

BID SPECIFICATIONS

For

SANDBLASTING AND PAINTING

LADDER FOR TANK 204, TOP, RING & DECK
OF TANK 501, PAINTING TWO FINISH COATS
ON SO. ACID TANK, SANDBLAST & PAINT CLAY
TOWER & MANIFOLD AT TANK 70; HAND CLEAN
& PAINT COOLER & PIPING AT SULFOLANE UNIT

Coastal States Petrochemical Company
Corpus Christi, Texas

February, 1968

JOB SPECIFICATIONS

I. PROJECT AND LOCATION

Sandblasting and painting top ring, deck and appurtenances of Tank 501, ladder for Tank 204 and painting two finish coats on So. Acid Tank, sandblast & paint clay tower & manifold at Tk 70; Hand clean & paint cooler & piping at Sulfolane Unit.

II. WORK TO BE PERFORMED

All work must be executed in a good and workmanlike manner and in accordance with the true intent of the specifications referred to herein and will be subject to inspection and test by Coastal States to ascertain that the specifications have been complied with. Any work or materials not expressly covered herein or by the specifications, but which are gainly implied therein as being required for the job, shall be considered as part of the contract. Work to be performed under this labor contract between Coastal States Petrochemical Company and others shall be as follows:

- A. Sandblast the deck and shell to "Near White Metal" SP-10, using Clemtex #3 bagged sand or an approved equal.

SP-10 "Near White Metal Blast" Reference SSPC-SP 1063T.

"Near White Metal" is a method of preparing the metal surfaces for the application of protective coatings by removing mill scale, rust, old paint and any foreign matter by propelling sand through a nozzle with compressed air.

This is defined as a surface, gray white in appearance, being almost a completely uniform metallic color, with very light shadows allowed over less than 10% of the surface area. The procedure:

1. Before blasting, grind smooth any rough welds and sharp edges.
2. Remove heavy deposits of oil and grease by detergent cleaning (Ref. SSPC-SP 1 52T), using one pound Sodium Meta Silica per five gallons of water.
3. The sand used shall be 16-30 mesh, unless otherwise specified, sharp angular grained silica sand that is fresh water washed, dried, properly graded and delivered to the job site in moisture-proof bags (Clemtex #3 or an approved equal).
4. Compressed air shall be delivered at a minimum nozzle pressure of 90 psi not to exceed 110 psi. This shall be free of detrimental amounts of condensed water and oil.
5. All blast products shall be swept or blown from the surface before priming commences.

6. Blast cleaning will not be conducted on surfaces that may become wet after blasting and before priming is complete, or when surfaces are less than 50°F. above the dew point, or when relative humidity is above 85%.
7. The blasted surface shall be primed within 8 hours.
- B. Apply one coat #2810 Durapon Red Chromate Primer, or equal, at rate of 6 mils wet in order to obtain 2½-3 mils dry.
- C. Apply #2809 Durapon Green Primer, or equal, as the second coat, at the rate of 5-6 mils wet in order to obtain 2½ dry.
 1. Do not thin in excess of one pint of #69 Reducer per gallon.
 2. Use DeVilbiss 704 Aircap with an E needle for best spray pattern.
 3. Allow overnight cure time between coats.
- D. Finish with two coats Special Durapon Beige, or equal, applied at the rate of 4½ mils wet in order to obtain 2 mils dry per coat on shell and two coats Briner's #1337 Chrome Polished Aluminum, or equal, on deck.

The above specifications apply to Tank 501; ladder for Tank 204 shall receive two prime coats and two coats finish in beige; So. Acid Tank two coats finish in beige; tower and manifold at Tank 70 Standard line specifications; cooler & lines at Sulfolane Unit, standard unit specifications shall govern.

1. All applications should be made with at least 15 hours of cure time between coats.
2. Use same size spray head and orifice as for the primer.
- E. Safety Precautions. If fire or explosion hazards are present, proper precautions shall be taken before any work is done. If the structure previously contained flammable materials, it should be purged of dangerous concentrations.

Nozzle blast operators exposed to blast dust shall wear a U. S. Bureau of Mines approved helmet connected to a source of clean, compressed air.

Filter type air respirators should be worn by all others who are exposed to blast dust environment. Adequate protection for personnel from flying particles shall also be provided in any blasting operation.

Safety goggles shall be worn by all persons near any blasting operation.

Blast hose shall be grounded to dissipate static charges.

- F. Inspection. All work under this specification shall be subject to inspection by the owner or his representative. All parts of the work shall be accessible to the inspector. The contractor shall correct such work as is found defective under the specifications. If the contractor does agree with the inspector, the arbitration or settlement procedure established in the contract, if any, shall be followed. If no arbitration or settlement procedure is established, the procedure specified by the American Arbitration Association shall be used.

III. APPLICABLE SPECIFICATIONS

- A. Coastal States shall furnish all paints and thinners.
- B. Contractor shall, at its sole cost and expense, furnish all necessary supervision, labor, tools, equipment, supplies, all expendable and/or consumable materials such as sand, motor oils, fuel and greases, etc., to perform all work herein specified.
- C. Contractor shall provide proper supervision on job site at all times, including supervision by prime contractor for any subcontract work by others.

IV. GENERAL CONDITIONS

- A. Working hours shall be from 7:00 A.M. to 3:30 P.M. Monday through Friday. Coastal States holidays will be observed.
- B. Contractor to furnish portable sanitary facilities and drinking water for construction forces if required.
- C. Coastal States shall have the right to effect changes in construction. Should changes be made, then the amount of payment or basis for payment shall be determined by Coastal States and the contractor prior to the starting of the work for which such change is made.
- D. Insurance. Contractor shall provide and maintain, at his own expense and cost, the carriers acceptable to Coastal States, the following insurance, to be evidenced by Certificates of Insurance furnished to the company by the carriers:
1. Workmen's Compensation Insurance on operations with minimum limits as follows:
 - (a) Bodily Injury -----\$100,000/\$300,000
 - (b) Property Damage-----\$50,000 on any one accident
- E. The Contractor shall submit his bid to: Attention B. A. Paulson, Coastal States Petrochemical Company, P. O. Box 521, Corpus Christi, Texas, 78403, not later than February 7, 1968.
- The quoted price shall include all remuneration required by contractor for required work.
- F. The contractor will comply with all Coastal States safety measures, etc.
- G. Bidders should visit the job site to familiarize themselves with the scope of work to be done.