



**Bulletin Number:** T21-009

**Date:** August 31, 2021

**Distribution:** External

## Welding: Preparing & Repairing Tank Linings for Post Application Work

This document addresses the procedure of preparing for the repair of tank linings after welding.

### **WELDING ON POLYMER LINED METAL**

We recommend being preemptive by removing the lining where you know the welding may impact. This avoids things burning and causing fires, smoke, vapors, etc.

Our procedure for repairing lining where welding has been done:

1. After the welding has been completed, perform a visual inspection of the lining to identify any burnt areas.
2. The area(s) to be repaired must be washed with clean water and dry.
  - a. It is recommended to test for soluble salts
3. Abrasive blast and or prepare with hand tools to achieve a cleanliness standard of SSPC SP11, and create a profile specified for new substrate application. (Refer to Specification for cleanliness and blast profile requirements.)
  - a. Remove burnt lining a minimum of 2 – 3 inches on either side of the affected area(s) until there is sound lining
  - b. Feather another 1 – 2 inches into the existing sound lining
4. Apply lining per our current Product Data Sheet or Specification and allow to properly cure before returning to service.