Other Linings Available From AMERICAN

ASPHALTIC LINING

AMERICAN furnishes some pipe and fittings lined with an asphaltic material in accordance with AWWA C110, C115, C153 and C151. After thoroughly drying, the lining has no deleterious effect upon the quality, color, taste or odor of potable water. Asphaltic lining is not normally used in water service; the majority of ductile water lines are cement lined. Asphaltic lining or seal-coat, if furnished, on cement lining is adequate for temperatures up to 150°F.

SPECIAL LININGS

Cement lining has proven effective as a lining for iron pipe in most water service applications, and an industry standard for cement lining is in place. Cement lining is applied at the pipe casting factory as part of routine manufacturing.

When service conditions go beyond basic water, a more thorough evaluation is called for, and a special lining applied by a third-party applicator may be indicated. This may include glass lining, epoxy lining and other special linings.

Because of the variables and complexities involved in special linings other than cement for special services other than basic water, AMERICAN directs inquiries for technical assistance and referrals to various lining manufacturers and their products, services, terms and conditions.

OTHER SPECIAL LININGS

Customers can request pipe and fittings with special linings other than those listed above (e.g., glass lining, etc.). Because of the variables and complexities involved in the selection of a proper lining for a given service, AMERICAN invites inquiries for technical assistance, availability and cost.

UNLINED

Because some service applications may require unlined pipe & fittings, AMERICAN furnishes any of its products without lining when so specified at time of purchase.

AMERICAN Coatings and Primers for Pipe and Fittings

Several different types of exterior primers for pipe and fittings are available from AMERICAN. Because of variables and complexities involved in the selection and application of a proper coating for a given service, AMERICAN invites inquiries for technical assistance.

ASPHALTIC

AMERICAN furnishes most pipe and fittings coated outside with an asphaltic coating approximately one mil thick per AWWA C151 for ductile iron pipe, AWWA C115 for flanged pipe and AWWA C110 and C153 for fittings.

All across the United States ductile iron and gray iron pipe and fittings with this standard coating have provided trouble-free service for decades. Unless otherwise specified, an asphaltic coating is applied to the outside of all pipe and fittings manufactured by AMERICAN.

The asphaltic coating works in conjuction with manufacturing annealing scale to provide a barrier to corrosion. If soils are deemed to be corrosive to ductile iron pipe when evaluated in accordance with the Design Decision Model™ (DDM™*) or Appendix A of AWWA C105, zinc coating with or without V-Bio polyethylene wrap should be used.

Asphaltic coating is not compatible with most top coats. See the following alternative coating and primer recommendations.

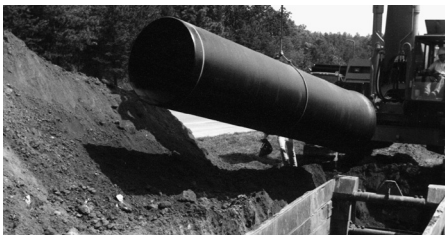
*DDM™ (Design Decision Model™) developed jointly by Corrpro Companies, Inc., and the Ductile Iron Pipe Research Association.
See american–usa.com, dipra.org or corrpro.com for details.

PHENOLIC ALKYD PRIMER

This is a fast-drying, lead- and chromate-free, corrosion-resistant primer formulated to accept a wide variety of topcoats. It is well suited for applications where the generic topcoats are unknown but its service is limited to atmospheric exposure. Refer to **AMERICAN** Alkyd-Phenolic Primer. **NOTE: NOT RECOMMENDED FOR IMMERSION. MUST ALLOW UP TO 30 DAYS OF CURING BEFORE TOPCOATING WITH CERTAIN COATINGS.**

EPOXY PRIMER

This is a high-solids, chemical- and corrosion-resistant coating for protection against abrasion, moisture, corrosive fumes, chemical attack and immersion.



This 30" AMERICAN Ductile Iron Fastite joint treated-water transmission main was furnished and installed—as is most ductile iron pipe—with standard asphaltic coating approximately one mil thick on the outside.

High-build properties provide outstanding corrosion protection with fewer coats, particularly on edges. Such high solids, high film-build epoxies are compatible with most catalyzed finish coats.

Typical (field) finish coatings include: epoxies (amine, polyamide, polyamidoamine, water-borne, coal-tar) and polyurethane. Refer to **AMERICAN** Polyamidoamine Epoxy Primer. **NOTE: AFTER 60 DAYS OF CURING, THIS PRIMER SHOULD BE UNIFORMLY SCARIFIED BY BRUSH-BLASTING WITH FINE ABRASIVE BEFORE TOPCOATING.**

OTHER SPECIAL COATINGS

AMERICAN can also furnish other special exterior coating systems. Contact **AMERICAN** for technical assistance in the selection of special exterior coating systems, lead times and costs. See pages 11-9 through 11-11 for additional information related to metallic zinc coating.

UNCOATED PIPE

Because some customer applications may require piping or fittings that have no coating applied to the exterior, AMERICAN furnishes, when specified at time of purchase, any of its products without exterior coatings.

While AMERICAN can supply uncoated, bare pipe to meet customer specifications, it is recommended to use an asphaltic or other approved coating on the spigot when assembling a joint to reduce the probability of displacing a gasket and to reduce the overall assembly load.

NOTE: AMERICAN also has the ability to furnish other primers, but this may affect price and availability.

AMERICAN Cast Iron Pipe Company
Standard O.D. Shop Primer Systems

RECOMMENDED AND PREFERRED PRIMER

Alkyd-Phenolic Primer
Interior/Exterior/Non-Immersion (Above Grade Only)
- Single-coat thickness: 2.0-4.0 mils DFT (50-101 microns).
- Typical Topcoats: alkyds, aluminums, epoxies, and urethanes.
- Coating must be cured for 30 days before being overcoated with certain topcoats.
- This primer is **not** recommended for immersion service.
- This primer is compliant with NSF Standard 61 **as an exterior surface coating only.**

Polyamidoamine Epoxy Primer
Interior/Exterior/Immersion (Above and Below Grade)
- Single-coat thickness: 3.0-8.0 mils DFT (76-203 microns).
- Typical Topcoats: epoxies and urethanes.
- This coating must be lightly blast cleaned before topcoating if it has not been exterior exposed for 60 days or longer.
- This primer is compliant with ANSI/NSF Standard 61 for potable water contact for pipe, fittings, and valves when combined with approved topcoats.