

SES-755

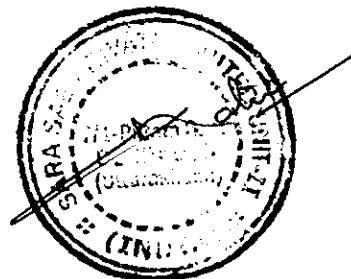
	SARA SAE ENGINEERING SPECIFICATION		
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## **SPECIFICATION FOR PAINTING WELLHEAD EQUIPMENT**

**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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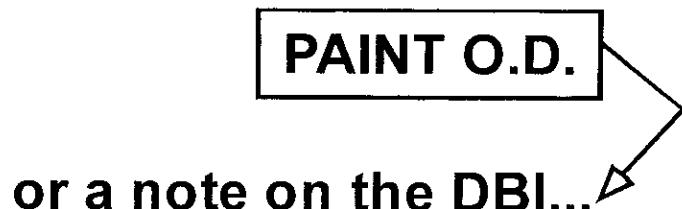


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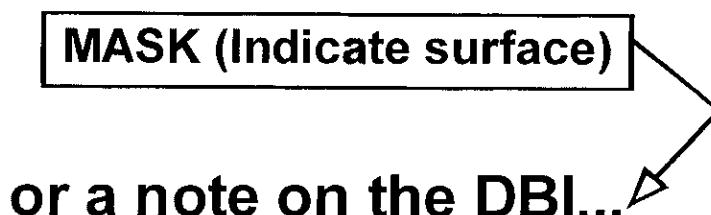
- 3.2.1 Mask or plug all exposed ring grooves, bleeder ports, and valve bores, grease ports, sealing surfaces, nameplates, exposed stems (e.g. on gate valves and actuators) or other critically machined surfaces before bead or abrasive blasting.
- 3.2.2 Remove masking after blasting and remove all bead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



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



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## 5.0 RECOMMENDATIONS

Manufacturer – ICI

- 5.1.1 Product Name: Fast product enamel, Series-75 lead free, prereduced by 15% VM&P Naphtha R1-K-3
- 5.1.2 Color: Vermilion Red

