

# Belzona Lines Internals of a Gas Main

ID: 8345

**Industry:** Steel & Metal Processing  
**Application:** VPF-Valves, Pipes and Fittings  
**Substrate:** Carbon Steel  
**Products:** \* Belzona® 4154 (Bulkfill Resin) & Kiln-Dried Sand ,  
\* Belzona® 1151 (Smoothing Metal) ,  
\* Belzona 5811 (Immersion Grade) ,

**Customer Location:** Steel Works, East Midlands, UK  
**Application Date:** August 2020

## Problem

40 year old gas main has corroded internally, leading to leaks which are continually patched externally. In 2015 the site decided to line the 3km main in sections. For 2020, 350 linear metres were completed in 4 days.



## Photograph Descriptions

- \* 1. Residue to be removed ,
- \* 2. Grit Blasting ,
- \* 3. Pits filled with Belzona 4154 (Bulk-Fill) ,
- \* 4. Finished Application ,

## Application Situation

Phase 5 lining of 96" site Gas main.

## Application Method

The main was cleared of residue that built up over the years. The whole pipe was cleaned and blasted to an SA 2.5, 75 micron profile, ready for the Belzona application. Any holes are over plated using 150mm<sup>2</sup> plates, bonded in position with Belzona 1151. The heavily pitted areas are filled with Belzona 4154 bulk fill material. The mix was achieved using 2 x units of resin to one bag of kiln-dried sand.

For more examples of Belzona Know - How In Action, please visit <https://khia.belzona.com>

ISO 9001:2015  
FS 695214  
ISO 14001:2015  
EMS 695213

Belzona products are  
manufactured under an ISO  
9000 Registered Quality  
Management System.

[www.belzona.com](http://www.belzona.com)

  
**BELZONA**  
Repair • Protect • Improve

2 coats of Belzona 5811 were spray applied to a total of 1000µm thickness in order to provide corrosion protection. This was applied in accordance with Belzna System Leaflet VPF-01.

Application from start to finish took 4 days.

## Belzona Facts

Phase 1 was to replace the gas main rather than repair. 100m was replaced, but the cost was very high, so the customer decided to look at the repair option with Belzona.

Phase 2 was completed in 2015, and currently has no reported leaks along the gas main.

---

For more examples of Belzona Know - How In Action, please visit <https://khia.belzona.com>

ISO 9001:2015  
FS 695214  
ISO 14001:2015  
EMS 695213

Belzona products are  
manufactured under an ISO  
9000 Registered Quality  
Management System.

[www.belzona.com](http://www.belzona.com)

