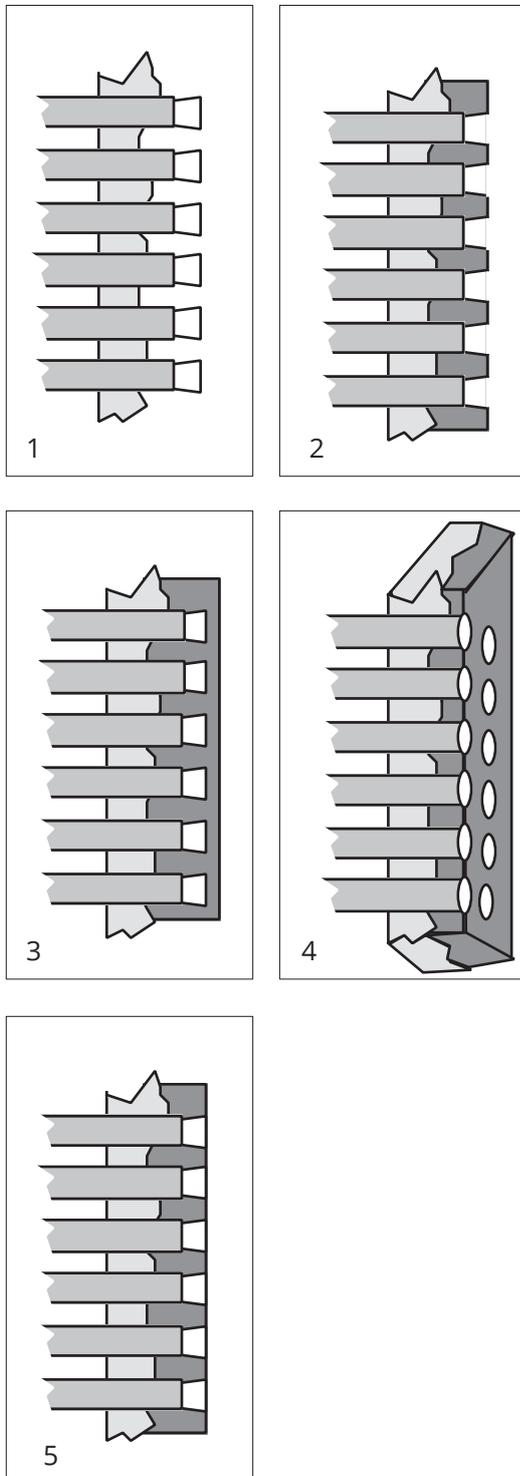


Tube end plates - corrosion



Corroded tube end plates provide an excellent example of how a surface repair should be carried out. The accuracy of the preparatory work is of great importance.

1. Insert rubber plugs in the tubes to protect these when shot blasting. Shot blast the tube end plate acc. to Wencon surface preparation, next page.
2. Replace the rubber plugs with cork plugs treated with Wencon Release Agent, and having a diameter 2 mm smaller at the one end than the inner diameter of the tube, 2 mm (0,08 inch) larger at the other end. Insert the cork plugs in the tubes, and to ensure they sit level, knock into plan by using a piece of wood or the like and a hammer.

Mix and apply a thick layer of Wencon Cream, and cover the cork plugs completely.

3. After curing, grind the surface to develop the plugs again. Because of this grinding it is not recommended to rebuild a sealing surface which mates with the end cover, if the surface is not corroded. If, however the sealing surface is in need of repair, wait until the above application has been done, and then build up the sealing surface as follows. First apply a coat of Wencon Release Agent on the flange, then apply a coat of Wencon Cream on the sealing surface, and then fit the cover into position before curing.
4. Remove the plugs. Preferably by means of a wooden screw in a drilling machine that can rotate in both directions. You can also push them out from the opposite end with a rod, or use compressed air.
5. Finally, apply two coats of Wencon Coating (see instructions). Use a paint roller for this - a thin one with hard felt covering - to avoid coating material coming into the tube ends.

Wencon surface preparation

Choose the relevant surface preparation, depending on the nature of the job.

Surface preparation using dry blasting methods:

Application with Wencon products on a dry surface, at minimum 3°C. above dew point.

1. Blast the machine part to SA 2,5 using sharp-edged blasting media, to a roughness of min. 75 microns.
2. Leave the part for sweating out salts in a warm place for at least 12 hours or heat it up to 30 - 40°C (86-104 °F) using gas torches.
3. Blast again to SA 2,5, prior to the application.
4. For parts containing a lot of water and salt, it may be necessary to repeat point 2 and 3, until the surface remains light grey, for at least 2 hours after blasting.
5. For optimal adhesion of Wencon products, always use Wencon Bio Cleaner or Wencon Cleaner prior to application. Follow one of below two methods:
 - 5.1 **Wencon Bio Cleaner**
Wet surface: Apply Wencon Bio Cleaner and let it work for 5-10 min. If necessary use a brush, to make sure the surface is clean. Rinse off with clean water and wipe off with an absorbing cloth. Apply Wencon UW Coating as a primer, and hereafter any Wencon products can be applied.

Dry surface: Apply Wencon Bio Cleaner and let it work for 5-10 min. If necessary use a brush, to make sure the surface is clean. Rinse off with clean water and dry with an absorbing cloth or with compressed air for a completely dry surface. Hereafter any Wencon products can be applied.
 - 5.2 **Wencon Cleaner**
After surface preparation, apply Wencon Cleaner with a brush and allow the product to evaporate before applying other Wencon products. Wencon Cleaner is non-flammable. Use only in large or well ventilated rooms.

Surface preparation using wet/damp methods:

Water jet the entire surface with water and sand to a standard equal, to SA 2,5 as described above.

If the surface is left wet after surface preparation, is it important to dry out the surface or alternatively use a Wencon UW product as a primer.

Surface preparation for emergency/temporary applications:

If above surface preparation methods are not possible, it may be necessary to use one of below methods:

- Blasting
- Grinding
- Needle Gunning

In emergency / temporary applications it may be difficult to prepare the surface according to above methods. In any case, it is important to clean the surface to SA 2,5 and 75 microns roughness. If possible dry the surface before applying. If not possible, use Wencon UW products prior to applying any other Wencon products.

For further information on Wencon surface preparation, please contact our Area Sales Managers.