

Maintenance Painting Specification N° 604

APPLICATION: EXTERNAL, EXPOSED STEELWORK (15-25 YEARS).

ENVIRONMENT: Industrial areas with high humidity and aggressive atmospheres, coastal and offshore areas with high salinity (ISO 12944 C5I and C5M)

LIFE TO FIRST MAINTENANCE: This system based on epoxy primers and polyurethane topcoat is considered suitable for a life of 15-25 years to first maintenance in the environment described.

PROJECT DESCRIPTION Suitable for all steel work in industrial atmospheres with high humidity and pollution and/or coastal and offshore areas with high 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
2	Corroless EPF primer	207 microns	200 microns
3	Corroless RF65 Topcoat*	69 microns	40 microns
Typical total dry film thickness			440 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 Categories C5I and C5M an 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