

# Maintenance Painting Specification N° 413B

**APPLICATION: EXTERNAL, EXPOSED STEELWORK (10-20 YEARS).**

**ENVIRONMENT:** Industrial areas with high humidity and aggressive atmospheres, coastal and offshore areas with low salinity (ISO 12944 up to C4)

**LIFE TO FIRST MAINTENANCE:** This system based on epoxy primers and polyurethane topcoat is considered suitable for a 10-20 year life to first maintenance in the environment described.

**PROJECT DESCRIPTION** Suitable for all steel work in urban and industrial atmospheres with moderate and pollution and/or coastal areas with low salinity. Typical applications are pipes, cranes, mechanical equipment, bridges, railings, tank externals and other structural steel.

**SURFACE PREPARATION:**

**Degrease** to remove oil, grease and dirt using a water based degreaser.

**Manual preparation:** Prepare using rust scrapers, chipping hammers, needle guns, wire brushes etc. to St2 as per EN ISO 8501 – 1:1998 standard or equivalent or. Ensure all scale is removed. Wash down with clean fresh water prior to application. Allow to dry.

**Mechanical Preparation:** Blast clean to minimum Sa1 as per EN ISO 8501-1:1998 or equivalent. Wash down with clean fresh water prior to application. Allow to dry.

**New steel:** All mill scale must be removed prior to application.

**Surface Profile:** Minimum 50 to Maximum 75 microns (3 Mils)

### COATING SYSTEM RECOMMENDED

COAT	PRODUCT	WET FILM THICKNESS	DRY FILM THICKNESS
1	Corroless EPF primer	207 microns	200 microns
3	Corroless RF60 Topcoat	69 microns	40 microns
4	Corroless RF60 Topcoat	69 microns	40 microns
Typical total dry film thickness			280 microns

**Stripe coat all nuts, bolts, edges welds etc before each full coat.**

**NOTES**

Although the system meets the performance requirements of ISO 12944 1998 Category C4 it should be noted that we specify a lower standard of preparation than the standard requires because of the unique rust stabilising characteristics of our primers.

\*Corroless RF65 is a semi-gloss finish if a full gloss is required use Corroless RF61