

 GMA PERFORMING SOLUTIONS	No doc. C20049I3122N° pp.10
	Editorial board R&D
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	No. Attachments 

PHENCOTE 2000

Condenser anticorrosive protection TL41

(TUBE SHEET CLADDING AND WATER BOXES)

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Summer

Protection anticorrosion of the CONDENSER TL41. 1

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1. Introduction

From 06 up to 14/06/22

Number tubes	9624
Diameter tube [mm]	22.22
Thickness tubular [mm]	1.245 (18 BWG)
Materials tubes	To the brass
Dimensions plate [mm]	2500x2200
Length tubes [mm]	9140



Fig. 1 - Image pre-works from plates tubes And speakers water; Evidence from a good level from storage of the speakers; the coating of the plates is state in great part for allow installation of the tubes.

The intervention is state coordinated from the supervisor Mr. Faye, with the support from various specialty techniques

2. Preparation superficial

How first they come activities they come installed Protective in PE

The surfaces of the plates tubes was cleaned with degreaser industrial And rinse through pressure washer, with next one drying (08-09 / 06)

The activity involves sandblasting to SA2.5 grade with asilicogenic grit and controlled granulometry (0.5-1.4 mm) grain type (09-10 / 06)



Fig. 2 - Installation Caps in PE Before of the sandblasting



Fig. 3- Wash hydrodynamic plates



Fig. 4 - Preparation superficial plates tubes And speakers water

TO at your place sandblasting he comes carried out a check from roughness with replica tape Testex Press-O-Tape (X- Coarse),with the indication average values of 75 microns.

The removal of the resulting material and aspiration of the powders.

3. Coating application

Yes procedure for check the conditions environmental with thermohygrometer .

Roller application of Phencote HR60 Primer (green) resin on the tube plates until the caps and caps are completely covered. interstices



Fig. 5 - Application primer at plates tubes

Application of a spatula for a thickness about 5 mm of the Phenote 2000 on tube sheets



Fig. 6 - Application Phncote cladding system on plates tubes

Application of the two coats of Phncote HR60WB coating on the surfaces of the water boxes, with preliminary stripe coat on the areas brought to iron after sandblasting (points located on the floor and ceiling of the crates side outputs)

Sanding of the surface of the plates tubes removal of the caps and sealing from defects localized



Fig. 7 - Sanding coating in Phoncote 2000 of the plates tubes



Fig. 8 - Application coating on water boxes

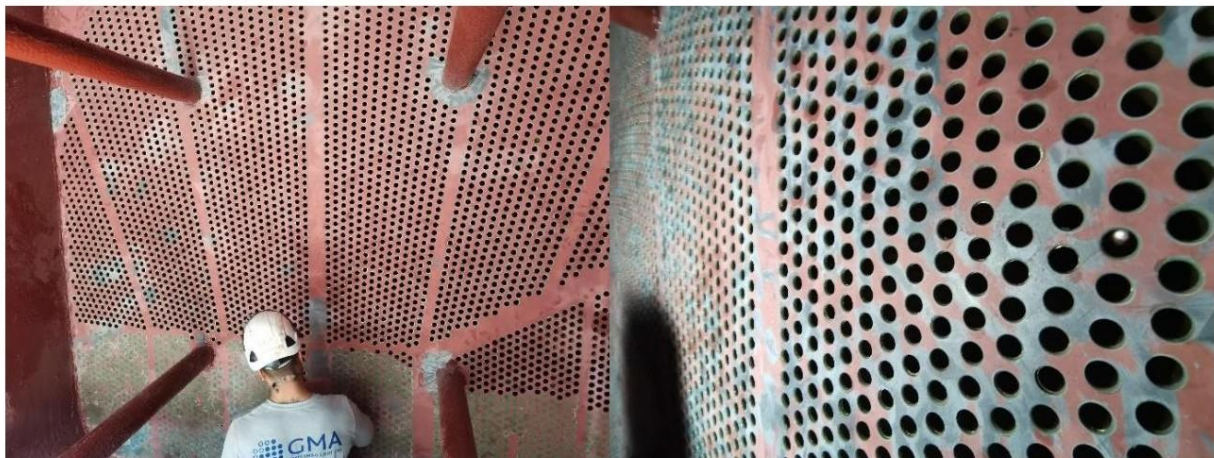


Fig. 9 - Removal caps from coating in tall thickness

Application of the top coat in Phenote HR60TL to the tube plates

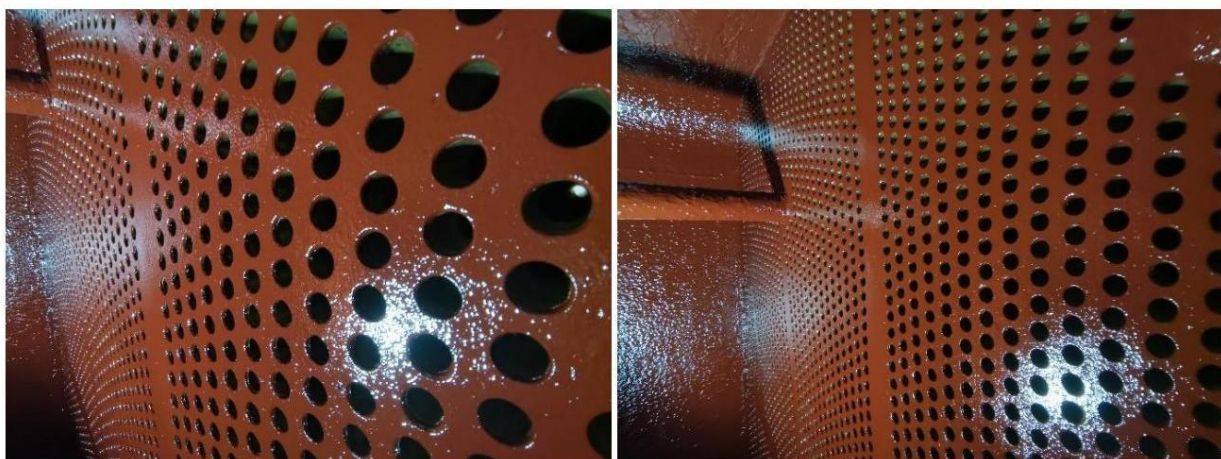


Fig. 10 - Particular appearance the final coating plates

4. Checks And testing

The tests, carried out on 13 and 14/06 (on 14/06 it was also carried out a check by the personal of IREN), expected, in addition to control visual itself, the execution of a thickness gauge and a dielectric check according to NACE SP0188. The checks are passed with positive result.

thickness measurements carried out are listed below on tube plates and speaker surfaces water.

READING-CASES FRONT (µm) - INPUTS

INSTRUMENT: PCE 4T13 - calibration with Elcometro plates

READING AREA	LETTURA			MEDIA PUNTI	OVERALL AVERAGE
	1	2	3		
A	1181	918	1027	1042	1018 micron (̃ 800 µm)
B	879	1003	1155	1012	
.	884	1194	1078	1052	
C	931	1025	944	967	
.	1001	892	1155	1016	
D					
.					
And					

READING-CASES REAR (µm) - OUTPUTS

INSTRUMENT: PCE 4T13 - calibration with Elcometro plates

And

READING AREA	LETTURA			MEDIA PUNTI
	1	2	3	
A	1074	1119	882	1025
B	1169	1031	933	1044
.	1147	1089	963	1066
C	1159	1182	999	1113
.	1095	1028	891	1005
D				
.				

READING-PLATES FRONT (µm) - INPUTS

INSTRUMENT: PCE 4T13 - calibration with Elcometro plates

READING AREA	READING			AVERAGE POINTS	OVERALL AVERAGE
	1	23			
A	4860	4729	5069	4565	5071 micron (y 4000 µm)
B	4428	5082	4877	5530	
C	5109	4137	3911	5473	
D.	4766	5369	4144	4494	
And	4478	5364	4313	5292	

READING-PLATES REAR (µm) - OUTPUTS

INSTRUMENT: PCE 4T13 - calibration with Elcometro plates

READING AREA	LETTURA			MEDIA PUNTI	OVERALL AVERAGE
	1	2	3		
A	5238	4279	5474	5228	4999 micron (y 4000 µm)
B	5340	5220	4978	4820	
.	5362	4358	4437	4203	
C	5462	4935	4993	5592	
.	4773	5745	4577	5152	
D					
.					
And					

Fig. 11 - Check activities



Fig. 12 - Appearance the final coating (speakers side outputs)

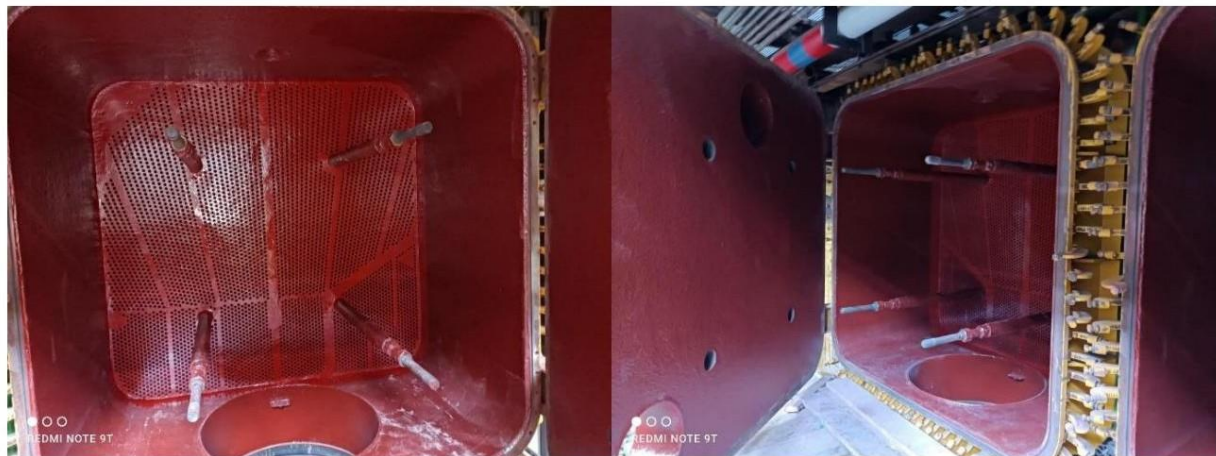


Fig. 13 - Appearance the final coating (speakers side inputs)

In agreement with the checks carried out, according to the requirements of the technical / economic offer , the coating with cycle Phencote 2000TS And Phncote HR60, respectively from plates tubes And water boxes was qualified.

Report compiled there:

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