

COATING SPECIFICATION

ZINC RICH EPOXY PRIMER, EPOXY MASTIC COATING ON STEEL OR CAST IRON

COATING SPECIFICATION: C3 ISSUE:4 DATE: DECEMBER 2022

1.0 SCOPE

This document summarises the procedure for the application of a 2 pack of zinc rich epoxy primer over-coated with a 2 pack of epoxy mastic.

Zinc rich epoxy primer	80microns DFT
Epoxy Mastic	150 microns DFT
Total DFT 230 microns	

Refer to Design Standard, DS 95 (Standard for the Selection, Preparation, Application, Inspection and Testing of Protective Coatings on Water Corporation Assets) for details for additional information or clarification.

It shall be read in conjunction with Water Corporation surface preparation specification **A1 - Surface Preparation for the application of Protective Coatings on Steel or Cast Iron.**

2.0 PURPOSE

This is a two-coat system primarily designed for applications including pump bases, where UV degradation is not an issue; the coating system shall not be used in immersed or buried conditions or exposed to corrosive environment such as hydrogen sulphide. It can be used for atmospheric corrosivity categories C1 to C5 as described in AS/NZS 2312. For corrosivity categories C4 & C5, Micaceous Iron Oxide (MIO) epoxy mastic is preferred (refer to the product list in Appendix 3 of DS 95).

3.0 DEFINITIONS

ACA: Australasian Corrosion Association.

Contractor: The service provider or its sub-contractor who will undertake the works.

Corporation: The Water Corporation and the Principal for the purposes of externally contracted asset delivery.

DFT: Dry Film Thickness.

ITP: The detailed Inspection and Test Plan(s) for the Works.

NACE: National Association of Corrosion Engineers.

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ZINC RICH EPOXY PRIMER, EPOXY MASTIC COATING ON STEEL OR CAST IRON

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Superintendent: The Superintendent for the contract, as defined in the conditions of contract, who is appointed by the Water Corporation to manage/oversee the work under the contract on behalf of the Water Corporation.

Works: The surface preparation, coating application and inspection to be undertaken by the Contractor to which this coating specification applies.

4.0 SUBSTRATE PREPARATION

- 4.1 All visible mill scale, rust, oxides, paint and other foreign matter shall be removed from the surfaces to be coated by blast cleaning to a **Class 3** (white metal) finish as specified in AS/NZS 1627 Part 4.
- 4.2 The blast cleaned surfaces shall have a uniform metallic appearance, a surface profile which provides satisfactory anchorage for the coating, as per paint manufacturer's recommendation and be otherwise compatible with the coating to be applied.
- 4.3 Coating shall not be applied to any prepared surface(s) exhibiting "flash corrosion" or that has been abrasive blasted more than 4 hours prior to commencement of coating.

5.0 COATING MATERIALS

- 5.1 Coating materials used for attaining the specified standard shall be selected in accordance with Appendix 3 of DS-95- commonly used coatings in potable water and wastewater infrastructures unless approved otherwise by the Team Leader – Asset Durability. This approval is required before coating commences.
- 5.2 The coating components shall be thoroughly mixed in the specified proportions. Material so prepared shall be used within the "pot-life" period claimed by the manufacturer for the relevant site conditions.
- 5.3 Coating specifications inclusive of datasheets, coating application method statements and ITP shall be submitted to the Principal for approval at least 10 working days prior to commencement of work.
- 5.4 Surfaces to be coated which will become inaccessible after assembly or erection shall be cleaned and painted before they become inaccessible.
- 5.5 Welds, edges, crevices, seams, joints and corners shall be brush coated before commencement of spray application of the coating.
- 5.6 Mixing, thinning, application and curing of protective coatings shall be carried out in accordance with the coating manufacturer's recommended practice for the on-site conditions.

COATING SPECIFICATION

ZINC RICH EPOXY PRIMER, EPOXY MASTIC COATING ON STEEL OR CAST IRON

COATING SPECIFICATION: C3 ISSUE:4 DATE: DECEMBER 2022

- 5.7 Recommended drying times between coats shall not be exceeded.
- 5.8 Applied coatings shall be protected from rain or moisture until cured.

6.0 ATMOSPHERIC CONDITIONS

- 6.1 Prior to and during coating application, the contractor shall record details pertaining to environmental conditions including ambient and surface temperature, relative humidity and dew point.
- 6.2 Coating application shall not commence if any one of the following conditions exists:
- The relative humidity is above 85%;
 - The substrate temperature is less than dew point plus 3°C;
 - The substrate temperature is below 10°C;
 - The substrate temperature is above 55°C;
 - The surface to be coated is wet or damp;
 - The specified surface cleanliness deteriorates, such that primer cannot be applied
 - If the weather is deteriorating or is unfavourable for application or curing;
 - If the pot life of the paint has been exceeded.

7.0 COATING THICKNESS

- 7.1 Coating thickness of a nominal dry film thickness of 80 microns of a 2 pack zinc rich epoxy primer, over-coated with 150 microns of a 2 pack epoxy mastic with a total thickness of 230 microns.

Caution:

Care should be exercised to avoid the application of zinc rich epoxy primer of Dry Film Thicknesses (DFT) in excess of 150 microns.

8.0 COATING FINISH

- 8.1 The finished coating shall be of uniform thickness, colour, appearance and gloss. It shall be fully cured, insoluble, adherent, coherent and free from mud cracking, holidays, laps, sags, blistering, checking, wrinkling, overspray, patchiness and any other defects that may impair the performance and/or appearance of the coating.

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ZINC RICH EPOXY PRIMER, EPOXY MASTIC COATING ON STEEL OR CAST IRON

COATING SPECIFICATION: C3 ISSUE:4 DATE: DECEMBER 2022

9.0 COATING APPLICATOR/PERSONNEL QUALIFICATION

- 9.1 Work shall only be carried out by a competent person.
- 9.2 The work shall be undertaken by an approved Water Corporation Protective Coating and Concrete Repair Panel member.
- 9.3 The Contractor shall nominate a certified coating inspector to perform inspections and maintain appropriate records for the work performed. The coating Inspector engaged in testing, monitoring and verification of surface preparation and coating application shall hold relevant inspection qualifications and current certifications (e.g. NACE or ACA) or approved by the Principal. The coating inspector shall conduct the following:
- Prepare Quality Assurance documentation to meet the specified standards given herein and the required acceptance criteria.
 - Perform inspections and maintain appropriate records for work performed.
 - Testing, monitoring and verification of surface preparation and coating application.

10.0 INSPECTION AND TESTING OF COATING

- 10.1 Coatings shall be visually examined for surface defects and any discontinuity arising after curing shall be recorded.
- 10.2 Finished coating thickness shall be determined using suitable instruments standardised (zeroed) on a smooth uncoated metal plate in accordance with AS 3894.3.

11.0 REPAIR OF A DEFECTIVE COATING AND RETESTING

- 11.1 Coatings with defective areas equal to 20% or more of the total coated surface will be rejected outright.
- 11.2 Defects such as pinholes, cracks, blisters, voids, foreign inclusions and irregular profile peaks shall be marked for repair and retested upon full cure of the repaired coating.

12.0 RECORDING AND REPORTING

- 12.1 Following testing a report shall be submitted by the Contractor. The Contractor shall keep detailed records and reports including the following:

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- Environmental conditions (relative humidity, dew point etc.);
- Surface preparation;
- Surface profile;
- Coating application;
- Coating testing;
- General failure.

12.2 To supplement these records, prior to any works commencing, an Inspection Test Plan (ITP) shall be forwarded to the Water Corporation for review a minimum of 10 working days prior to the commencement of work.

13.0 CONTRACTOR'S RESPONSIBILITY

- 13.1 The Contractor shall supply all necessary plant, equipment, materials and labour, prepare the surface and apply and maintain the protective coating in accordance with this specification
- 13.2 A list of all items to be inspected and the relevant drawing reference shall be forwarded to the Water Corporation Coating Inspector prior to the inspection being undertaken.
- 13.3 The preceding inspection clauses shall not relieve the Contractor of their responsibility to supply materials and perform work in accordance with the requirements of any overriding contract documentation.

Document Revision History					
Sect	Issue	Date	Revision Description	RVWD	APROV
9	4	6/12/2022	Amend coating applicator/personnel qualification	AO	SS

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