

EN ISO 21809-2011

EXTERNAL THREE-LAYER POLYETHYLENE COATING

Coating thickness:

Weight of 1 meter of pipe Pm/m (kg/m)	Total coating thickness, at least, mm					
	Class A1	Class A2	Class A3	Class B1	Class B2	Class B3
Pm ≤ 15	1.8	2.1	2.6	1.3	1.8	2.3
15 < Pm ≤ 50	2.0	2.4	3.0	1.5	2.1	2.7
50 < Pm ≤ 130	2.4	2.8	3.5	1.8	2.5	3.1

Coating type:

Coating classes:

Class A – used for application at pipeline service temperatures from minus 20 °C to plus 60 °C.

Class B – used for application at pipeline service temperatures from minus 40 °C to plus 80 °C.

Acceptance testing of pipes with coating:

- external appearance of coating check;
- length measuring of bare ends;
- taper angle measuring coating to the pipe's body;
- dielectric coating integrity testing;
- thickness of coating testing;
- strength test of coating with the impact up to (23±3) °C;

Peel force control:

Class A – at temperatures of plus 23 °C and plus 60 °C;

Class B – at temperatures of plus 23 °C and plus 80 °C;

- cathodic disbondment test;
- hot water coating test.

