Standard Finish for Transformers

INSTRUCTIONS

Transformer tanks and many accessories attached thereto, being made of steel are normally susceptible to rusting. To effectively prevent rusting of exposed steel surfaces on Westinghouse transformers careful attention is given to the following fundamental steps: (1) Surfaces are thoroughly cleaned and prepared for the application of protective coatings of paint; (2) The careful application of a high-grade durable paint of a type which is best suited to our manufacturing processes.

The proper preparation of the surface to be finished is indispensable in securing a satisfactory and lasting finish. Regardless of how good the paint may be, it will be a failure as a protection if applied over a wet, dirty, rusty or greasy surface. Rust and scale have the characteristics of absorbing and holding moisture. For a durable finish, it is absolutely essential that no moisture be sealed in by the application of paint. By shot blasting the exposed surfaces on Westinghouse transformer tanks, a clean dry surface with sufficient roughness for good adhesion of the priming coat is secured, and the possibility of trouble from this source is eliminated.

The two factors that determine the quality of any paint are the pigment and vehicle. The pigment gives the color and body of the paint and the vehicle holds the pigment particles in place and forms a continuous adherent film. Although attention is generally centered upon the selection of the pigment many tests show that the vehicle of a paint is the first of these two components to disintegrate. It is, therefore, our practice to secure paint from suppliers who have done extensive development in the formulation of industrial paint and in the development of both pigments and vehicles for many years.

Our standard finish for medium and large tanks consists of three air dried coats of paint. Each coat is flowed on. The color of the final coat is a dark blue-gray. The colors of prior coats are different to obtain a contrast between adjacent coats, thus insuring that each coat is continuous and of sufficient thickness.

Any portion of the paint film damaged during shipment or installation should be repaired promptly. To repair, clean damaged portion by means of scraper or sandpaper, apply a coat of primer, allow to air dry for at least 24 hours, then apply a coat of finish paint. For small marred spots only the finish paint is necessary after cleaning. The life of this finish is not indefinite and, therefore, the protective coating should be maintained by refinishing when necessary. The primer is Paint No. 7164-1 and the paint for the finish coat is Paint No. 7165-1. The second or intermediate coat is a mixture of the primer and finish paints, 1 part primer paint to 6 parts finish paint by volume. These paints can be applied satisfactorily by flowing, dipping, spraying or brushing.

Finish Paint No. 7165-1 for repairing marred spots is packaged in one pint containers and designated as Style No. 302509.

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Sharon, Pa.

Westinghouse Press
Printed in U.S.A. (Rep. 11-42)