



Standard Practice for Qualification of Coating Applicators for Application of Coatings to Steel Surfaces¹

This standard is issued under the fixed designation D4228; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This practice provides a standard qualifying method for coating applicators to verify their proficiency and ability to attain the required quality for application of specified coatings to steel surfaces including those in safety-related areas in a nuclear facility.

1.2 Variations or simplifications of the practice set forth herein may be appropriate for special coating work such as maintenance or qualifications of equipment suppliers shop personnel. It is not the intent of this practice to mandate a singular basis for all qualifications.

1.3 Evaluation of the coating applicator being qualified in accordance with this practice, shall be by qualified agents as specified in 4.1. Reports shall be prepared as specified in Section 5, and certification as specified in Section 6.

1.4 It is the intent of this practice to judge only the ability of the coating applicator to apply specified coatings with the proper tools and equipment.

1.5 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

1.6 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Terminology

2.1 Definitions:

2.1.1 *coating applicator, n*—an individual who has worked in the painting trade sufficiently long enough to master the use of all applicable tools and the materials being applied.

2.1.2 *governing documents, n*—technical specifications, jobsite procedures, and reference documents.

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2.1.3 *qualifying agents, n*—the designated representatives of the owner or of the coating organization, or both, who have sufficient experience in the practical application and evaluation of coatings applied to steel surfaces.

3. Application of Coatings

3.1 This practice requires the coating applicator to apply the specified coating in conformance to the governing documents to a test panel similar to that detailed in Fig. 1. A physical test area may be selected by the owner/representative. The test area shall simulate job conditions and acceptance criteria shall be the specification requirement. This panel is typical of the panel used for qualification, and may be modified to suit site configurations.

3.2 This practice requires the coating applicator to perform the application using the proper technique and application equipment consistent with the specified coating materials.

3.3 The surfaces of the test panel shall be prepared in accordance with the governing documents.

3.4 Place the test panel approximately 12 in. (305 mm) above ground level and at approximately 30° from the vertical plane, with the complex side up. This will simulate the types of difficult coating situations encountered by coating applicators.

3.5 The coating applicator shall demonstrate his ability to apply the specified coating to a uniform dry-film thickness in accordance with the governing documents, as evaluated by the qualifying agents.

3.6 Allow required drying as prescribed by the governing documents prior to taking the dry-film thickness reading of the applied coating. If a coating system specified requires multiple coats, treat each coat as a separate application, allowing a specified drying time before inspecting each completed coat.

3.7 The coating applicator shall be provided with the following:

3.7.1 Information regarding the specified coating material(s), including wet and dry film thickness required, and all other information contained in the governing documents for the coating system being applied.

3.7.2 Coating materials properly mixed in accordance with the governing documents and ready for application.

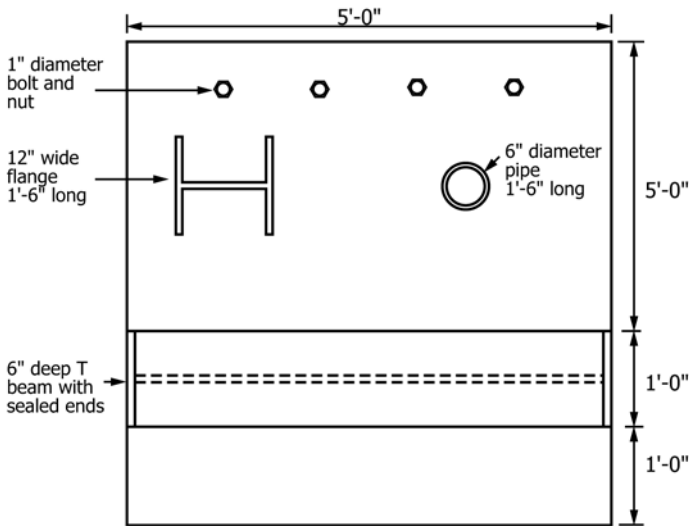


FIG. 1 Test Panel—Complex Side

3.7.3 The necessary equipment for the proper application of the specified coating.

3.7.4 Miscellaneous equipment, brushes, and thinners required for cleaning the equipment after completion of the test.

3.7.5 A practice area to adjust and test the equipment prior to performing the test.

3.7.6 All necessary safety equipment.

3.7.7 Wet-film thickness gage for testing the coating thickness during application, where applicable.

4. Evaluation of Coating Application

4.1 Evaluation of the coating applicator shall be made by two qualifying agents. Only one qualifying agent can be production-related.

4.2 The qualifying agents shall be capable of answering technical questions requested by the coating applicator relating to the application of the specified coating material(s). The qualifying agents shall be thoroughly familiar with the specified coating material(s) and acceptance criteria and shall be aware of any difficulties in applying the coating to any surface.

4.3 The qualifying agents shall have a wet-film gage of the same type used by the coating applicator, as well as a calibrated magnetic-type dry-film thickness gage.

4.4 The qualifying agents shall take dry-film thickness readings on all areas of the test panel, except nuts and bolts. These readings shall be recorded as specified in Section 5. Wet-film readings may be used to check the coating applicator’s progress during application. The dry-film thickness reading shall be used to verify the specified dry-film thickness requirements and uniformity of application. The number and location of readings shall be as indicated on Fig. 2.

4.5 The coating applicator and the qualifying agents shall understand the required dry-film thickness range requirements of the governing documents before any coatings are applied.

4.6 The qualifying agents shall inspect the finished surface to verify that it conforms to the requirements of the governing documents. A description of the appearance of the completed applied coating and dry film thickness shall be recorded on the form shown in Fig. 2.

5. Report

5.1 The qualifying agents shall use a report form similar to that in Fig. 2 to record dry-film thickness readings specified in 4.4, and the appearance of the completed coating surface as specified in 4.6 is recorded on a form similar to Fig. 3.

5.2 The qualifying agents and coating applicator shall sign the report form.

5.3 The generation of documentation and maintenance of records shall be as delineated in the applicable documents.

6. Initial Qualification

6.1 The qualifying agents shall prepare a form similar to Fig. 3. The qualification form shall state the coating materials used and the application equipment used in the test.

6.2 The qualifying agents and the coating applicator shall sign the qualification form.

Test Application of Coating to Standard Steel Test Panel by Coating Applicator for Qualification for Coating of Steel Surfaces

Coating Applicator _____			
Readings	Wet	Dry	
Flatside: _____	_____	_____	_____
_____	_____	_____	_____
_____	_____	_____	_____
Complex Side:			
Pipe: _____	_____	_____	_____
"H" Beam: _____	_____	_____	_____
"T" Bar: _____	_____	_____	_____
Plate: _____	_____	_____	_____
Description of Finished Surface: _____	_____		
_____	_____		
_____	_____		
Date: _____	Qualifying Agent: _____	_____	
Material: _____	Qualifying Agent: _____	_____	
DFT Range: _____	Coating Applicator: _____	_____	

FIG. 2 Record Form for Test Application

Coating Applicator Qualification for Application of Coatings to Steel Surfaces

Coating Applicator's Name: _____
 Location (Site): _____

Qualifying Agents:

1. _____ Representing: _____
 2. _____ Representing: _____

Coating System: _____
 Manufacturer: _____
 Type of Application Equipment: _____
 Comments: _____

The above applicant has been certified as a Coating Applicator for the application of the above coatings for steel surfaces.

Date: _____ Qualifying Agent: _____
 Coating Applicator: _____ Qualifying Agent: _____

FIG. 3 Qualification Form

7. Requalification

7.1 The owner or his designated representative may determine the degree of requalification to be permitted, as well as the acceptance of previously qualified coating applicators based on time interval since the date of the qualification form and provided the same coating materials and application procedures are used. Note the acceptance of previous qualification in the quality assurance file or the project.

8. Limited Qualifications—Touch Up and Repair

8.1 Limited qualifications can be accomplished using only areas representative of the actual plant surfaces, even though they do not include all areas represented in **Fig. 1**.

9. Limited Qualifications—Brushes, Rollers, or, Other Special Tools

9.1 Limited qualifications for special application tools may be required on certain projects. When such limited qualification is performed, the limitations shall be noted on the records for qualification and application.

10. Keywords

10.1 applicator; qualifications, (initial, limited); qualifying agents; report; requalifications

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