



METHOD STATEMENT n. 1
STEEL PILES COATING IN WET AND SPLASH ZONES WITH SUBCOM T.260
EPOXY MASTIC DESIGNED FOR UNDERATER AND OTHER WET APPLICATIONS

- Marking of the piles to determine the coating position.
- Removal by scarping or other adequate means of all the marine growth and/or foreign materials in the area to be coated.
- Accurate sandblasting to reach a surface preparation equivalent to Swedish Standard SA 2,5. (Since the structures are in a highly aggressive environment, Swedish standard sample plates or comparison photos do not apply).
- Mix the two components (A yellow colour + B blue colour) of SUBCOM T.260 1:1 by volume the blue and yellow becomes a uniform green, without stripes.
During mixing, keep the gloved hands and the material wet with sea water.
Do not mix more material than can be applied in the working time. After the time limit is exceeded material will not adhere properly to the substrate.
- Spread and press carefully SUBCOM T.260 by hand, on the surface to be coated, to achieve an average film thickness of 4-6 mm., with an expected consumption of 7-9 Kg/sq.m. (In case of pitting, allow for adequate extra quantities of Subcom T.260).
- Double check the coated area the following day, to touch-up pinholes or small holidays, if any.
- To guarantee a good adhesion of Subcom T.260 to the steel piles, impressed current systems, if installed, must be switched off, from the interested sections at least 7 days before its application.
- When Subcom T.260 is fully cured (7 days from application) it will be possible to switch on and slowly increase the impressed current system to reach gradually (6-8 days) the polarization of the structure, avoiding power peaks, which could cause hydrogen release.
- Since application requires reasonable waves/current condition to both avoid possible harm to divers and consent a valid first grip to Subcom T.260 during the early curing stage (about 2-3 hours), the Site Supervisor shall decide upon the most suitable working periods during the day.
- According to our experiences a team of 3-4 divers assisted by 2 skilled workers in charge of sandblasting equipment and mixing of Subcom T.260 can coat, in favourable conditions, an average of 12 sqm/day.