

<b>Coating Schedule</b> <b>Compiled By: Towers Infrastructure Management</b>	<b>Reference No: 233</b> <b>Date: 18 August 2016</b>
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<b>Item:</b>	<b>Site Welding Repair Specification.</b>  Site repair of heat damaged areas of existing galvanised members due to the welding of strengthening steel work onto the primary structure.
<b>Service Conditions:</b>	Mild, Moderate, Tropical, Industrial and Marine atmospheric exposures.
<b>Pre-treatment:</b>	Remove all weld slag, spatter; smooth all sharp edges and corners to a 2mm radius and to achieve a Grade P2 surface finish as per ISO 8501.3. Rinse with fresh clean water
<b>Surface Preparation:</b>	Power tool clean the welded and heat-affected surfaces as per AS 1627.2. Remove any unsound adjacent coating material damaged during hot-work. Avoid causing excessive damage to the galvanising or the existing coating system. All surfaces are to be clean and dry before coating and between coats.
<b>The Repair Zone</b>	The entire area of the welded steelwork affected by heat shall be fully treated in accordance with one of the approved coating systems specified below.  Where cleats have been welded to a solid round leg, the entire circumference of the leg must be repaired and painted. The repair zone is to extend for 100mm above and below each weld.

## Two Approved Coating Systems

<b>Dulux</b>	<b>Product</b>	<b>DFT/WFT (microns)</b>		<b>Recoat Min/Max</b>		<b>Solvent</b>
<b>Spot Primer:</b>	Zincanode 402(Cold Cure)	75	155	4 hrs	30 days	Epoxy
<b>Intermediate:</b>	Durebild STE (Cold Cure)	100	125	9 hrs	30 days	Epoxy
<b>Finish Coat</b>	Durebild STE (Cold Cure)	100	125	9 hrs	30 days	Epoxy

<b>Carboline</b>	<b>Spot Primer</b>	<b>Spot Intermediate</b>	<b>Spot Finish Coat</b>
<b>Product:</b>	Carbozinc 858	TP Vinyl 2 Primer	TP Vinyl 2 Topcoat
<b>Coating Type:</b>	Epoxy zinc-rich	High build MIO vinyl	High build MIO vinyl
<b>Colour:</b>	Light Grey	Green	N35 Light Grey
<b>Specified DFT:</b>	80 microns	60 microns	60 microns
<b>Nominal WFT:</b>	125 microns	120 microns	120 microns
<b>Mix Ratio:</b>	3A:1B	Single pack	Single pack
<b>Recoat time @ 25°C (Min/Max):</b>	6 hours/14 days	16 hours/Indef	16 hours/Indef
<b>Solvent:</b>	No 2 Thinner	No 10 or X-100	No 10 or X-100
<b>Application Method:</b>	Brush, roller, spray	Brush, roller, spray	Brush, roller, spray

### Notes:

- Apply the zinc primer to bare steel only or to any locations where the galvanising has been damaged or is below 50 µm.
- The Intermediate and Finish Coats will be either Spot or Full coats as nominated in the Work Scope.
- A stripe coat of epoxy is to be applied after the primer to all edges, corners, welds, etc., as detailed in the Specification.
- More than one application of each coat may be required to achieve the nominated DFT particularly if using brush or roller.
- Alternate coats of epoxy shall be of a different shade.
- The finish colour is to be Light Grey (AS 2700 N35) unless noted otherwise.
- This Specification must be read in conjunction with the latest Product Data Sheets and SDS.
- The use of thinners other than those specified by the manufacturer is not permitted.