

Approval & Reception Procedure

DMC – Departamento de Materiais de Construção	
Protective Coating on Sewerage Concrete Pipes	Document No. ARP/DMC/03
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1. Reference Standards

RADARM Art. 89 and project specification.

2. Approval Procedure

The manufacturer's catalogue and technical specifications of coating material shall be submitted.

For approval of the proposed materials, the project specification should be considered.

3. Reception Procedure

The painted sewerage pipes shall be inspected before the coating thickness test. The internal surface and both ends of the pipe shall be appropriately coated.

The concrete pipes shall be divided in lots in accordance with the following:

Nominal Diameter up to DN 600: 100 pipes per lot or part thereof.

Nominal diameter over DN 600: 50 pipes per lot or part thereof.

For each lot, two pipes that represent the actual conditions shall be selected for the testing. The thickness shall be measured at 5 points uniformly distributed in the internal surface of each selected pipe. For each point, 4 readings must be taken.

For those small diameter pipes where the coating thickness test could not be done, visual inspection should be done before installation.

4. Acceptance Criteria

The recommended minimum dry film thickness is 200 microns, i.e. all the measured points shall be equal to or greater than 200 microns. If any higher value is specified in the specification project, the dry film thickness test results should conform to that specification.

In case only one pipe fails to comply with the requirements, two additional pipes shall be selected and tested. If the results of the additional pipes comply with the requirements, the lot shall be accepted and the non-compliance pipe shall be repainted. If not, additional coating shall be applied and retest shall be done.