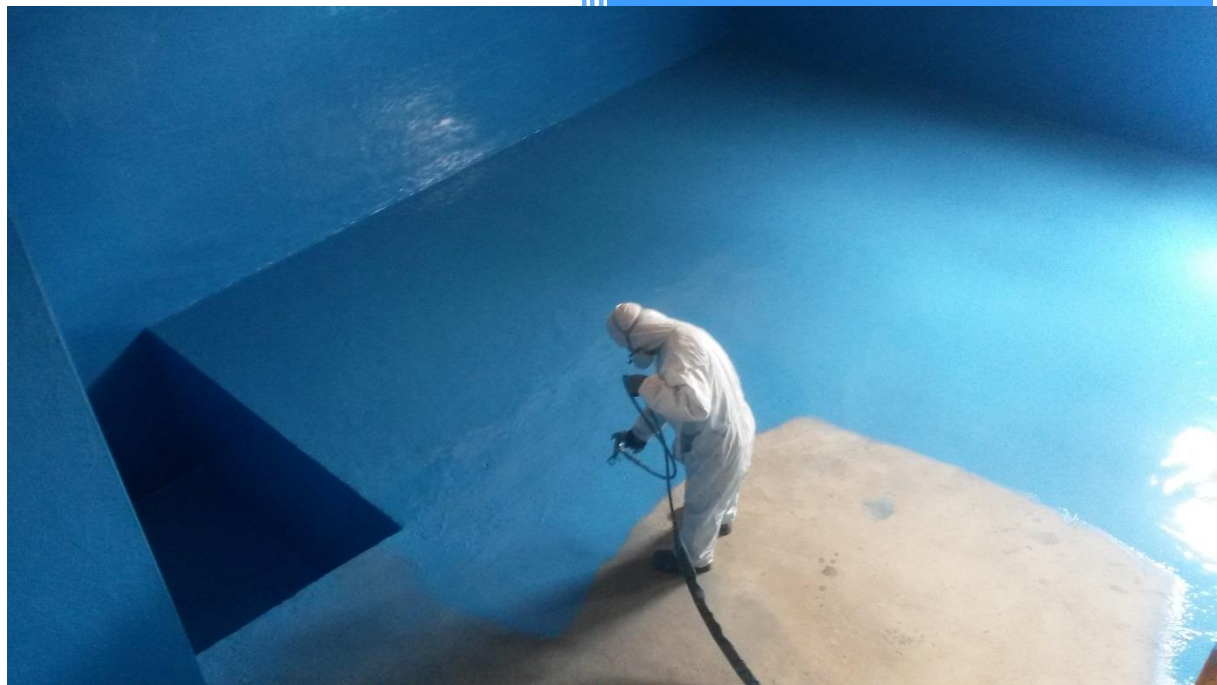




## Procedure for waterjetting used in combination with Humidur<sup>®</sup> coating systems



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## 1 Introduction

This guide provides an in depth description of the process of waterjetting as surface preparation prior to the Humidur® application. Note that only the procedure described hereafter is approved by Acotec.

For more information about the application process of the Humidur® coating system, consult the application guides and manuals available on [www.humidur.be](http://www.humidur.be).

## 2 Surface preparation: Waterjetting

**Before coating application, all surfaces shall be free of oil, grease, dirt or any other contamination.**

The visual standard for waterjetting, developed by SSPC and NACE International, illustrates four cleanliness conditions.

### 2.1 Precleaning

The procedure for precleaning as described in NACE WJ-2/SSPC-SP WJ-2 or NACE WJ-3/SSPC-SP WJ-3 should always be done before waterjetting.

### 2.2 Waterjetting

The required cleanliness degree prior to Humidur® application is at least WJ-3; better is WJ-2. The visual assessment is described in Table 1. Note: WJ-4: Light cleaning is not accepted.

The pressure of the water should be at least 70 MPa (10,000 psi). The water shall be of sufficient purity and quality.

TABLE 1

Cleanliness degree	Title	Description
<b>WJ-3</b>	Thorough Cleaning	Surface area shall be cleaned to a matte finish with at least two-thirds of the surface area free of all previously existing visible residues (except mill scale) and the remaining one third containing only randomly dispersed stains of rust, coatings, and other forms of foreign matter.
<b>WJ-2</b>	Very Thorough Cleaning	The surface shall be cleaned to a matte finish with at least 95% of the surface area free from all previously existing visible residues and the remaining 5% containing only randomly dispersed stains of rust, coatings and foreign matter.

### 2.3 Inspection

After waterjetting the surface preparation shall be checked:

- Surface has to be free of any standing water
- No contamination is allowed (dirt, grease, oil)
- All dust shall be removed
- The surface profile shall be assessed (The roughness shall be at least  $\pm 60 \mu\text{m}$  or 2 or 3 according to ISO 8503)
- Degree of Flash Rust must be assessed (see Appendix B of the mentioned NACE Standards):  
Light Degree is accepted, Moderate Degree is rejected



A corrosion Inhibitor can be used to prevent or minimize flash rust on the surface : Chlor\*Rid is approved by Acotec for this purpose.

Coating application shall start as quick as possible after waterjetting.