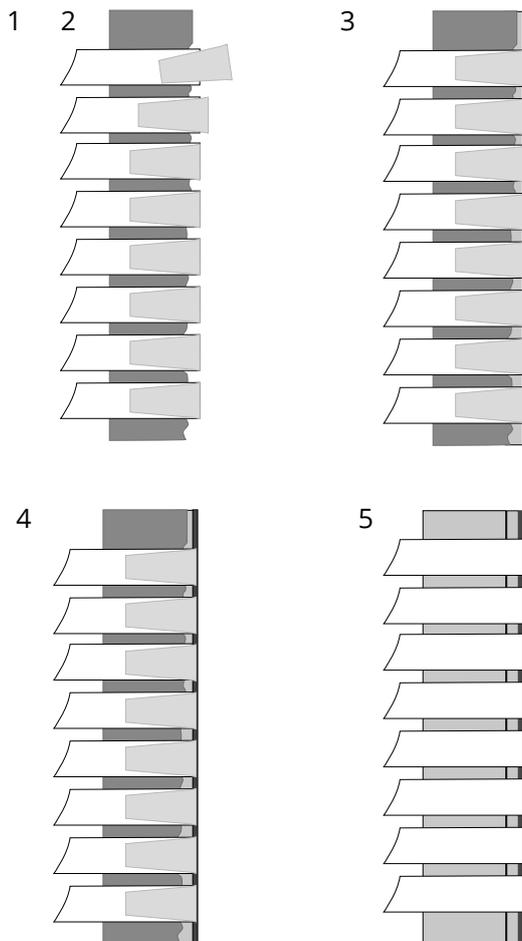
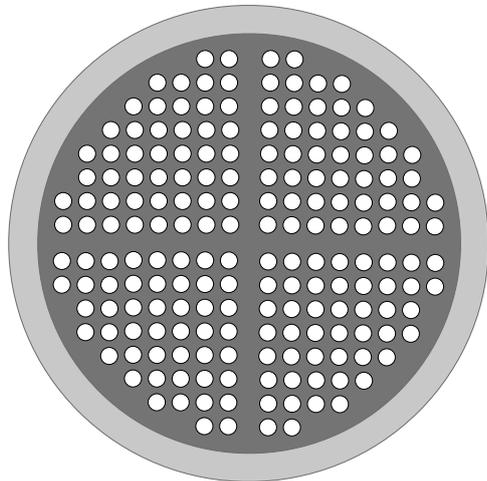


Tube end plates - corrosion

APPLICATION DATA SHEET No. 118



Corroded tube end plates can be rebuilt and protected against further corrosion using a Wencon Solution. However the result greatly depends on the preparations and accuracy of the work done. These are the steps we recommend.

1. Insert plugs in the tubes to protect these while grit blasting. Grit blast the tube end plate acc. to Wencon surface preparation, see next page.
2. Replace the plugs with new plugs treated with Wencon Release Agent. Knock the plugs all the way into the tubes and ensure they sit level/flush .
3. Mix and Wencon Cream or Wencon Rapid and apply to the the surface untill it is sufficiently rebuilt.
4. While the first layer is curing, Semi-cured, apply one layer of Wencon Coating, it is okay if it covers the plugs.
5. Remove the plugs while the coating is still wet.

NB. If there is a need to rebuild a sealing surface that mates with the end cover, wait until the above application has been done, and then build up the sealing surface as follows.

1. First apply a coat of Wencon Release Agent to the flange, then apply a coat of Wencon Cream on to the sealing surface, and then fit the cover into position before curing.
2. Finally, apply two coats of Wencon Coating using thin hard felt paint roller. Avoid getting coating material 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.

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.

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.

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