Introduction

The following general application procedure is applicable to vessel saddles operating at temperatures in excess of 50°C and should be read in conjunction with the specific requirements of the client as detailed in the guideline specification prepared for the project. Unless directed to the contrary in this proposal, Promat FENDOLITE® MII shall be mixed and applied in accordance with the current Promat FENDOLITE® MII & FENDOLITE® TG Energy Industries Application Manual.

Inspection of steel surfaces

All steel surfaces to be protected shall be in good condition, adequately protected from possible corrosion, be free from oil, grease, dirt, dust, grime or any other contaminants.

Priming requirements

Anti-corrosion and paint requirements are beyond the scope of this specification. However, where the Promat FENDOLITE® MII System is to be applied directly to steel substrates, we recommend that the surface be blast cleaned to SA 2½ in accordance with SIS 05 59 00: 1967 and are primed and painted with a two-pack epoxy system, applied and cured in accordance with the manufacturer's recommendations.

Installation of support system

Install suitable length stud welded pins at 400mm maximum centres on a staggered pitch. Alternatively self adhesive pins may be used where mesh will completely encapsulate the saddle. Where the steel priming system is removed to facilitate stud welding, it must be made good with a suitable repair system in accordance with the client's specification.

Application of PROMAT® PSK101

All uninsulated items of steelwork to which the Promat FENDOLITE® MII System is to be applied shall be painted with one coat of PROMAT® PSK101 at a wet film thickness of 100-150 microns (55-82 microns DFT) and allowed to cure and dry.

Installation of thermal insulation

Installation of thermal insulation shall be carried out in accordance with the manufacturer's recommendations, unless directed otherwise in this specification. The thickness of the insulation shall be sufficient to provide an interface temperature (between the rock wool and Promat FENDOLITE® MII) of not more than 50°C.

Application of Riblath 271

Galvanised Riblath 271 should be attached to previously fixed stud welded or adhesive insulation pins and secured using non-return Speedfix washers.

It is important that the ribs point toward the mineral wool to provide a stand-off for good penetration and keying of the Promat FENDOLITE® MII. Ensure that the Riblath is overlapped and wire tied in accordance with the manufacturers recommendations.

Installation of mesh reinforcement

Promat propose the use of 50mm x 50mm PROMAT® Plastic Coated Galvanised Mesh. Wrap the mesh loosely round the profile of the vessel saddle securing in place with Speedfix washers attached to the previously installed pins. All mesh joints should be overlapped by a minimum of two mesh apertures and self-tied or tied with 1.6mm galvanised hog rings or tie wire at 150mm centres. Joints should be staggered so that not more than three layers of mesh overlap at any one point. Once positioned, the mesh should lie substantially within the mid third of the applied Promat FENDOLITE® MII thickness.

Application of Promat FENDOLITE® MII

Application of the Promat FENDOLITE® MII shall be in accordance with the current Promat FENDOLITE® MII & FENDOLITE® TG Petrochemical Application Manual. Application may commence at the base of the vessel saddle and proceed upwards. Where possible, the Promat FENDOLITE® MII should be applied as a single coat to the required thickness. Promat FENDOLITE® MII MUST NOT be trowelled flush with the reinforcing mesh as this can create a plane of weakness.

Intermediate coats shall be left rough textured or well scratched to provide a good key for the following coat. The final coat shall be at least 8mm thick to avoid cracking.

The suggested finishing technique is to level the surface with a steel float to close down the surface.

Water shedding and sealing of Promat FENDOLITE® MII / steel junctions

Top surfaces shall be sloped to shed water. All terminations of Promat FENDOLITE® MII against steel must be sloped to shed water. Promat FENDOLITE® MII / steel junctions shall be sealed by cutting a ‘U’ shape into the material and applying a polysulphide or silicone based mastic sealer.

NOTE: Promat recommend that the mastic seal is not applied until after final surface treatment.

Final surface treatment

Promat propose that on curing and drying of the Promat FENDOLITE® MII, the surface is treated with a Promat approved topcoat paint system. The selected topcoat system must be applied strictly in accordance with the manufacturer’s recommendations. It is necessary to maintain the correct environment conditions as stipulated in our current Promat FENDOLITE® MII & Promat FENDOLITE® TG Energy Industries Application Manual immediately before, during and after the particular application. Refer to Energy Industries Data Sheet EIDS 033 - Sikalastic (Decothane) Application Procedure.

NOTE: Ideally, all repair work should be carried out prior to application of the final surface treatment (refer to the current Promat FENDOLITE® MII & FENDOLITE® TG Application Manual).

The information given in this Application Procedure is based on practical experience, independent and other tests and represents, in Promat’s opinion, the best technical advice available. Since the products are applied under circumstances beyond our control, Promat can accept no direct or consequential liability, whether in contract or in tort, for the interpretation of such recommendations and reserves

the right to modify the recommendations as necessary. Should it be unclear as to the meaning of any of the instructions given above, or if further information is required, please consult Promat.