


SES-755

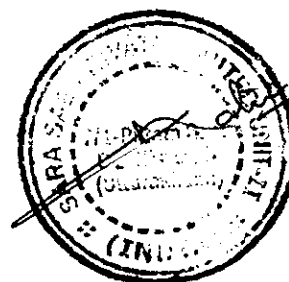
	SARA SAE ENGINEERING SPECIFICATION	
	SECTION SES 26 - 755	
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SPECIFICATION FOR PAINTING WELLHEAD EQUIPMENT

Summary: The purpose of this specification is to establish a painting/coating standard for wellhead equipment.

COATINGS MAY NOT BE USED TO IMPROVE THE MATERIAL CLASS OF THE BASE MATERIAL


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3.2.1 Mask or plug all exposed ring grooves, bleeder ports, and valve bores, grease ports, sealing surfaces, nameplates, exposed stems (e.g. on gate valves and actuators) or other critically machined surfaces before bead or abrasive blasting.

3.2.2 Remove masking after blasting and remove all bead or abrasive blasting material. Blow all abrasive material from holes with air, making sure that it is all dislodged.

3.3 All surfaces that are not to be painted should be masked or plugged after cleaning (3.1 or 3.2). Grease or tape is acceptable as masking material. Mask or plug all exposed ring grooves, bleeder ports, valve bores, grease ports, sealing surfaces, nameplates, exposed stems (e.g. on gate valves and actuators) or other critically machined surfaces before painting.

3.3.1 Grease film thickness for masking should have an approximate thickness of .015 inch (380 microns).

3.4 Prior to painting equipment with weld preps (37 1/2° REF) mask over the length of the bevel or to estimated pipe OD if bevel is larger. Do not use grease or oily substance. After painting remove masking material and residue. No further protection is required.

4.0 PAINTING CALLOUT

4.1 All surfaces which are to be coated/painted should be indicated as follows:

PAINT O.D.


or a note on the DBI...

4.2 All surfaces which are to be masked should be indicated as follows:

MASK (Indicate surface)

or a note on the DBI...



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5.0 RECOMMENDATIONS

Manufacturer – ICI

5.1.1 Product Name: Fast product enamel, Series-75 lead free, prerduced by 15%
VM&P Naptha R1-K-3

5.1.2 Color: Vermilion Red

