

MAFLOWRAP®

System Application Guidelines

SYSTEM For above and below ground applications:

PRIMER B400

MAFLOWRAP TAPE

MOULDING COMPOUND 1190 / LD MASTIC

OUTERWRAP TAPE

APPLICATION

SURFACE PREPARATION

The surface to be wrapped should be as clean as possible. Remove metal burrs and other projections, and all loose matter, any existing coatings, dirt, rust and foreign debris. Ensure all oil and grease is removed with solvent.

Inspect old pipe work or factory coatings and remove any loose coating back to sound material with wire brushing. Where new or existing steelwork has been subjected to chemical attack, salt spray, fungi or bacteria other methods may be used.

PRIMER

Stir Primer B400 well before application. When not in use keep the containers tightly sealed.

Apply primer by brush or roller in an even coat over the pipe surface, working well into welds and seams. Ensure surface is free from runs, drips and bare spots.

The primed surface should be at least touch dry before over wrapping.

Health & Safety Regulations should be observed at all times.

MOULDING COMPOUND 1190 / LD MASTIC

For weld beads, flanges or pipe fittings mould with Moulding Compound 1190 or LD Mastic to provide a smooth profile.

MAFLOWRAP TAPE

The primed surface should be dry and free from moisture at the time of wrapping.

Use a tape of suitable width for ease of application.

Peel back the release paper from the first 200mm of tape and start wrapping by placing the adhesive side of the tape on to the primed surface. Remove the release paper as wrapping progresses and use sufficient tension to ensure good conformability to the pipe surface. Overlap by at least 75mm on to any adjoining factory applied coating.

When spiral wrapping, allow a minimum overlap of 25mm. A 55% overlap will ensure double thickness protection throughout. The overlap should be increased when the tape is applied around pipe bends to prevent loss of overlap seal on the outside of the bend. End laps should be at least 150mm.

OUTERWRAP TAPE

Overwrap with OUTERWRAP tape where extra mechanical strength, electrical resistance or solar protection is required

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Cigarette Wrapping

When it is not possible to spiral wrap pipes, welded joints, tees, and bends, apply the tape "cigarette wrap" and take care that all overlaps are made facing downwards.

▲ Inspection and Testing

The tape should be inspected immediately after wrapping to locate any pinholes or tears. Any holes or defects should be repaired.

▲ Repairs

- Make two parallel cuts around the pipe on either side of the damaged area. Remove the band of damaged material between the cuts.
- Clean exposed metal surface and apply primer.
- Apply tape.
- Repairs should be made under tension, allowing at least 1½ full circumferential wraps, extending for 100mm on to each side of the existing wrapped paper.

ESTIMATION GUIDE

Outside Pipe Diameter		Tape Width		Linear Metre (L.M.) of Tape per Linear Metre of Pipe				Primer B400 Litres/L.M.
Inches	mm	mm		25mm	Tape Overlap	55%		
1	25.4	50		3.2		3.5		0.01
1½	38.1	50	75	4.8	2.4	5.3	3.5	0.02
2⅝	60.3	50	75	7.6	3.8	8.4	5.6	0.03
2⅞	73.0	50	75	9.2	4.6	10.2	6.8	0.04
3½	88.9	75	100	5.6	3.7	8.3	6.2	0.05
4½	114.3	75	100	7.2	4.8	10.6	8.0	0.06
6⅝	168.3	100	150	7.0	4.2	11.7	7.8	0.09
8⅝	219.1	100	150	9.2	5.5	15.3	10.2	0.11
10¾	273.1	150	225	6.9	4.3	12.7	8.5	0.14
12¾	323.9	150	225	8.1	5.1	15.1	10.0	0.17
14	355.6	150	225	8.9	5.6	16.6	11.0	0.19
16	406.4	150	225	10.2	6.4	18.9	12.6	0.21
18	457.2	150	225	11.5	7.2	21.3	14.2	0.24
20	508.0	150	225	12.8	8.0	23.6	15.8	0.27
22	558.8	150	225	14.0	8.8	26.0	17.3	0.29
24	609.6	150	225	15.3	9.6	28.4	18.9	0.32
26	660.4	150	225	16.5	10.4	30.7	20.5	0.35
28	711.2	150	225	17.9	11.2	33.1	22.1	0.37
30	762.0	150	225	19.2	12.0	35.5	23.6	0.40
32	812.8	150	225	20.4	12.9	37.8	25.2	0.43
36	914.4	150	225	23.0	14.4	42.6	28.4	0.48
40	1016.0	150	225	25.5	16.0	47.3	31.5	0.53
48	1219.2	150	225	30.6	19.2	56.7	37.8	0.64
60	1524.0	150	225	38.3	23.8	70.9	47.3	0.80

To calculate linear metre of tape required for linear metre of pipe:

$$\frac{1}{\text{Tape Width} - \text{overlap}} \times 3.1416 \times \text{pipe o.d. (In mm)}$$

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