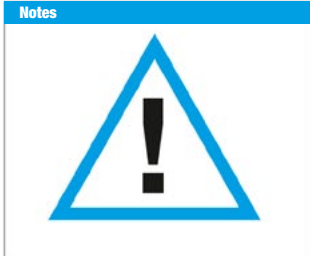




# SEALID®-Tape All-in-1



**Notes**

- Prepare the surface appropriately
- Steel surface  
Cleanliness (ISO 8501-1) min. ST2/SA2½  
Roughness (ISO 8503-1) 50-100 µm
- The pipeline section must be coated immediately after blasting and no more than two hours later.
- For tape widths >50 mm we recommend the use of DENSOMAT® wrapping machine for easier application.
- The following application instruction can also be transferred to the wrapping of full pipe length or pipe bends.
- Meet the standards:
  - Minimum overlap  
ISO 21809-3, Type 12A-2: min. 50 %  
EN 12068, Classe C50: min. 67 %
  - The characteristic values were determined in accordance with the standards on a blasted surface (SA 2½).
- In order to avoid wrinkling due to thermal elongation of the carrier film, the temperature difference between pipe surface (before and after tape application) and tape roll should be max. +25 °C (+45 °F).  
In the case of several days of strong sunlight exposure, the finished wrapping should be covered with a suitable material (e.g. DENSOLEN®-DRM PP Rockshield).

**1. Cleaning and Drying**

- The areas to be coated (steel surface and adjacent factory coating) have to be clean, dry, and free from grease and dust.
- Humidity and ice have to be removed by drying with a torch flame.
- All contamination which might act as a release agent (e.g. grease, oil, varnishes, temporary protecting paints, coupling agents) have to be completely removed prior to tape application.

**2. Surface Preparation**

- The surface must be adequately prepared and have a degree of cleanliness of at least ST2/SA2½ (do not polish the surface)
- Any existing mill scale has to be removed by abrasive blast cleaning.

**3. Transition to Factory Coating**

- Transitions to adjacent factory coating should be bevelled by use of a round shaped rasp (recommended angle: ≤ 30 °).  
Remove grinding dust.

**4. Preparation of Factory Coating**

- Adjacent factory coating has to be circumferentially roughened as minimum in double tape width with coarse emery cloth.
- Remove grinding dust and then clean properly.

**5a. Initial Wrapping Position**

- Wrap with the green side of the tape facing the surface of the pipe under uniform tension.
- Sufficient tape tension is applied if tape width is narrowed by app. 1 % during application.
- Remove release liner.
- The tape is applied to the factory coating with the outer edge of the tape at a distance of at least 1.5 times the tape width from the surface of the steel pipe. The start of the tape must point to the underside of the pipe (8-10 o'clock position).
- **The first wrap must be done with a complete overlap (100 %).**

**5b. Wrapping**

- Spirally apply the following wraps with the above-mentioned minimum overlap.

**5c. Final Wrapping Position**

- The end of the wrapping is done on the factory coating with the outer edge of the tape at a distance of at least 1.5 times the tape width from the surface of the steel pipe.
- The last wrap has to be done with a complete overlap (100 %). The tape must end at the same level as the tape started but on the opposite side of the pipe.

**8. Testing**

- No wrinkles are allowed in the finished wrapping based on visual inspection.
- The wrapping has to be tested for absence of porosity with high voltage holiday detector.  
Test voltage: 5 kV + 5 kV per mm of coating thickness, max. 25 kV.

Product	Coating application temperatures °C (°F)			Max. temperature difference between the surface and the material °C (°F)	Storage temperature °C (°F)
	Material	Pipe surface	Environment		
SEALID®-Tape	+20 to +50 (+68 to +122)	> +5 (+41) and min. +3 (+5,4) above dew point	-40 to +60 (-40 to +140)	< +25 (< +45)	≤ +40 (≤ +104)
Surface preparation	The specific application instructions must be followed.				
Health, safety & environmental protection	The application must comply with all environmental & safety regulations locally applicable. All safety and environmental instructions on product labels and safety data sheets must be applied. Wear personal protective equipment such as safety goggles, safety gloves and appropriate work clothing. Cover the ground to protect against contamination.				

**More information:**

