

Powder coating

Life to First Maintenance:	20 - 25 years
Environment:	EXTERNAL - STANDARD NON-COASTAL
Standard:	ISO 12944:2007
<hr/>	
Items:	Fabricated structural or architectural steelwork
Preparation:	Blast clean to SA2 (50-75 microns)
First coat:	Hot zinc metal spray (50-75microns)
Second coat :	De-gas inside stoving oven
Third coat :	Apply polyester powder coating (60-100 micron) Total recommended min 110 microns DFT
Packaging:	Wrapped in foam, bubble wrap and cardboard onto pallets or bearers wherever possible
Site coating:	Not available. However, specialist overcoating in wet spray epoxy can be achieved if coating damaged.
Process documents:	On request, all projects can be traced via process inspection reports, calibrated micrometer readings and a final certificate of conformity issued.
<hr/>	

Notes Hot zinc metal spray gives off 'gassing' which forms pinholing, this can be overcome by the allowance of pre-heating (de-gassing).