



Corrosion Technology
Pipe & Plate Mill Inspection
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Vendor Surveillance
Laboratory Testing
Expediting

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Report No. 06-1802

For

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***Laboratory Testing:
Salt Fog Exposure – ASTM B 117-03
On Fluorokote #1 Stock***

P.O. No. 11441

Prepared by

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I.T.I Contract No. 9338



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Introduction

Two (2) raised-face FRP piping flange assemblies were delivered to ITI Anti-Corrosion, Inc. for exposure to 2200±24 hours of *ASTM B 117-03; Standard Practice for Operating Salt Spray (Fog) Apparatus*.

The nuts/bolts/washers used on each assembly were coated with the Fluorokote #1 Stock system. The assemblies were designated as follows:

Nut/Bolt/Washer Coating	Torque Method	Position of Assembly in B 117 Chamber
Fluorokote #1 Stock	Hand	Horizontal
	Wrench	Vertical

The assemblies were visually examined for corrosion (ASTM D 610-01) at 1200±24 hours, 1800±24 hours, 2000±24 hours, with the full/final evaluation performed at 2200±24 hours.



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Fluorokote #1 Stock Results

Duration	Position & Torque	% Of Rust & Visual Examples Per ASTM D 610-01
1200±24 Hours	Horizontal (Hand)	≤0.01% (Less than or equal to one hundredth of one percent) No Visual Example
	Vertical (Wrench)	≤0.01% (Less than or equal to one hundredth of one percent) No Visual Example
1800±24 Hours	Horizontal (Hand)	≤0.03% (Less than or equal to three hundredths of one percent) Visual Example 9-G
	Vertical (Wrench)	≤0.01% (Less than or equal to one hundredth of one percent) No Visual Example
2000±24 Hours	Horizontal (Hand)	≤0.3% (Less than or equal to three tenths of one percent) 7-G
	Vertical (Wrench)	≤0.1% (Less than or equal to one tenth of one percent) 8-G
2200±24 Hours	Horizontal (Hand)	≤0.3% (Less than or equal to three tenths of one percent) 7-G
	Vertical (Wrench)	≤0.1% (Less than or equal to one tenth of one percent) 8-G

The Horizontal/Hand Torque assembly was disassembled at the completion of the exposure with the nuts being easily unthreaded by hand with little effort.

