

Maintenance Painting Specification N° 804A

APPLICATION: IMMERSED STEELWORK (5-10 YEARS).			
ENVIRONMENT: Immersion in fresh water (ISO 12944, IM1) in sea or brackish water (IM2)			
LIFE TO FIRST MAINTENANCE: This system based on a solventless epoxy system is considered suitable for a 5-10 year life to first maintenance in the environment described.			
PROJECT DESCRIPTION: Suitable for River installations, Hydroelectric power plant, Harbour areas with structures like sluice gates, locks, jetties, offshore structures, ballast tanks, buried tanks, steel piling, buried pipes and constantly wet steel work.			
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 Mills).			
COATING SYSTEM RECOMMENDED			
COAT	PRODUCT	WET FILM THICKNESS	DRY FILM THICKNESS
1	Corroless EPF primer	207 microns	200 microns
2	Corroless RF35 Topcoat	210 microns	200 microns
Typical total dry film thickness			600 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 IM1 and IM2 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.			