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## NEW WORK , ACID ENVIRONMENT

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## 1 GENERAL

This system details the coating of structural steelwork, plate work, mechanical equipment, and structures situated in an acid fume environment. The system is liable to chalk with ultra violet exposure.

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## 2 REQUIREMENTS

This system shall be applied in accordance with AA Specification 164050. It is imperative that this document has been read prior to the commencement of any application.

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## 3 SURFACE PREPARATION

Abrasive blast to a white finish in accordance with SA-3 of ISO 8501-1 to obtain a surface profile of 45µm to 65µm.

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## 4 APPLICATION

- Primer** : One complete coat of epoxy primer. DFT shall be 75 to 125µm.
- Intermediate** : One complete coat of epoxy mastic. DFT shall be 125 to 150µm.
- Finish** : One complete coat of epoxy finish. DFT shall be 75 to 100µm.

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## 5 TOTAL THICKNESS

The total DFT of the system shall be 275µm to 375µm.

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## 6 APPROVED COATINGS

	<b>Brand name</b>	<b>Manufacturer</b>
<b>Primer</b>	: Carboguard 193	Stoncor
	Sigmacover 256 S	Sigma Coatings (Pty) Ltd.
	Interzone 954	Plascon
	Penguard Express	Jotun Coatings (Pty) Ltd.
<b>Intermediate</b>	: Carboguard 188 HB	Stoncor
	Sigmacover 630/1000	Sigma Coatings (Pty) Ltd.
	Primastic	Jotun Coatings (Pty) Ltd.
	Not required	Plascon
<b>Finish</b>	: Carboguard 188 Finish	Stoncor
	Sigmacover 630/1000	Sigma Coatings (Pty) Ltd
	Interzone 954	Plascon
	Penguard Topcoat	Jotun Coatings (Pty) Ltd
<b>Note</b>	: Individual coating materials as supplied from different manufacturers have their own particular build characteristic.	

It is the responsibility of the applicator to ensure that he can achieve the required DFT of any and all of the required coats in a single application. If multi-coats are required, they shall be applied within the re-coat restrictions of that particular coating and all additional labour shall be for the sole account of the applicator.

## APPENDIX A: REFERENCED DOCUMENTS

AA\_CPS\_00043902, New Work, Acid Environment

AA Spec 164050 : Corrosion Protection of Steelwork with Coatings

SANS ISO 8501-1 : Pictorial surface preparation standards for painting steel surfaces

## APPENDIX B: RECORD OF AMENDMENTS

Issue 0 : Reviewed and amended (T Perham 28/04/06).

Issue 1 : Reviewed and Updated Clause 6 (T Perham, May 2008); Appendix A added.

Issue 2 : Rebranded (J Orkney, June 2011)