



Surface Preparation Procedure

For Aquawrap® and Powersleeve®

Surface preparation is critical to success when high performance composites are applied in the field. Bad surface preparation can result in premature failure or weakened properties of the repair system. Please contact our office for information on preparation when encountering questionable conditions.

1. Major surface contamination buildup should be removed prior to any high-quality cleaning. This is often done with water-based pressure washer machinery and high-alkalinity detergent wash.
2. Paint may or may not need to be removed, depending on the type of repair. Generally, any paint or coating must be removed. All pipeline tape wraps, bitumen coatings, insulation, etc. must be removed.
3. Abrasive blast to a near white (NACE No.2/SSPC-SP 10) level all surfaces that the composite will contact. This is adequate for most work. Installations requiring structural adhesion, or for isolated patch applications where the patch is held to the work surface by its adhesion, must be white metal blasted (NACE No.1/SSPC-SP 5). Where abrasive blasting is dangerous or impossible, surfaces that the composite will contact should be abraded (scratched up) with the equivalent of an 80-grit abrasive and the metal surfaces should be brought to the equivalent of the appropriate NACE level mentioned above.
4. Excess dust and residue from the abrading should be blown or wiped away with oil-free compressed air or new, clean solvent wipes.
5. All sharp corners, dents, leak repairing patches and wall/diameter offsets greater than 1/8th-inch (3mm) (1/16th-inch for fluid-tight installations) should be smoothed with a high compressive and high flexural strength filleting and filling compound. Most circumferential piping welds and the like require no special filleting or smoothing.
6. After filling and smoothing, wipe the surface again with a clean cloth and a solvent cleaner. Remove any dust or foreign matter from the surface of the pipe in the area of the repair.
7. Application of the primer and composite should begin within 4 hours of the final cleaning, unless special preparations have been made.