



### Porwal's Pipeline Coal Tar Tape

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#### PORWAL'S COAL TAR TAPE COATING

Over several years of experience, technologists have found out effective measures to reduce the corrosion of pipeline carrying oil, gas & water as it is economical than to replace corroded pipeline. Coal Tar Tape coating provides superior performance in the area of water resistance to soil chemicals, soil bacteria and plant growth. PORWAL'S Coal Tar Tape buries the corrosion with buried pipeline.

It is manufactured and supplied as per AWWA-C-203/2002 & IS 15337/03

#### METHOD OF APPLICATION FOR TAPE COATING

- a) **Cleaning** : Proper surface preparation is essential to get the best performance out of Porwal's Coal Tar Tape. The surface is to be cleaned from oil, grease, dirt, rust and loose particles either by sand blasting / shot blasting, powertool cleaning / solvent cleaning in case, rusting occurs before the surface is primed due to time lag, the surface must again be cleaned by suitable means.
- b) **Primer** : One uniform coat of Primer to be applied by brush or spray or any other methods, ensure uniform coating. The primer shall be allowed to dry to the touch prior to tape application. If application is done in cold weather the pipe shall be preheated until it is warm to the touch and traces of moisture are removed. Drums containing primer should be stirred well before application.
- c) **Coating & Wrapping** : Remove the thermofusible film on one side of Porwal's Tape, heat the tape surface uniformly by torching, for wrapping application use a wide mouth torch (avoid over heating which can damage the tape by melting and running down of the coating material). As soon as the primer is hard dry, tape should be applied on the pipe. Generally 2 mm tape in two layers wrapping or 4 mm in single layer are applied. Primer is applied on first coat of Tape to give better bonding of second layer of Tape on first coat. Apply tape spirally or any other conventional way maintaining a certain amount of tension and intimate contact with the pipe surface ensuring perfect addition



to avoid formation of air pockets, bubbles beneath the tape. The overlap between the ends should be min. 12 mm per single coat or as per design / specification requirement. The overlap to be fused properly.

- d) **Double Layer**: Application of the second layer of Porwal's Tape is as per procedure outlined above except the thermofusible tape on the both side of the Porwal's tape to be removed. The application should meet the adhesion and holiday detection as per standards.

Compound	:	Coal Tar Enamel
Reinforcement	:	Fibre glass tissue
Thickness	:	2/2.5/3/4 mm ± 10%
Weight Kg. / M2	:	1.50 Kg/sq/mm ± 10%
Stock width	:	200mm/250mm/333mm/ 500 mm/1000 mm (± 5 %)
Length	:	10/15 m or according to pipe dia

**The material** : A preformed tape, heat fusible, composed of coal-tar base coating material supported on a fabric of inorganic fibres, conforming to AWWA C-203 & IS 15337/03

Characteristics of Coal Tar component shall be tested for Cathodic disbondment as per BS 4164/87  
Fabric shall be thin, flexible mat or tissue composed of glass fibres having minimum thickness of 0.3mm and weight of the same will be minimum 40gm/Sq./metre.

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