

Rev. May 1, 1955



PLIBRICO SPECIFICATION C-2
FOR
A-R ABRASION RESISTANT-REFRACTORY CEMENT

A-R Cement is a factory mixed, super duty, dense refractory cement of trowling consistency, having chemical setting properties and hardening to a very smooth abrasion and chemical resistant surface.

A-R Cement is shipped in a dry mixed form and is ready to apply after it has been mixed with clear water at the job site.

A-R Cement has a density of 110 lbs. per cubic foot in place.

A-R Cement has excellent acid resistant properties but is not 100% acid proof - withstanding normal process acids brought about by moisture induction into the various processes.

A-R Cement is recommended for use in all high velocity Catalyst Transfer Lines, Regenerator Plenum Chambers, Reactor Cone Sections, Feed Inlet Piping, Flue Gas Stacks and conductor pipes, and all other steel vessel or pipe surfaces requiring high abrasion and chemical-resistant linings where it is impossible to cure the refractory material and a chemical setting material is desired.

In keeping with our technical services, we take pleasure in outlining general specifications for installing A-R Refinery Cement,

PLIBRICO A-R CEMENT
for Abrasion Resistant Catalyst Piping Linings

A. Details (General)

1. Refractory lining will be Plibrico A-R Refractory Cement reinforced with a protective grid armor of 3/4" - 14 gauge armor grating or 5/8" - 16 gauge Floorsteel grating. Total lining thickness to suit operating conditions but not less than 1" thick.
2. Armor grating will be supported by 1/4" or 3/8" thick by 2" long by 1" wide steel bar washers fastened to the inside shell by 3/8" thick stud suitable length to space the surface of the steel grating at the inside face of the A-R Cement.
3. The steel bar supporting members will be spaced on 12" centers. Armor grating sections are to be welded direct to the steel bars.

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B. Application Procedure

1. Clean interior of pipe by sandblasting or clean with accepted and approved solvents.
2. Weld steel bars and studs in place on 12" centers. Bars and studs to be hammer tested to assure quality weld.
3. Install armor grating sections. Grating sections are to be rolled so that they fit snug against the steel bar washers. Weld each strand of adjoining grating sheets together. One 1/4" long fillet weld shall be used at each bar washer.
4. Mix A-R Cement with pure clean water, following exactly instructions received with the material. Do not mix more cement than can be used up within several hours.
5. Trowl A-R Cement into the grating grid working from the center to the sides, making sure that all voids are eliminated beneath the grating.
6. A-R Cement must be allowed to air dry, 24 hours at temperatures above 40 deg. F. before being subject to heat and placed in service. If the temperature is below 40 deg. F., the material must be allowed to air dry for 48 hours. A-R Cement should not be exposed to temperatures below 25 deg. F., until it has been allowed to air dry and set up completely.

NOTE - For additional specifications covering abrasion resistant linings, please see Plibrico Specifications C-1 and C-3.

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