

**COAL TAR-EPOXY COATING OF PERMANENT BULKHEAD SHEET PILES.
(REV 1-3-94) (FA 6-21-99) (7-00)**

ARTICLE 560-11 (Pages 691 and 692) is expanded by the following new Subarticle:

560-11.5 Coal Tar-Epoxy Coating of Permanent Bulkhead Sheet Piles:

560-11.5.1 Shop Coating: Shop coat steel sheet piles for permanent bulkheads in accordance with Section 560. For purposes of this specification, “shop” shall be interpreted as being a permanent building structure capable of protecting the piles and coating from wind, weather, dust and direct sunlight.

560-11.5.2 Surface Preparation: Immediately before coating, abrasive-blast the steel to a near-white condition at least equal to the Society for Protective Coatings, Specification SSPC-SP 10. The average profile depth shall be 1.5 mils [40 µm] minimum. Re-blast piles not coated immediately following surface preparation to the original blast standards before coating application. Ensure that all surfaces to be coated are completely dry and free of any contamination at the time of coating.

560-11.5.3 Materials: Use a coal tar-epoxy coating listed on the Qualified Products List.

560-11.5.4 Application of Coating: Apply the coal tar-epoxy in accordance with Section 560 and the following specific requirements:

(1) Apply the coal tar-epoxy system two coats. The time interval between the first coat and the second coat shall be in strict accordance with the coating manufacturer’s published specifications. Apply the first coat to yield a dry film thickness of 8 to 10 mils [200 to 250 µm]. Apply the second coat so that the total dry film thickness of the two coats is between 16 and 20 mils [400 and 500 µm]. Give the inside portion of the interlock claw and the interlock ball a single coat that will yield a dry film thickness of 2 to 4 mils [50 to 100 µm]. Build up and puddling of the coating in these areas is not allowed.

(2) Ensure that no portion of the coating is less than the specified minimum film thicknesses. The total minimum film thickness for any combination of coats shall be the sum total of the averages of the specified thickness range of the individual coats.

(3) After applying the coating on the steel piles, the Engineer will thoroughly inspect the surfaces and make film thickness measurements at the approximate rate of one for each 25 ft² [2.25 m²] of area unless deficient thickness is found. In this case, the rate of sub-measurements will be increased as required to determine the extent of the deficient area. Provide the necessary ladders or scaffolds for making the inspection.