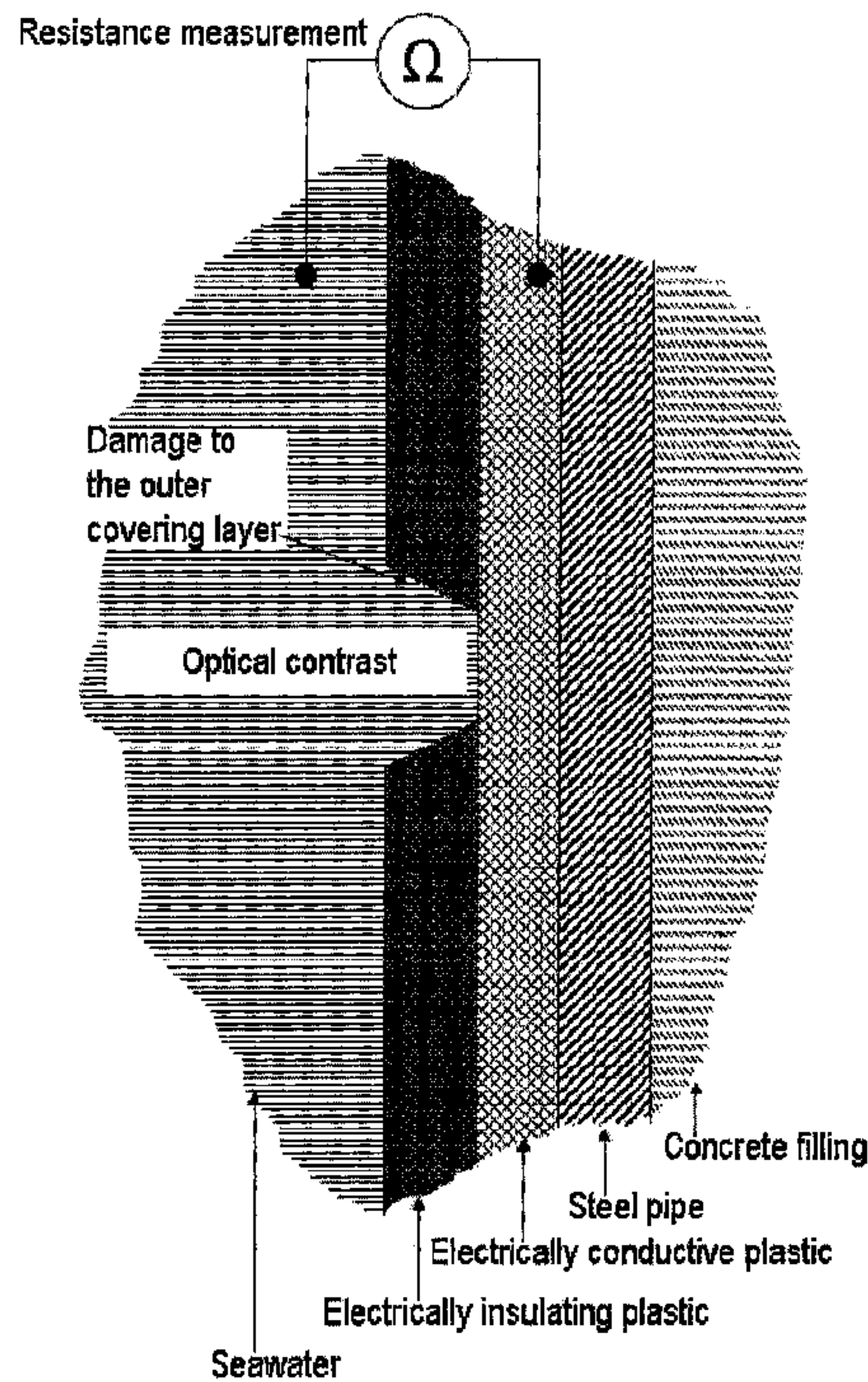




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(54) Titre : SYSTEME INDICATEUR D'USURE POUR SYSTEMES DE REVETEMENT DE PROTECTION CONTRE LA CORROSION EN MER
 (54) Title: WEAR INDICATOR SYSTEM FOR OFFSHORE CORROSION PROTECTION COVERING SYSTEMS



(57) **Abrégé/Abstract:**

A metal pipe which has an at least two-layer corrosion protection covering with an upper and a lower layer, the lower layer being finished such that, in the event of damage to the layer or layers lying above, a visual or electrical signal can be detected, is used for installation in an offshore structure or for producing a pipeline laid in water. Damage to the corrosion protection covering can therefore be detected easily and, if appropriate, reported by remote monitoring.

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Abstract:

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Wear indicator system for offshore corrosion protection covering systemsField of Invention

The invention relates to a wear indicator system for metal pipes which are part of an offshore structure or a pipeline and are covered with a corrosion protection system.

5 Background of Invention

Offshore structure designates stationary structures which are erected in the open sea off the coast. Examples of such offshore structures are wind power plants, drilling rigs and lighthouses. The pipelines in question are rigid pipes having a solid metal wall, as opposed to flexible pipes of multilayer construction.

10 The metal pipes are, for example, part of the foundation structure of offshore structures. The foundation structure of offshore structures is the area which carries the actual functional unit. In the case of wind power plants, the foundation structure carries the tower including turbine and rotors. In the case of drilling rigs, the foundation structure carries the platform including superstructures. In the case of
15 lighthouses, the foundation structure carries the tower, if present, and the light. The foundation structure lies underwater, in the intertidal zone, in the foam zone and possibly in the aerosol zone. The foundation structure includes the foundation elements with which it is anchored in the sea floor.

20 In the course of the planned expansion of wind power utilization, a large number of offshore wind power plants are planned for the coming years both in the North Sea and in other seas and in inland seas. The overall mechanical system of an offshore wind power plant comprises the components turbine, rotors, tower and foundation structure.

25 In order to base these plants on the bottom of the body of water, at locations up to over 100 km from the coast, specific constructions are required, which differ highly

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from the constructions in the onshore region. Some regions of these complicated constructions, such as monopiles, jackets, tripods, tripiles, etc., are subjected to high static and primarily dynamic and corrosive loading. Depending on the position and water depth at the respectively considered location, what are known as the 50-year wave and the tidal range have to be taken into account. Added to this are high UV radiation, salty spray, foam, aerosols, temperature changes, mechanical loadings, growth with mussels and other life forms and associated mechanical wear by animals and chemical ablation as a result of discharges from animals and other marine life forms. For these constructions, use is made of steel pipes which, for corrosion protection reasons, can be sealed off in an airtight manner or filled with concrete. Furthermore, power or other supply lines can run through the steel construction pipes.

To date, the metal pipes needed for the construction have been designed with substantially thicker wall thicknesses (up to 25%) than directly necessary and conventional paints, mostly based on epoxy resin or polyurethane, are used for the corrosion protection. As a rule, these paint systems do not offer particular protection against mechanical loading. In addition, these frequently have to be applied by hand at great heights, which results in quality control being difficult. The quality of such a coating is not comparable with the coating performed at the factory.

EP 2 511 430 A1 describes that steel construction pipes which are covered with an extruded layer made of a polyamide moulding compound can be used in the foundation structure of offshore structures. Better protection against mechanical loadings and against corrosion and UV irradiation is achieved therewith than in the case of the previously known applicable pipes. The covering can also be formed in multiple layers.

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Pipelines made of metal are currently frequently covered with a polyolefin such as polyethylene or polypropylene (WO 2002/094922 A1; US 2002/0066491 A1; EP-A-0 346 101 A2). The coatings or coverings are used primarily for corrosion protection; they are described by corresponding standards. For the polyolefin
5 covering, these are, for example, DIN EN 10288 and DIN 30678. In the case of the polyolefin covering, this layer is produced, for example, by means of tubular or wrapping extrusion. For the purpose of adhesion promotion, epoxy and adhesive layers can be applied one after another before the extrusion.

Another prior art, which is regulated by DIN EN 10310 (German version
10 EN 10310:2003), provides for the coating of steel pipes for underground and water-laid pipelines by means of polyamide powder. The polyamide coating is applied by dipping in a fluid bed, spraying on or in the roll application process. Because of the process, only relatively thin layers can be applied to the metal by means of powder coating. Disadvantageous in particular is the fact that a powder made of a relatively
15 low-molecular weight polyamide has to be used for the coating, in order to ensure good flow of the melt on the hot metal surface. A coating obtained in this way is primarily used for corrosion protection. Furthermore, thermosetting coatings based on epoxy or polyurethane are also known.

In pipeline construction, higher technical requirements are to an increasing extent
20 being placed on the pipe coating, since the environmental, laying and operating conditions are becoming more and more demanding. One of the most effective methods to protect underground pipelines against corrosion, in particular in the case of cathodic corrosion protection, is a multilayer covering. This consists of an epoxy resin layer as a first layer, a copolymer as adhesive as a second layer and an outer
25 polyolefin layer made of polyethylene or polypropylene. This covering method can be applied to pipes from small to large. However, in the offshore and onshore area, high requirements are often additionally placed on the resistance against mechanical

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stresses. In order to take this problem into account as well, WO2010/094528 recommends the use of a metallic conduit pipe which is covered with an extruded layer made of a polyamide moulding compound, to produce a pipeline laid in water.

Damage to such corrosion protection coatings leads to the corrosion of the steel construction to be protected and can thus lead to structural endangering of the structure or the pipeline. The prior art is, therefore, firstly, primarily in offshore structures, regular on-site inspection of the corrosion protection; secondly, the steel construction is designed with the inclusion of a safety factor which permits time-limited corrosion of the steel construction caused by damaged protective layers.

Since, for example, offshore wind power plants are not continuously occupied, the inspection of these wind power plants is associated with considerably increased expenditure; a visit to the plant is always necessary. As a result of external influences of the weather and of the sea, a visit or visual inspection of the plant is not always possible, however, which additionally makes the inspection more difficult.

15 Summary of Invention

The object of the invention is, therefore, to develop a wear indicator system for corrosion protection covering systems which, even in the case of non-regular occupancy of offshore structures, permits reliable assessment of the corrosion protection. In particular, travelling to these structures should therefore be limited to a minimum and, in addition, the safety margin in designing these structures can be reduced.

This object has been achieved by a metal pipe which has an at least two-layer corrosion protection covering with an upper and a lower layer, the lower layer being finished such that, in the event of damage to the layer or layers lying above, a visual or electrical signal can be detected.

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The subject-matter of the invention is also the use of such a metal pipe for installation in an offshore structure, in particular in the foundation structure of an offshore structure, or for producing a pipeline laid in water.

In a first possible embodiment, the lower layer, that is to say the one facing the metal, is designed to be electrically conductive, while the upper layer, facing the water, is designed to be electrically insulating. By means of applying an electric voltage with respect to the water, it is thus possible to detect damage to the coating by means of remote monitoring, as a result of the short circuit that then occurs. The water is preferably water which contains dissolved salts, for example seawater or brackish water. The electrically conductive layer can be insulated with respect to the metal. However, it can also be conductively connected to the metal, so that the metal construction is at the same potential.

In a second possible embodiment, two layers lying one above the other are constituted in an optically contrasting manner. In general, they differ in colour. If, for example, the upper layer is set to be yellow and the lower layer red, then damage to the upper layer can be detected by means of the occurrence of red areas. The contrast preferably corresponds at least to the grey scale of 4 (according to DIN EN 20105-A02), particularly preferably at least to the grey scale of 3 and in particular preferably at least to the grey scale of 2/3. The measurement is carried out in accordance with DIN EN ISO 11664-4, using a spectrophotometer (sphere).

In a third possible embodiment, the first and the second embodiment are combined with each other. Damage is detected by means of the occurrence of a short circuit and reported by remote monitoring; on-site, the damage can then be found and repaired quickly by the optical contrast. The principle is illustrated in fig. 1.

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According to one aspect of the present invention, there is provided a corrosion protected metal pipe, comprising: a metal pipe for installation in an offshore structure, or for being laid in water; and an at least two-layer covering on the pipe having a lower layer facing the pipe and an upper layer on a side of the lower layer not facing the pipe; wherein one of: the lower layer is electrically conductive and the upper layer is electrically insulating and for facing water, the lower layer is optically contrasting to the upper layer, and the lower layer is electrically conducting and optically contrasting to the upper layer and the upper layer is electrically insulating; wherein a primer layer is absent from between the metal pipe and the at least two-layer covering; and
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10 wherein the pipe comprises a damage detection means, the damage detection means being a resistance measurement device arranged with a first side for exposure to the water and a second side in contact with the lower layer.

According to another aspect of the present invention, there is provided a corrosion protected metal pipe, comprising: a metal pipe for installation in an offshore structure, or for being laid in water; and an at least two-layer covering on the pipe having a lower layer facing the pipe and an upper layer on a side of the lower layer not facing the pipe; wherein one of: the lower layer is electrically conductive and the upper layer is electrically insulating and for facing water, the lower layer is optically contrasting to the upper layer, and the lower layer is electrically conducting and optically contrasting to the upper layer and the upper layer is electrically insulating; wherein said lower layer of the at least two-layer covering is directly on and in contact with the metal pipe; and wherein the pipe comprises a damage detection means, the damage detection means being a resistance measurement device arranged with a first side for exposure to the water and a second side in contact with the lower layer.
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Brief Description of the Drawings

In fig. 1, a steel pipe with concrete filling is illustrated, which has been covered with a layer made of an electrically conductive plastic and thereafter with a layer made of an electrically insulating plastic. The two plastic materials are coloured differently. The outer, electrically insulating covering layer has been damaged at a point, so that the electrically conductive layer comes into contact with seawater. As a result, a short circuit is detected via an electric resistance measurement. The damaged point can be found by using the optical contrast.

Detailed Description of the Invention

- 10 The electrically conductive design of the lower layer can be carried out in a known way, for example by using a moulding compound filled with conductive carbon black or by embedding axially extending or wound electric conductors, for example wires, stranded wires or tapes. The offshore structure is preferably an offshore wind power plant, a drilling rig or a lighthouse.
- 15 The foundation structure of an offshore wind power plant is the structure which carries the tower. It extends from the foundation elements, which are anchored in the sea floor, via the structure which is located underwater, as far as the point at which the tower begins and which may be located above the calm water level.

The following types, for example, are used as the foundation structure:

- 20 The monopile construction comprises a cylindrical hollow pile. The monopile is used close to the coast in many European offshore wind parks; it is suitable for foundations at water depths of up to currently about 20 metres. Monopiles can be installed simply and quickly; however, heavy pile driving equipment is needed for the erection. In recent times, trials of a gentle installation using a drill head have been carried out.

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The jacket is a latticework construction made of steel which resembles the construction of conventional power masts. At its four feet, the jacket is anchored in the sea floor with piles. The jacket construction has already proven worthwhile in the oil industry at relatively great water depths. As a result of the latticework construction, 40 to 50% steel can be saved as compared with the monopile. Thus, the project costs when this construction is used at relatively great water depths increase only relatively slightly. Since the individual structural elements are relatively small, they can be produced easily and can be transported and mounted simply.

In the case of the tripod, the structure comprises a tripod formed from steel pipes, on which the central pipe is placed centrally. The legs of the tripod can each be seated on a pile or on a plurality thereof. In order to drive the pile, centring sleeves are arranged at the corner points of the equilateral triangle that results. The piles are connected to one another by horizontal struts and connected to the central pipe via diagonal bracing. The central pipe does not enter the sea floor. Since steel pipes having smaller diameters are used in this case, the tripod can be used for water depths of more than 20 metres.

The quadropod is a modification of the tripod concept with four instead of three struts. In this case, increased foundation rigidity is achieved at great water depths.

The tripile comprises three steel piles, which are anchored under water. Above water, a tripod construction is placed on these steel piles. According to manufacturer's information, tripile foundations are suitable for water depths of 25 to 50 metres.

Constructions of this type are described, for example, in the following publications:

- Fundamente für Offshore-Windenergieanlagen [Foundations for Offshore Wind Power Plants], Deutsche Energie-Agentur GmbH, as at 12/09;

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- Florian Biehl, Kollisionssicherheit von Offshore-Windenergieanlagen [Collision Safety of Offshore Wind Power Plants], Stahlbau, Vol. 78 (6), pp. 402 – 409 (2009);

- K. Lesny, W. Richwien (Publishers), Gründung von Offshore-
5 Windenergieanlagen - Werkzeuge für Planung und Bemessung [Foundations of Offshore Wind Power Plants – Tools for Planning and Dimensioning], VGE Verlag Glückauf 2008, ISBN: 978-3-86797-035-8;

- DE 103 10 708 A1.

The upper and the lower layer of the corrosion protection covering consist of a
10 polymer material, for example a polyamide moulding compound, a polyolefin moulding compound, a fluoropolymer moulding compound (for example based on PVDF), a moulding compound based on a thermoplastic polyurethane, a cross-linked polyurethane or a cross-linked epoxy resin.

In a preferred embodiment, the upper layer consists of a polyamide moulding
15 compound applied by extrusion. The lower layer can then either likewise consist of a polyamide moulding compound, a polyolefin moulding compound or another polymer material. The material of this lower layer can contain an adhesive resin, for example epoxy resin (for example Araldite®); in this case, this layer can be applied directly to the metal surface.

20 In general, however, between the metal surface and the lower layer there is at least one further layer. For example, this can involve the following layers:

- A ceramic layer, for example according to WO 03/093374 A2;

- a priming layer, for example of epoxy resin (US 5 580 659 A) or a water-based mixture of epoxy resin and polyacrylate latex (WO 00/04106 A1);

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- an adhesion promoter layer made of a polyamide hot-melt adhesive which, for example, can be applied as powder by spraying, etc. (EP 1 808 468 A2), or of a polyolefin which bears functional groups. Suitable functional groups are, for example, carboxyl groups or acid anhydride groups (WO 02/094922 A1), epoxy groups or alkoxy silane groups (EP-A-0 346 101 A2). The polyolefin layer can also be foamed. The polyolefin is preferably polyethylene or polypropylene;

- a differently composed adhesion promoter, which is intended to ensure that the composite comprising polyamide layer and base material is not impaired under mechanical stress;

10 - a textile reinforcement in the form of woven fabrics or mats, for example made of glass fibres or aramid fibres (Kevlar).

A possible ceramic layer, priming layer, adhesion promoter layer and/or textile reinforcement is applied to the pipe in accordance with any desired method. Suitable methods are prior art.

15 The materials of the upper and lower layer are applied in accordance with known methods, for example by means of tubular or wrapping extrusion. In one possible variant, both layers, possibly together with an adhesion promoter layer, can be produced and applied by means of co-extrusion of a multilayer composite.

20 The tubular and the wrapping extrusion are covering methods that have proven worthwhile over a long time for pipes. These methods are described in more detail in the *Stahlrohr-Handbuch* [Steel Pipe Handbook], 12th edition, pp. 392-409, Vulkan-Verlag Essen, 1995.

The applied layers must be at least so thick that they can be produced as a closed layer under the application conditions. The layer thickness is preferably at least 0.5 mm, particularly preferably at least 1.0 mm and in particular preferably at least 1.2 mm.

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Usually, layer thicknesses up to about 8 mm, preferably up to about 7 mm, particularly preferably up to about 6 mm and in particular preferably up to about 5 mm have proven worthwhile. If required, however, the layer can also be chosen to be thicker, for example up to 30 mm or more.

- 5 The metal pipe consists, for example, of steel, stainless steel, copper, aluminium, cast iron, zinc, alloys with one of these metals as main component, brass, galvanized steel, cadmium-coated steel, aluminium-coated metal, steel coated with metal alloys, such as GALFAN, or of any other metal. The pipe can be produced in accordance with all methods of the prior art, for example as welded or seamless pipe.
- 10 Appropriate production methods are generally known prior art.

The outer diameter of the metal pipe is preferably at least 20 mm and at most 8000 mm.

The individual pipes are connected to one another constructionally in a known way, for example by welding.

- 15 A particular advantage of the invention is that the damage can already be detected and repaired when the metal construction itself has not yet begun to corrode. In this case, the repair is considerably less complicated overall.

CLAIMS:

1. A corrosion protected metal pipe, comprising:
a metal pipe for installation in an offshore structure, or for being laid in water; and
5 an at least two-layer covering on the pipe having a lower layer facing the pipe and an upper layer on a side of the lower layer not facing the pipe;
wherein one of:
the lower layer is electrically conductive and the upper layer is electrically insulating and for facing water,
10 the lower layer is optically contrasting to the upper layer, and
the lower layer is electrically conducting and optically contrasting to the upper layer and the upper layer is electrically insulating;
wherein a primer layer is absent from between the metal pipe and the at least two-layer covering; and
15 wherein the pipe comprises a damage detection means, the damage detection means being a resistance measurement device arranged with a first side for exposure to the water and a second side in contact with the lower layer.
2. The corrosion protected metal pipe according to claim 1,
wherein
20 the lower layer is optically contrasting to the upper layer.
3. The corrosion protected metal pipe according to claim 2, wherein

the optical contrast corresponds at least to a grey scale of 4 according to DIN EN 20105-A02.

4. The corrosion protected metal pipe according to claim 1, wherein the upper and the lower layer each, independently, comprise a polymer material.
5. The corrosion protected metal pipe according to claim 4, wherein the upper layer is a polyamide moulding compound applied by extrusion.
- 10 6. The corrosion protected metal pipe according to claim 1, wherein the lower layer is electrically conductive and the upper layer is electrically insulating.
- 15 7. The corrosion protected metal pipe according to claim 6, wherein the lower layer comprises an electrically conductive material.
8. The corrosion protected metal pipe according to claim 7, wherein the electrically conductive material is selected from the group consisting of conductive carbon black, an axially extending conductive wire or tape and a wound conducting wire or tape.
- 20 9. The corrosion protected metal pipe according to claim 2, wherein the lower layer is colored and the color of the lower layer is in optical contrast to a color of the upper layer.

10. The corrosion protected metal pipe according to claim 1, further comprising at least one layer, which is other than a primer layer, between the metal surface and the lower layer.

11. The corrosion protected metal pipe according to claim 10, wherein the
5 at least one layer between the metal surface and the lower layer is selected from the group consisting of a ceramic layer, an adhesion promoting layer and a textile reinforcement.

12. The corrosion protected metal pipe according to claim 11, wherein the
10 at least one layer between the metal surface and the lower layer is the adhesion promoting layer and the adhesion promoting layer is a polyamide hot-melt adhesive, or a polyolefin having functional groups.

13. The corrosion protected metal pipe according to claim 11, wherein the at least one layer between the metal surface and the lower layer is the textile reinforcement and the textile reinforcement is a woven fabric or mat.

14. The corrosion protected metal pipe according to claim 1, wherein the
15 pipe metal is a metal material selected from the group consisting of steel, stainless steel, copper, aluminium, cast iron, zinc, an alloy comprising copper, aluminum or zinc as a main component, brass, galvanized steel, cadmium-coated steel, aluminium-coated metal, and steel coated with a metal alloy.

15. A corrosion protected metal pipe, comprising:
20 a metal pipe for installation in an offshore structure, or for being laid in water; and

an at least two-layer covering on the pipe having a lower layer facing the pipe and an upper layer on a side of the lower layer not facing the pipe;

25 wherein one of:

the lower layer is electrically conductive and the upper layer is electrically insulating and for facing water,

the lower layer is optically contrasting to the upper layer, and

the lower layer is electrically conducting and optically contrasting to the upper layer and the upper layer is electrically insulating;

wherein said lower layer of the at least two-layer covering is directly on and in contact with the metal pipe; and

wherein the pipe comprises a damage detection means, the damage detection means being a resistance measurement device arranged with a first side for exposure to the water and a second side in contact with the lower layer.

16. The corrosion protected metal pipe according to claim 15,

wherein

the lower layer is electrically conductive and the upper layer is electrically insulating.

15 17. The corrosion protected metal pipe according to claim 16, wherein the lower layer comprises an electrically conductive material.

18. The corrosion protected metal pipe according to claim 15,

wherein

the lower layer is optically contrasting to the upper layer.

20 19. The corrosion protected metal pipe according to claim 18, wherein

the optical contrast corresponds at least to a grey scale of 4 according to DIN EN 20105-A02.

20. The corrosion protected metal pipe according to claim 17, wherein the upper and the lower layer each, independently, comprise a polymer material.
21. The corrosion protected metal pipe according to claim 20,
5 wherein
the upper layer is a polyamide moulding compound applied by extrusion.
22. The corrosion protected metal pipe according to claim 17, wherein the electrically conductive material is selected from the group consisting of conductive
10 carbon black, an axially extending conductive wire or tape and a wound conducting wire or tape.
23. The corrosion protected metal pipe according to claim 18, wherein the lower layer is colored and the color of the lower layer is in optical contrast to a color of the upper layer.
- 15 24. The corrosion protected metal pipe according to claim 15, wherein the pipe metal is a metal material selected from the group consisting of steel, stainless steel, copper, aluminium, cast iron, zinc, an alloy comprising copper, aluminum or zinc as a main component, brass, galvanized steel, cadmium-coated steel, aluminium-coated metal, and steel coated with a metal alloy.

201100539 Foreign Countries

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Resistance measurement

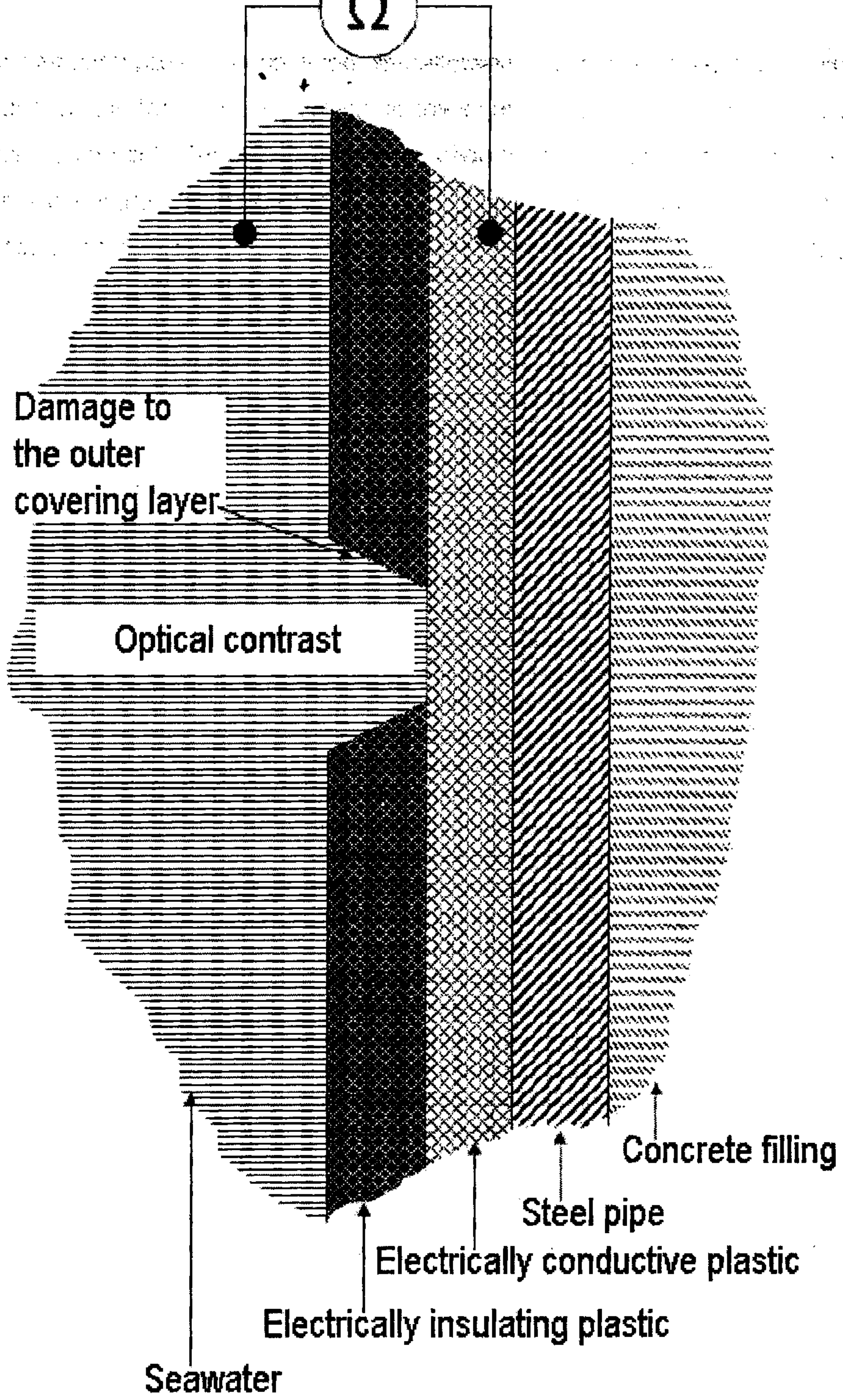


Fig. 1

Resistance measurement

