Upadated February 2009

METHOD STATEMENT n. 3

RENOVATING THE ANTICORROSIVE PROTECTION OF STEEL BRIDGE STRUCTURES

SURFACE PREPARATION

The steel surfaces to be coated shall be grit-blasted to SA 2½ grade.
After grit-blasting carefully blow away or dust-off all remaining foreign particles. Take particular care in removing residuals from hidden cavities, complicated structures, etc.
As soon as possible, in all cases not later than 2-3 hours, the cleaned surface shall receive one coat of S PRIMER, epoxy-zinc phosphate primer.

APPLICATION

FIRST COAT

The Primer
S PRIMER is a two-pack epoxy-zinc chromate primer supplied in Kg 25 pre-weighted packs, separate pails, Kg 20 for component A (resin) and Kg 5 for component B (hardener). Mixing ratio: 4:1.

Mixing

Pour the whole content of can B (hardener) into the can containing component A (resin). Mix thoroughly for 3-5 minutes using a suitable low-speed mechanical mixer until the material attains uniform consistency and colour.
For small quantities, mix each component separately, then measure by weight 4 parts of component A and 1 part of component B, mix then together to a uniform colour.
While mixing, take care to scrape the sides and bottom of the packs.

Do not add diluent.

Application

S PRIMER may be applied by roller, brush or airless sprayer.
When using airless sprayers, S PRIMER may be diluted, if required, with up to 5% of Omnia Thinner.
Apply the primer at a rate of 150 gr/m² to obtain a dry film thickness of 40-50 µ per coat

THE INTERMEDIATE COAT
Within 6 to 24 hours apply one intermediate coat of 100 COAT, two-pack epoxy-vinyl coat, supplied in kg 26,3 pre-weight packs, separate pails, kg 23,7 for component A (resin) and kg 2,6 for component B (hardener). Mixing ratio: 9:1.

Mixing.

Pour the whole content of can B (hardener) into the can containing component A (resin). Mix thoroughly for 3-5 minutes using a suitable low-speed mechanical mixer until the material attains uniform consistency and colour.
For small quantities start mixing each component separately, then measure by weight 9 parts of A and 1 part of component B, mix them together to a uniform colour.
While mixing, take care to scrape the sides and bottom of the packs.

Do not add diluent.

Application

Make sure that the already primed substrate has not been contaminated by water or other foreign substances, if so clean accurately, then apply 100 COAT preferably by airless sprayers for large surfaces.
Before spraying, the coating may be diluted, if required, with up to 5% of Omnia thinner.
Apply the coating at a rate of 200-230 gr/m² to obtain a dry film thickness of 80-100 µ.

THE FINAL COAT

Within 18-36 hours, apply a finishing coat of PU COAT, two-packs, Acrylic-Polyurethane Coating, supplied in 22 Kg pre-weighted packs, separate pails, Kg 17,6 for component A (resin) and Kg 4,4 for component B (hardener). Mixing ratio: 4:1.

Mixing

Pour the whole content of can B (hardener) into the can containing component A (resin). Mix thoroughly for 3-5 minutes using a suitable low-speed mechanical mixer until the material attains uniform consistency and colour.
For small quantities start mixing each component separately, then measure by weight 4 parts of A and 1 part of component B, mix them together to a uniform colour.
While mixing, take care to scrape the sides and bottom of the packs.

Do not add diluent

Application
Make sure that the already coated substrate has not been contaminated by water or other foreign substances, if so clean accurately, then apply PU COAT preferably by airless sprayers for large surfaces.
Before spraying, the coating may be diluted, if required, with up to 5% of Omnia thinner.
Apply the coating at a rate of 120-150 gr/m² to obtain a dry film thickness of 50-60 µ.

Make sure that ambient relative humidity is less then 80%.