

# **BALUCHISTAN ENERGY COMPANY LIMITED**

## **DEVELOPMENT OF LPG TESTING LABORATORY AT TAFTAN**

### **GENERAL SPECIFICATION FOR COLD APPLIED TAPE**



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# GENERAL SPECIFICATION FOR COLD APPLIED TAPE

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# GENERAL SPECIFICATION FOR COLD APPLIED TAPE

## 1.0 SCOPE

This specification covers the minimum requirements for performing the Cold Applied Tape wrapping for underground carbon steel (Carbon Steel) piping.

## 2.0 CODES AND STANDARDS

### 2.1 Wrapping Material for Under Ground C.S. Piping at Temperature Up To 85°C

The surface preparation and coatings shall be in accordance with this Statutory Regulations (where applicable):

- Primer Paste:

Primer paste for polyethylene-wrapping tape shall consist of butyl based elastomers blended with synthetic resins. This paste shall provide excellent adhesion between the pipe metal and the tape together with effective resistance to any tendency for cathodic disbondment. The Primer Paste shall be suitable for use by either machine or hand brush application. The paste shall be non-toxic, non-polluting and conform to local and national standards.

POLYKEN PRIMER #1019 or equivalent.

- Inner wrapping tape:

The inner wrapping tape shall be not less than 20 mils thick (0.508 mm) and shall provide the main corrosion resistance layer. It shall consist of a polyethylene backing tape with a butyl rubber based adhesive layer to assure high bond efficiency with the primer paste. The inner wrapping tape shall be principally designed for machine application but shall also permit hand placement.

The tape shall possess excellent conformability with the pipe profile when applied over seamed, spiral welded or extruded pipe. The inner wrapping tape shall resist both chemical and electrolytic corrosion.



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POLYKEN # 989 or equivalent.

- Outer wrapping tape:

The outer wrapping tape shall be not less than 30 mils thick (0.762 mm) and shall provide the main mechanical resistance layer. It shall consist of a tough polyethylene backing tape with a very adhesive butyl rubber based layer to assure high bond efficiency with the anti-corrosion inner wrapping tape. The outer wrapping tape shall be principally designed for machine application but shall also permit hand placement. The tape shall possess excellent conformability with the profile when applied over seamed, spiral welded or extruded pipe.

POLYKEN #956 or equivalent.

- Mastic and mastic strip:

A combination of mastic strip and mastic adhesive shall be used for hand wrapping field joints for valves, flanges and fittings, elbows and tees (if required). The mastic strip shall be butyl rubber based with excellent high adhesion properties. The mastic shall be the solvent less type based on butyl rubber. Filler tape can be used.

POLYKEN #930 or equivalent.

### 3.0 HANDLING AND STORAGE OF MATERIALS

- 3.1 All the wrapping materials shall be stored and handled in accordance with the manufacturer's specification.
- 3.2 The piping spools, which have been wrapped at the shop, shall be handled with care to prevent damage to wrapping tapes during transportation and installation. In case that the wrapped piping spools have to be suspended, belt slings or other adequate measures shall be used.