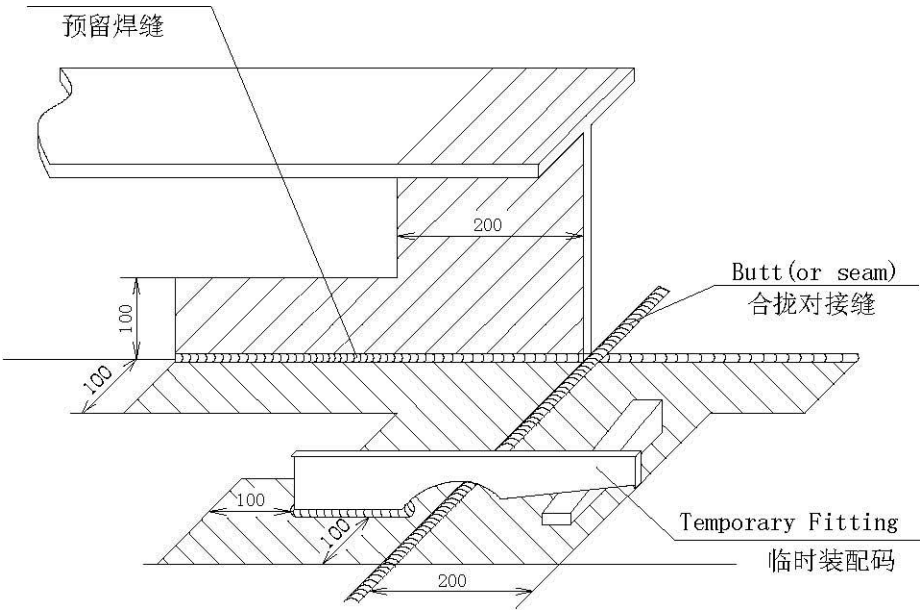
Assessment and calculation of coating damaged areas　涂层破损的评估

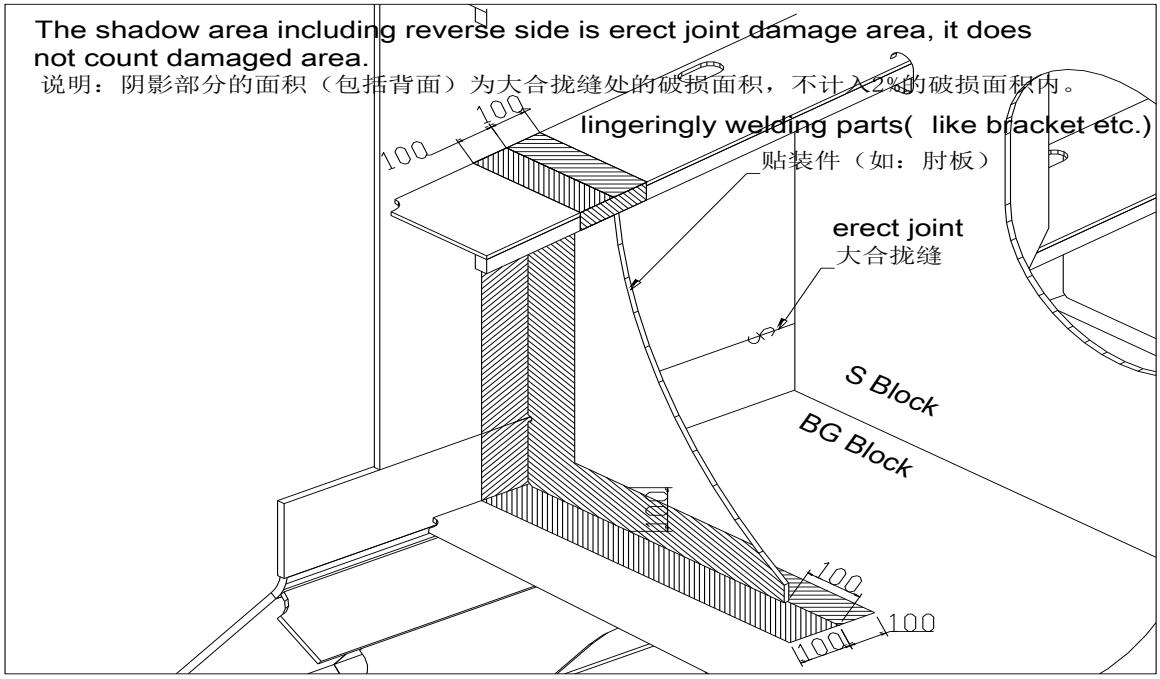
3.4.1 The damaged areas, caused by erection joint and the fillet welding on tank boundary watertight bulkhead, need not to be assessed.

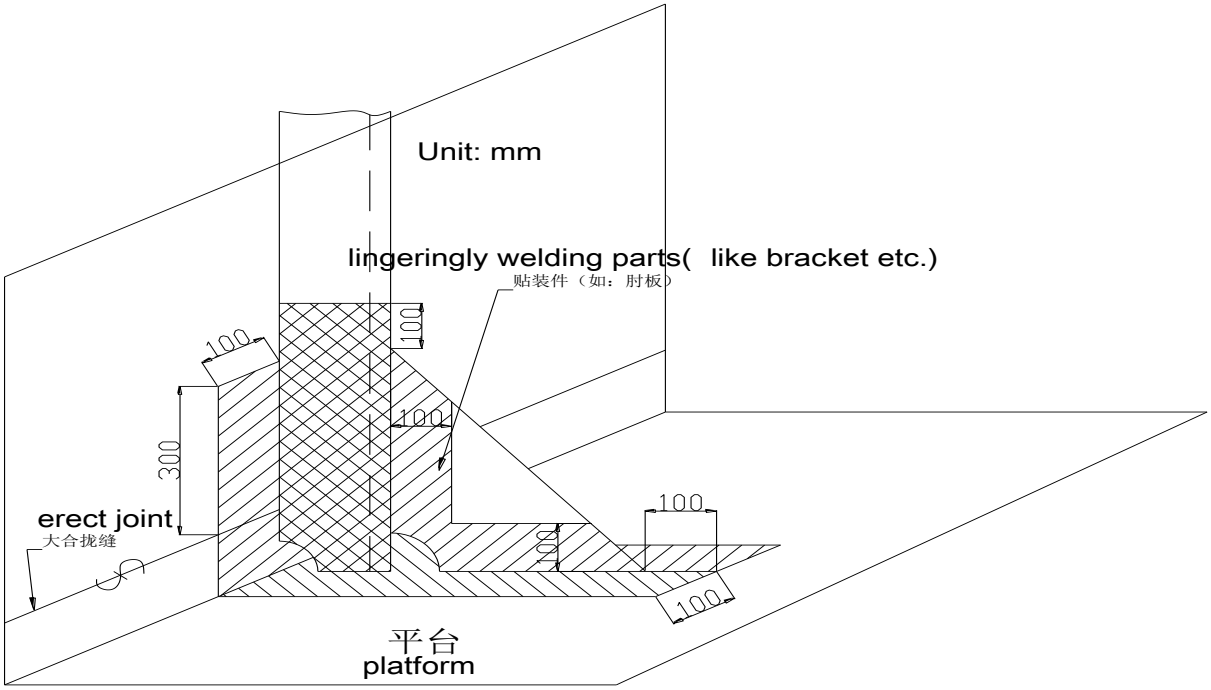
压载舱内如图1 阴影区所示范围内的合拢区焊缝和水密焊缝的破损面积不需评估。

3.4.2 Coating damage means the areas where the damage reaches steel surface.

油漆破坏意为破损到达钢表面。







The shadow area in the graphs shall not be counted into the coating damage.

3.4.3 After erection of blocks on dock or quay, Assessment and calculation of coating damaged areas shall be carried out with the reference to ISO4628-3:2003, except the damaged areas caused by erection joint and the fillet welding on tank boundary watertight bulkhead.

分段在船台（船坞）或码头合拢后，除合拢区焊缝和水密焊缝外的涂层破损情况参照ISO4628-3:2003进行评估。

3.4.4 Areas masked during application of main coating, e.g., for leakage test or future welding, are to categorized as "butt" to be power tooled to St 3 or better. "Butt" means erection joints.

All the tightness welding including pipe penetration seams and connected pipe seams shall be tape with 40~50 mm width via proper application. If the mis-cover area over max. 100mm width, the over area will be counted into the coating damage area.

油漆施工过程中无法避免的部位：如：需做水密试验的部位或后续要进行电焊的部位也归为合拢缝。

所有水密焊缝包括套管和管子接头需要用宽度是40~50mm的（胶带）进行保护，如果保护物超过100mm，则超过的部分计入2%。

3.5 painting of pre-erection stage 总组涂装

Erection joints to be done in pre-erection stage.

3.6 dock and quay painting 船台（船坞）及码头涂装

3.6.1 Butts(erection joint and the fillet welding on tank boundary watertight bulkhead) St3 according to GB/T 8923-1988（equal ISO 8501-1:1988）.

分段或总段间合拢焊缝和水密焊缝涂层破损处，采用动力工具打磨除锈至GB/T8923- 88（相当于ISO 8501-1：1988）规定的St3级。

3.6.2 Assessment and calculation of coating damaged shall be carried out according to 3.4,

except erection joint and the fillet welding on tank boundary watertight bulkhead and repaired damage area in pre-erection stage.

除合拢区焊缝、水密焊缝损坏部位以外的区域，须按照3.4 的规定对压载舱内涂层破损情况进行评估。

3.6.3 According to the results of assessment, following methods shall be adopted.

根据评估结果，采用下列方式进行涂层破损处理：

a) Small damages up to 2% of total area and contiguous damages up to 25 m^2 (except erection joint and the fillet welding on tank boundary watertight bulkhead): St 3 according to GB/T 8923-88 (equal ISO 8501-1：1988）. Contiguous coating damage means the damage areas, the distance between the edges of which is less than 100mm. Same meaning in below.

若紧邻涂层破损不超过25m2或小范围破损面积总和不大于全舱面积2%时，（不包括合拢区焊缝和水密焊缝，）则对涂层破损处，采用动力工具打磨除锈至GB/T 8923-88（相当于ISO 8501-1：1988）规定的St3级。紧邻涂层破损也归为涂层破损，至破损间间距少于100mm的破损。

b) Contiguous damages over 25 m^2 or over 2% of the total area of the tank, Sa 2.5 should be applied according to GB/T 8923- 88（ equal ISO 8501-1:1988）.

若紧邻涂层破损超过25m^2 或小范围破损面积总和大于全舱面积2%时，则对涂层破损处采用喷砂（丸）除锈至GB/T 8923-88（相当于ISO 8501-1：1988）规定的Sa2.5级。

c) Defects within the coating layers not reaching the steel surface are to be touched up to the specified DFT after appropriate treatment of coating surface, this kind of defects are not to be counted towards the 2% or 25m2 assessment.

涂层间的缺陷没有达到钢材表面的区域，其表面在采用合适的方法进行表面处理后，补涂到规定的膜厚,这种涂层间的缺陷不作为涂层破损。

3.6.4 After completion and accepted the final coat of water ballast tank in dry dock, slipway or quay side, the builder shall try to avoid new damaged coating. If any new damaged coating shall be done as following:

If the total damaged area in one tank is up to 5m^2, St3 shall be carried out. If the total damaged area in one tank is over 5m^2, Sa2.5 shall be carried out.

当压载舱在干船坞、船台或码头被最终认可后，船厂需要避免新的油漆损坏，如果新的油漆损坏小于5平方。可以打磨到ST3级，如果新的油漆破损大于5平方，则需要冲砂到SA2.5级。