDS)

C-TP-101 "Construction Standard for Surface Preparation"

E-TP-270 "Engineering Standard for Coatings"

M-TP-290 "Material and Equipment Standard for Coal Tar Enamel (Hot Applied)"

SSPC (STEEL STRUCTURES PAINTING COUNCIL, VOLUME 2)

SSPC-PA Guide 3 "A Guide to Safety in Paint Application"

US FEDERAL STANDARDS

"Federal Test Method Standard No. 141 "

Method 3011 "Condition in Container"

Method 4321 "Brushing Properties"

Method 4541 "Working Properties and Appearance of Dried Film"

3. UNITS

This standard is based on International System of Units, (SI) except where otherwise specified.

4. DEFINITIONS AND TERMINOLOGY

COAL TAR

A mixture of high molecular mass hydrocarbons, obtained by distillation of high temperature coal tar, processed so that to produce base materials for primers grade a and b (See table 1).

COATING (PROCESS)

The process of applying a thin layer of a material in the form of a fluid or powder upon a substance.

COATING (PRODUCT)

A thin layer of a material applied by a coating process.

PRIMER

A liquid material applied as an undercoat directly to the metal, in order to assist the bonding of a subsequent coating of coal tar enamel.

SOFTENING POINT (RING AND BALL)

The temperature at which a disc of the material, contained in a ring, undergoes a standard deformation caused by the weight of a ball under standardized test conditions.

5. COMPOSITION

Coal tar primer shall consist only of processed coal tar pitch and refined coal tar oils*, suitably blended to produce a liquid that may be applied cold by brushing or spraying and that will produce an effective bond between the metal and a subsequent coating of coal tar enamel. The primer shall contain no benzene or other toxic or highly volatile solvents. The primer shall show no tendency to settle out in the container.

* Coal tar oils up to 200 °C consist of benzene, toluene, xylenes, cumenes, etc.

6. PROPERTIES

The coal tar primer for coating material shall meet the requirements of table 1, when tested by the methods specified, and when dry, shall provide an effective bond between the metal and the subsequent coating, in accordance with the appropriate performance requirements given in Table 2.

The primer shall also meet the requirements of clauses 6.1 through 6.3.

TABLE 1 - PROPERTIES OF PRIMER

CHARACTERISTICS	UNIT	REQUIREMENTS		TEST METHOD	
		GRADE a	GRADE b	BSI	ISO 5256 (E) 1985
ASH CONTENT (MASS ON DRY EXTRACT)	W %	0.5	0.5	—	A →M
SOFTENING POINT OF COAL TAR USED (RING AND BALL)	°C	80 - 100	100 - 120	BS 4164 APPENDIX D	A →D
VISCOSITY (No. 4 FLOW CUP AT 23°C)	SECOND	20 - 200	20 - 200	BS 3900 PART A 6 (BREAK POINT PROCEDURE)	—
(ABLE CLOSED CUP) FLASH POINT Min. °C	°C	23	23	BS 2000 PART 170	—
PENETRATION OF COAL TAR USED (AT 25°C TO 10 ⁻¹ mm)	°C	20 - 30	10 - 20	BS 4164 APPENDIX E	A →E

6.1 Odor

The odor shall be normal for the materials permitted (ASTM Standard D.1296).

6.2 Color

The color shall be black.

6.3 Working Properties

The primer shall be capable of application by brush and spray when tested in accordance with US Federal Standard No 141 methods 4321, 4331, and 4541.

The primer shall show no streaking, running or sagging after drying.

TABLE 2 - PERFORMANCE REQUIREMENTS OF PRIMER IN CONJUNCTION WITH COAL TAR ENAMEL (IPS-M-TP-290)

TEST	GRADE 105/15	GRADE 105/8	GRADE 120/5	METHOD	
				AWWA	BS 4164
SAG, MAXIMUM, mm 70°C 24h 80°C 24h	1.5 —	1.5 —	— 1.5	AWWAC C 203	APPENDIX G
LOW TEMPERATURE CRACKING AND DISBONDING -30°C -25°C -20°C	None — —	— None —	— — —	AWWAC C 203	APPENDIX H
BEND AT 0°C FIRST CRACK, MINIMUM, mm INITIAL AFTER HEATING DISBONDED AREA, MAXIMUM, mm ² INITIAL AFTER HEATING	20 15 2000 3000	15 10 3000 5000	— — — —	—	APPENDIX J
IMPACT DISBONDED AREA, MAXIMUM mm ² 0°C * 25°C	15000 —	— 1000	— —	AWWAC C203	APPENDIX K
PEEL, INITIAL AND DELAYED, MAXIMUM, mm 30°C 40°C 50°C 60°C 70°C	3.0 3.0 3.0 — —	— 3.0 3.0 3.0 —	— — — 3.0 3.0		APPENDIX L
CATHODIC DISBONDING IN 28 DAYS MAXIMUM, mm	5	5	5	—	APPENDIX M

Note :

Apply the enamel not less than 16 hours and not more than 72 hours after the primer has been applied.

7. STORAGE LIFE, PACKAGING, SAMPLING

7.1 Storage Life

The product shall meet the requirements of clause 6 after storage of at least 24 months from date of delivery, in a full tightly covered container.

7.2 Packaging

The primer shall be packaged in not contaminated steel drums containing not more than 210 liters.

7.3 Sampling

When samples of coating material are required for testing, the purchaser shall specify the number of packages to be sampled and the procedure to be adopted. The samples so taken shall be identified by the supplier and one-half retained by the purchaser for the purpose of making such tests as he may require.

In coating materials, the filler will settle during storage. In order to ensure that test samples of these materials are representative, they shall be made up of equal increments taken from the top, middle and bottom of the package.

Preparation of samples for testing shall be in accordance with method C of ISO 5256.

8. INSPECTION AND TESTING

8.1 All materials supplied under this Standard Specification shall be subject to timely inspection by the purchaser or his authorized representative. The purchaser shall have the right to reject any material(s) supplied which is (are) found to be defective under this Standard Specification. In case of dispute, the arbitration or settlement procedure, established in the procurement documents shall be followed.

8.2 The supplier shall be responsible for the performance and costs for all laboratory test requirements as specified in this Standard.

The supplier shall set up and maintain such quality assurance and inspection systems as are necessary to ensure that the materials comply in all respects with the requirements of this Standard Specification.

8.3 Purchaser's inspector(s) shall have free access to the supplier's work to follow up the progress of the materials covered by this standard and to check the quality of materials.

The supplier shall place free of charge at the disposal of the purchaser's inspector(s) all means necessary for carrying out their inspection:

results of tests, checking of conformity of materials with this Standard requirements, checking of marking and packing and temporary acceptance of materials.

8.4 Samples submitted to the purchaser will be tested in the purchaser's laboratory or in a responsible commercial laboratory designated by the purchaser.

8.5 The supplier shall furnish the purchaser with a certified copy of results of tests made by the manufacturer covering physical and performance characteristics of each batch of product to be supplied under this Standard Specification. The supplier shall furnish, or allow the purchaser to collect samples of the material representative of each batch of product.

Certified test reports and samples furnished by the supplier shall be properly identified with each batch of product.

8.6 Prior to acceptance of the supplier's material, samples of material submitted by the supplier will be tested by the purchaser.

If any sample is found not to conform to this Standard, material represented by such sample will be rejected.

If samples of the supplier's material that have been previously accepted are found not to conform to this Standard, all such material will be rejected.

8.7 After the supplier has obtained approval from the purchaser for the bitumen primer proposed to be furnished, the supplier shall submit the coating manufacturer's detailed specifications for the bitumen primer supplied, with instructions for the handling and application of the material.

8.8 Unless otherwise specified in this standard specification the methods of sampling and testing shall be in accordance with applicable methods of the American Society for Testing and Materials and /or BS 4147.

9. LABELING

9.1 Labeling Standard

Refer to ANSI Standard Z 129.1 "Precautionary Labeling of Hazardous Industrial Chemicals".

9.2 Marking of Containers

Each container shall be legibly and permanently marked with the following information:

- Name: Coal Tar Primer (Cold Applied) for use with Coal Tar Enamel (IPS-M-TP-290):**
- Specification: IPS-M-TP-280:**
- Grade of primer:**
- Grade of enamel of IPS-M-TP-290 which primer shall be used with:**.....
- M.E.S.C. No.:**
- Order No.:**
- Maximum temperature resistance:**
- Flash point °C:**
- Drying time for over coating:**
- Kind of thinner:**
- Cleaning material:**
- Color: Black**
- Batch No.:**
- Stock No.:**
- Date of manufacture:**
- Quantity of primer in container:**
- Information and warning, if required:**
- Manufacturer’s name and address:**
- Design guide: For the guidance on the usage of this primer for various applications/environments reference shall be made to IPS-E-TP-270.**

9.3 Direction for Use

In addition to the manufacturer’s instructions for use, the following directions shall also be supplied with each container of premier.

This primer is intended for use as a prime coat on steel (mainly steel pipe).

The surface of steel shall be prepared in accordance with IPS-C-TP-101 (surface preparation before applying the primer).

This primer is intended to be followed by hot applied coal tar enamel conforming to IPS-M-TP-290. Mix primer thoroughly before use.

Apply by brush to the specified film thickness or if none is specified, to at least 100 microns dry.

The surface to coated shall be dry and the surface temperature shall be at least 3°C above the dew point.

9.4 Direction for Safety

In addition to the manufacturer’s instructions for safety, the following directions shall also be supplied with each container of primer:

This primer is hazardous because of its flammability and potential toxicity. Proper safety precautions shall be observed to protect against these recognized hazards. Safe handling practices are required and shall include, but not be limited, to the provisions of SSPC-PA Guide 3,"A guide to safety in paint application" and to the following:

- Keep primer away from heat, sparks, and open flame during storage, mixing, and application. Provide sufficient ventilation to maintain vapor concentration at less than 25% of the lower explosive limit.

- Avoid prolonged or repeated breathing of vapors or spray mists, and prevent contact of the paint with the eyes or skin.
- Clean hands thoroughly after handling primer and before eating or smoking.
- Provide sufficient ventilation to insure that vapor concentrations do not exceed the published permissible exposure limits. When necessary, supply appropriate personal protective equipment and enforce its use.
- This primer may not comply with some air pollution regulations because of its hydrocarbon solvent content.