APPENDIX A. Finish Codes

SECTION S. CORROSION RESISTANT STEEL ALLOYS

CODE		APPLICABLE FINISH
S100		**NO FINISH REQUIRED. (FOR CRES PEEL SHIM, CASTINGS, AND TUBING ASSEMBLIES CONTAINING LAP WELDS & FOR COMPONENTS THAT WOULD TRAP PASSIVATION SOLUTION)**
	A	NO FINISH REQUIRED.
S103		**DO NOT FINISH. DETAIL OF BONDED ASSEMBLY.**
	A	NO FINISH REQUIRED.
S104		**DO NOT FINISH. DETAIL OF WELDED ASSEMBLY.**
	A	NO FINISH REQUIRED.
S146		**ALL CRES EXCEPT CASTINGS, CRES REQUIRING COLOR MATCH AND WELDED ASSEMBLIES WITH LAP JOINT**
	A	CLEAN AND PASSIVATE PER 146. NOTES: THIS PROCESS MAY NOT REMOVE HEAT TINT OR DISCOLORATION RESULTING FROM THE AGING OPERATION.
S147		**ALL CRES ROUGH FORGINGS AND HEAT TREATABLE CRES, EXCEPT CASTINGS - DESCALE AND PASSIVATION**
	A	CLEAN, CHEMICAL DESCALE AND PASSIVATE PER 147. (0.00075 IN METAL REMOVAL PERMITTED).
S208		**ALL AISI 410 OR 17-4PH ROUGH CASTINGS**
	A	PROTECT ALL SURFACES PER 208.
S210		**CASTINGS-TEMPORARY CORROSION PROTECTION ALL AISI 410 OR 17-4PH ROUGH CASTINGS**
	A	PROTECT ALL SURFACES PER 210.
S211		**CORROSION PREVENTIVE SHIPPING PAPER ALL CRES ALLOYS (FOR F2 ONLY)**
	A	PREPARE ALL SURFACES PER 526.
S402		**PRIMER - AISI 410 OR 17-4PH CASTING DETAILS**
	A	CLEAN PER 135.
	B	PRIME ONE COAT ON SURFACES SPECIFIED ON DRAWING PER 202.
	C	TOUCH UP AS REQUIRED PER 321.
S403		**GRAY EPOXY ENAMEL/GRAY URETHANE AISI 410 OR 17-4PH CASTING DETAILS**
	A	CLEAN PER 135.
	B	PRIME ONE COAT ON SURFACES SPECIFIED ON DRAWING PER 202.
	C	PAINT PRIMED SURFACES WITH GRAY EPOXY ENAMEL OR GRAY URETHANE PER 211.
	D	TOUCH UP AS REQUIRED PER 322.