

Holiday Testing Procedure

8002

General

This standard is established to assist Quality Engineering personnel in determining the conformance or nonconformance of a coating system with a holiday requirement.

Since it does establish requirements of conformance it becomes a manual to be utilized by engineering and other departments within **WaterSmart Environmental, Inc. (WSE)** and by suppliers utilized by **WSE**

Applicable specifications of this document.

NACE RP 0187-87 - Discontinuity (Holiday) Testing of Protective Coatings, Sections 1, 2, 3, and 5

Note: NACE (National Association of Corrosion Engineers)

WaterSmart Environmental, Inc. Specifications

- QA-SP-1 Surface Preparation (Grit Blast/Clean-up)
- QA-Paint-1 - Paint

Film Coatings

1. The required dry film thickness of the applied coating shall be part of the job purchase order.
2. The specified nominal thickness shall be the accepted (proven by experience) best average thickness of the specified coating material system and/or in accordance with the paint manufacturers recommendation.
3. Film thickness given in the specification shall be the final total dry film thickness of the completed and cured coating application.

Coating Continuity

The degrees of continuity are termed as conditions "A", "B", and "C". The purchase order shall specify the type of continuity required. If none is specified, type "C" will be assumed.

Condition "A" - Pinhole Free

1. The applied coating film shall be continuous.
2. The total number of discontinuity points shall be as defined in Table 1.

Condition "B" - Relatively Pinhole Free

1. No more than two points of discontinuity shall occur within an area having a radius of six inches as measured from a point of discontinuity.
2. No gross discontinuity (larger than pinpoint size) shall be allowed.
3. The total number of discontinuity points shall be as defined in Table 1.

Condition "C" - Commercially Continuous

1. No more than two point discontinuity shall occur within an area having a radius of six inches as measured from a point of discontinuity (pinhole).
2. No more than 40% of the total number of allowable points of discontinuity shall occur within any one area equal to 25% of the total area under consideration.

The total number of discontinuity points shall be as defined in Table 1.

Total Number of Allowable Points of Discontinuity			
Surface Area Being Coated (Sq. Ft.)	Condition A	Condition B	Condition C
1-10	0	1	5
11-49	0	2	10
50-99	0	5	20
100-499	0	10	30
500-999	0	15	50
1,000-5,000	0	30	80

