External Coating Process Flowchart

1. The entrance control of pipes. Visual inspection
2. Preliminary heating in the gas furnace
3. Abrasive cleaning of external pipes surface in a shotblast unit by steel chipped fraction
4. Removal of dust from pipes internal cavity by a purge
5. Visual inspection of pipe
6. Having heated pipes
7. Having heated pipes
8. One- and two-layer FBE coating
   a) Epoxy powder paint coating
   b) Epoxy impact-resistant coating (only in case of a two-layer coating)
9. Three-layer PE and polypropylene coating
   a) Epoxy primer coating
   b) Adhesive coating
   c) Polyethylene (or polypropylene) coating
10. Water cooling of coated pipes
11. Uniformity coating inspection with high-voltage flaw detector
12. Coating removal from pipe ends
13. Final quality inspection of coated pipes (visual)
14. Pipe marking. Pipe storage

Internal Coating Process Flowchart

1. Pipe storage before pipe delivery
2. Pipe incoming control
3. Pipe heating
4. Internal pipe surface degreasing
5. Second heating of pipes
6. Internal pipe surface blast cleaning in Shot Blaster ¹ 1
7. Blaster internal surface quality examination
8. Internal pipe surface blast cleaning in Shot Blaster ¹ 2
9. Internal surface blowout
10. Internal surface preparation quality inspection
11. Coating application on pipes (in coating chamber)
12. Internal coating pre-curing
13. Pipe induction heating
14. Pipe coating curing in the full-polymerization chamber
15. Internal flow coating quality inspection
16. Marking of coated pipes. Stacking of pipes provided tarpaulin protective caps