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KLM Technology Group #03-12 Block Aronia, Jalan Sri Perkasa 2 Taman Tampoi Utama 81200 Johor Bahru Malaysia	PAINTING REPAIR PROCEDURE (PROJECT STANDARDS AND SPECIFICATIONS)	

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SCOPE

This procedure covers the minimum requirements on the surface preparation and painting / coating for the touch-up and repair of damaged external or internal surfaces of existing structures and facilities including structural steel works, process piping, pressure vessels, galvanized surfaces and equipment.

PURPOSE

This procedure outlines the general requirements for the repair of painted/coated surfaces.

REFERENCES

SSPC-SP 1	Solvent Cleaning
SSPC-SP 2	Hand Tool Cleaning
SSPC-SP 3	Power Tool Cleaning
SSPC-SP 10	Near-White Blast Cleaning
SSPC-SP 11	Power Tool Cleaning to Bare Metal

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DEFINITIONS

Contractor: A firm that performs paint removal, surface preparation, and coatings application in the industrial market.

Painting System: A term intended to include, with equal emphasis, not only the well accepted components of the system such as surface preparation and paint materials, but also the application, inspection, and safety function.

Coating System: A term which refers to the applied and cured multi layer film or the components of a system based on non-paint type coating.

Work: A term which refers to all works associated with the selection of the painting and coating systems, surface preparation, paint application, and inspection.

Repair - Minor repair of coated / painted surfaces.

SSPC - Steel Structures Painting Council

Dft - Dry Film Thickness

Wit - Wet Film Thickness

PROCEDURES

1. General Requirements

- i. Every possible precaution shall be taken to ensure that the damaged surface(s) shall be thoroughly clean, dry, free from condensation, moisture, dust, oil grease, rust, dirt and other contaminants before the application of the touch-up/repair processes.
- ii. Blast cleaning and painting shall not be conducted when the surfaces are less than 3 °C above dew point or when the relative humidity of the air is greater than 85%.

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- iii. Any paint found to be incorrectly applied shall be removed and repainted to the appropriate painting/coating requirement.
- iv. Surface preparation, whenever possible, shall be carried out by dry blast-cleaning. Where dry blast cleaning is not feasible due to limited access, risk of damage to equipment, light gauge steel, proximity to electrical or instrumentation components, hand or power tool cleaning shall be applied. This shall be followed by solvent cleaning prior to painting.
- v. Where the damaged surface being repaired lies adjacent to a previously coated surface, the cleaning shall extend to the surrounding coating by a minimum of 25 mm on all sides and the edges shall be "chamfered" to ensure continuity of the patch coating.
- vi. Appropriate protection, shields or screens shall be used to cover the remainder of the previously coated surface to prevent any possibility of damage to or contamination of the coating before starting any repair work.
- vii. Any paint coating found inadvertently applied to areas where it is not required e.g. machined or polished surfaces, surface of stainless steel or non-ferrous alloys, name plates, manufacturers identification tags, instruments and instrument glasses, sight glasses, control valve stem, high friction grip bolt assemblies, etc. shall be hand wiped clean with thinner or cleaner while the coating is still wet or rubbed down with fine sand paper if it is dry and restored to their original surface condition.
- viii. The use of brushes or rollers for touch-up/repair on localized damaged surfaces where proper coating by spray application is not feasible may be used upon COMPANY approval.

When using brushes, ensure that a smooth coat, as uniform in thickness as possible, is obtained with no deep or detrimental brush marks.

Paint shall be worked into all crevices and corners. Runs and sags shall be brushed out immediately during paint application.