

General Aquawrap® Install Steps For Carbon Steel Pipelines Onshore

- For external corrosion less than 80% wall loss and dents less than 6%. Grind gouges sharp edges smooth with 60% wall remaining. Not for cracks or internal corrosion.
- Get a repair calculation before installing **Aquawrap®** Phone: **817-240-6434**.
- Install when pipe surface temps are between 40-200F and outside temp is greater than or equal to 33F.
- Sandblast pipe (NACE 2 Finish).
- Clean sandblasted pipe surface with Acetone or MEK.
- Fill-in ALL voids: (**911,913, or 563**) and primer:(**BP-1, 913, or 563**) over ALL of the pipe repair area, as shown in the two photos on the next page in step 2. Allow primer to become tacky/sticky before applying Aquawrap over it.
- Ok to use (**913 or 563**) as the filler/primer, allow it to become tacky/sticky before applying Aquawrap over it.
- If using BP-1 Primer, it is NOT a void filler: **Scrape** the bottom of both part A & B cans, which have solids settled at the bottom of each can, then stir them individually before mixing them together using a 1 to 1 ratio, then stir the ratios together thoroughly until one solid color and streak free).
- Apply **Aquawrap®** (G-05 material **Circumferentially Wrap**, G-03 material **Spiral Wrap**)
- Note: **Never apply more than 16 layers of Aquawrap® at one time.**
- Within a few minutes, apply 3 layers of blue plastic stricture over **Aquawrap®**, and in the same direction that the **Aquawrap®** was applied around the pipe, then perforate the plastic, within a few minutes.
- Remove the blue plastic within 10-15 minutes, if applying more layers/multiple courses, or anytime after 1 hour once all layers are installed.
- Apply metal bands over each end of **Aquawrap®** for future PIG/ ILI detection.
- **Aquawrap®** is ready to be tied-into your adjacent/existing coating, using your approved top coat or tape product, once your thumb nail cannot be pressed into **Aquawrap®**. If leaving above ground, then top coat the entire repair with a UV coating within 1 week after installation.
- For quick 60 minute recoat purposes you can install **Aquawrap®** 3 layers and 2 layers over seams when butting up sections. Make sure to tie-in each end of the Aquawrap repair with your approved epoxy or tape coating.

Typical Aquawrap® Installation Process

For steel substrates, it's recommend cleaning to bare metal, NACE II or SSPC-10 level. The better the cleaning and preparation, the better the wrap will bond/adhere to the pipe. For concrete surfaces, above and below the water line, all loose debris, coatings, marine growth, etc. must be removed. This can be done with high pressure water blasting or sand blasting.



Step 1:
Sand Blast to
NACE II Near White
Finish. Acetone or MEK
pipe.

Step 2:
Fill-in ALL voids and primer over ALL
of the pipe repair area, as shown
above in the two photos. Allow primer
to become tacky/sticky before applying
Aquawrap over it.

Fillers: Gray 911, 913, 563

Primers: White BP-1, Gray 913, 563

Fillers/Primers: Gray 913, 563

For few pits, fill with 911, once dry 5-7
min. roughen up with sandpaper, then
primer. For many pits, fill/prime with
913 or 563, which sets-up slow
enough to wrap over once tacky/sticky.

Step 3:(First get Aquawrap® Calculation **817-240-6434**)

Apply Aquawrap® one of the two following ways:

1. Aquawrap® G-05 circumferentially wrap the required
number of layers directly on top of one another, but if
more than 16 layers, then reinforce with the stricture
blue plastic, perforate it, and then remove in 10-15
minutes, to apply more layers. For repairs longer than
the roll's width, apply the same number of layers butted-
up adjacent, and half of the layers over the seams, when
using the same size roll width. When using combination
of 8" and 12" size roll widths, apply at least 3 layers on
bottom and half or more the required layers over seams
to achieve required layers, same length on top/bottom,
but offset seams: start bottom with 12" and top with 8".
2. Aquawrap® G-03 spiral wrap roll width that is equal to
or less than the pipe's outside diameter. Example: 12.75"
pipe OD, use 12" wide roll or less.

Typical Aquawrap® Installation Process



Step 4:
Immediately after applying Aquawrap®, wrap three layers of the blue stricture around it tightly, and perforate it so excess water will gas out as Co2.



Step 5:
Wait at least one hour to remove blue plastic. Once you cannot press your thumb nail into Aquawrap® then move on to step 6.



Step 6:
Place metal band around each end of the repair area for pigging purposes if necessary, then tie-in coating with your approved epoxy or tape. If leaving above ground then top coat the entire Aquawrap® repair with your approved UV coating.