

# VISCOTAQ™ TRANSITION COATING (SOIL/AIR)



The soil-to-air interface can be a problematic area for coatings and a common place for corrosion. Risers and soil-to-air transitions are especially sensitive to corrosion due to the movement of the soil, bacteria, weather cycles (freeze/thaw), oxygen and pH levels.

Viscotaq™ is an ideal corrosion prevention coating for these transitions. It can be applied with minimal surface preparation, does not require primer and forms a homogeneous continuous, self-healing corrosion prevention coating. Viscotaq bonds at a molecular level creating an impermeable barrier to moisture and oxygen. It shows excellent adhesion to the steel surface but also to underground and aboveground coating systems, essential for a transition coating. In addition, it always remains in a semi-solid state that provides high impact strength and allows for a high resistance against sheering. Ease of application and outstanding performance is what makes Viscotaq™ an excellent technology for corrosion prevention.

- The transition from soil to air of a pipeline is extremely sensitive to corrosion.
- Underground and aboveground coatings can be different; the transition coating must show excellent adhesion to both types of coatings.
- Always start wrapping from the bottom to the top: the overlap is then on top of the previous wrap in the upper direction.

## COMPOSITION

Viscotaq™ is a non-crystalline a-polar viscous elastic (visco-elastic) semi-solid polyolefin coating for corrosion prevention of underground and aboveground substrates.

Viscotaq's molecular chemistry is unique and designed in such a way that the viscosity gives it permanent wetting characteristics and the elasticity of the product provides the strength and feeling of a semi-solid. The Viscotaq compound bonds to the substrate by means of Van der Waals principles, penetrating the pores and anomalies of the substrate. The compound remains in intimate contact with the substrate creating an impermeable homogeneous corrosion prevention coating.

## COMPONENTS

Viscotaq ViscoWrap™ (ST, HT or XHT)

Viscotaq™ Outerwrap (PVC, PE, HDPE or Denso Glass Outerwrap, if required)



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## METHOD OF APPLICATION

**Note:** Protect the riser with a minimum of 1-1/2 ft./0.5 m below the soil/air transition.  
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### 1. Surface Preparation:

All surfaces shall be cleaned of mud, mill lacquer, wax, tar, oil, grease, or other foreign contaminants.

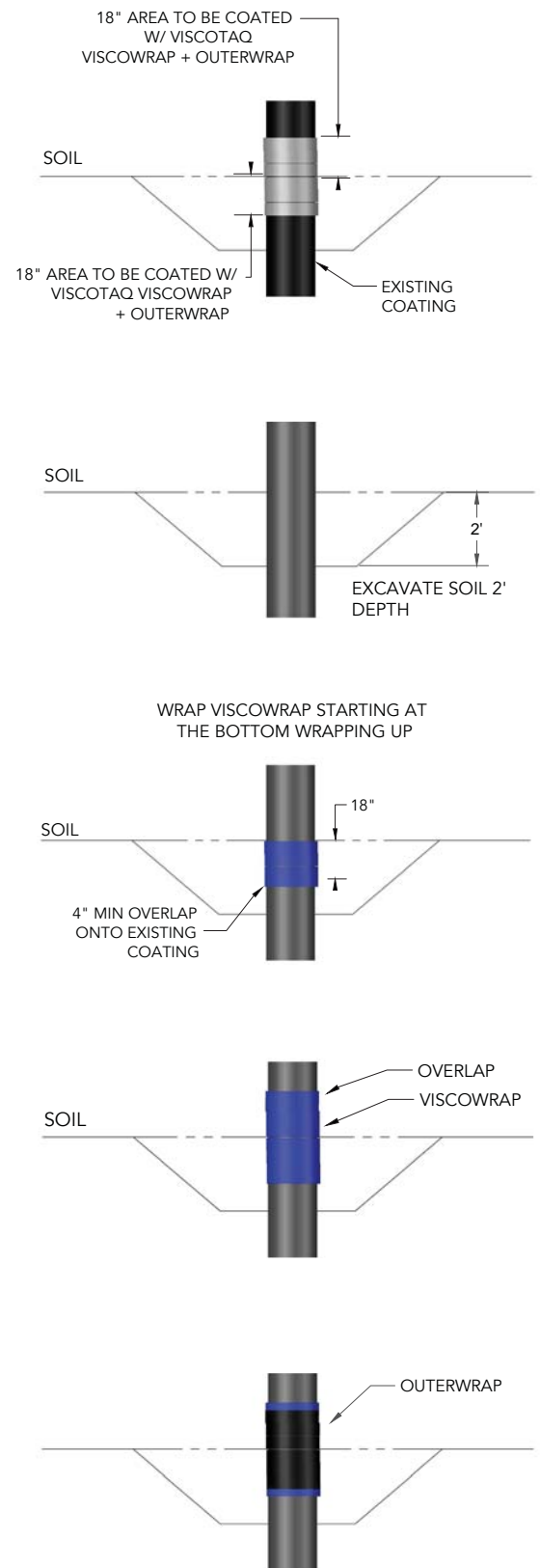
- Edges of the plant/existing coating shall be bevelled, and the plant coating shall be roughened over a minimum length of 6"/15 cm.
- Surface preparation may be carried out by a wire-brush cleaning to a minimum degree of cleanliness of ISO 8501-1, grade St 2 (SSPC SP 2), but preferably power brush cleaning, grade St 3 (SSPC SP 3 / SSPC SP11) or commercial blast-cleaning to a minimum degree of cleanliness of ISO 8501-1, grade Sa 2, SSPC 6.
- Dust contamination shall be grade 3 or better measured in accordance with ISO 8502-3. Remove any grease and dust with industrial alcohol (SP 1, solvent cleaning) using lint free wiping rags.
- All cleaned areas shall have protective coating applied before end of shift. If a cleaned surface does not get coated, it shall be re-cleaned on the shift.
- An alternative peel test procedure is recommended prior to application. Please refer to the Viscotaq Technical Manual for full surface preparation and peel test requirements.

### 2. Viscotaq ViscoWrap™

- The existing factory coating must be bevelled to an angle of 45 degrees (if applicable). In case of thick coatings, bitumen or coal tar enamel, a bridge should be made on the bare steel onto the coating transition with a straight circumference wrap first. This initial circumference wrap will allow proper wrapping over the 45-degree angle.
- Begin straight on the existing factory coating overlapping.
- Overlap onto the existing pipe coating: < 30" pipelines 4" overlap, > 30" pipelines 6" overlap.
- Once the initial straight circumference wrap is complete, wrap it with slight tension up the pipe starting on the first wrap.
- Wrap at an angle to create a smooth overlap and to ensure no air pockets are formed during wrapping.
- ViscoWrap shall be applied with a minimum of 1/2"/1cm overlap.
- End wrapping of ViscoWrap with a straight wrap overlapping onto the existing coating with a minimum of 6"/15 cm.

### 3. Viscotaq™ Outerwrap

- Outerwrap shall be wrapped with a minimum of 50% overlap.
- Wrap in the opposite direction of which the ViscoWrap was applied.
- The first wrap should be a straight circumference wrap; followed by wrapping with tension down the pipe. Wrapping should end on a 4 o'clock position and last wrap should be applied onto the pipe without tension.
- A 1/4"/6 mm section of ViscoWrap material should be visible after the Outerwrap had been applied unless otherwise specified by the end user.
- Denso Glass Outerwrap can be used in place of or in addition to the PVC or PE when additional mechanical protection is required.



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