

Application Guide



Epoxy HR

Product description

This is a two component polyamine cured phenolic/novolac epoxy coating. It is heat resistant up to 205 °C (401 °F) and can be applied on hot substrates up to 150 °C (302 °F). The standard aluminium version may be used as primer, mid coat or finish coat. Suitable for properly prepared carbon steel, galvanised steel, stainless steel and aluminium substrates.

Scope

The Application Guide offers product details and recommended practices for the use of the product.

The data and information provided are not definite requirements. They are guidelines to assist with efficient and safe use, and optimum service of the product. Adherence to the guidelines does not relieve the applicator of responsibility for ensuring that the work meets specification requirements. Jotuns liability is in accordance with general product liability rules.

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

Referred standards

Reference is generally made to ISO Standards. When using standards from other regions it is recommended to reference only one corresponding standard for the substrate being treated.

Surface preparation

The required quality of surface preparation can vary depending on the area of use, expected durability and if applicable, project specification.

When preparing new surfaces, maintaining already coated surfaces or aged coatings it is necessary to remove all contamination that can interfere with coating adhesion, and prepare a sound substrate for the subsequent product.

Inspect the surface for hydrocarbon and other contamination and if present, remove with an alkaline detergent. Agitate the surface to activate the cleaner and before it dries, wash the treated area using fresh water.

Paint solvents (thinners) shall not be used for general degreasing or preparation of the surface for painting due to the risk of spreading dissolved hydrocarbon contamination. Paint thinners can be used to treat small localized areas of contamination such as marks from marker pens. Use clean, white cotton cloths that are turned and replaced often. Do not bundle used solvent saturated cloths. Place used cloths into water.

Process sequence

Surface preparation and coating should normally be commenced only after all welding, degreasing, removal of sharp edges, weld spatter and treatment of welds is complete. It is important that all hot work is completed before coating commences.

Soluble salts removal

Soluble salts have a negative impact on the coating systems performance, especially when immersed. Jotun's general recommendations for maximum soluble salts (sampled and measured as per ISO 8502-6 and -9) content on a surface are:

For areas exposed to (ISO 12944-2):

C1-C4: 200 mg/m²

C5M or C5I: 100 mg/m²

Im1-Im3: 80 mg/m²

It is impractical to check salt level on hot substrates, hence the best recommendation practical when preparing a hot surface in the field is to carry out a thorough high pressure fresh water cleaning. Extra attention must be put

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to badly pitted surfaces.

Carbon steel

Initial rust grade

The steel shall preferably be Rust Grade A or B (ISO 8501-1). It is technically possible to apply the coating to rust grades C and D, but it is practically challenging to ensure specified film thickness on such a rough surface, hence risk of reduced lifetime of the coating system. When steel of Rust Grade C or D is coated, the frequency of inspection and testing should be increased.

Metal finishing

For areas in corrosivity category C1 to C4 (ISO 12944-2) all irregularities, burrs, slivers, slag and spatter on welds, sharp edges and corners shall conform to minimum grade P2 (ISO 8501-3) Table 1, or as specified. For areas in corrosivity category C5, Im1-3 the requirement are for the steel to conform to grade P2 (ISO 8501-3) Table 1. All edges shall have a rounded radius of minimum 2 mm subjected to three pass grinding or equally effective method. One may use a mechanical grinder fitted with a suitable abrasive disc. All sharp irregularities, burrs, slivers, slag and spatter on welds, whether apparent before or after blast cleaning, shall be removed before coating application. It is recommended that welding smoke should be removed by low-pressure Water Cleaning LP WC method (ISO 8501-4) Wa 1 using fresh water. Welding smoke residues are water soluble and could cause blistering if not removed by washing before blasting. Defective welds shall be replaced and treated to an acceptable finish before painting. Temporary welds and brackets shall be ground to a flat finish after removal from the parent metal. Surface preparation and coating should normally be commenced only after all metal finishing and degreasing of a specific area is complete. It is important as much hot work as possible is completed before coating commences.

Pitting repair

Pittings in steel can be difficult to cover fully with most coatings. In some areas it is practically feasible to use filler to fill pittings. This should then be done either after the initial surface preparation or after application of first coat. For tank coating and lining used for chemical exposure the recommendation is to fill pits through welding, since using fillers may negatively affect the coating systems' chemical resistance and flexibility.

Abrasive blast cleaning

Application of protective coating shall commence before degradation of the surface standard occurs.

Cleanliness

After pre-treatment is complete, the surface shall be dry abrasive blast cleaned to Sa 2½ (ISO 8501-1) using abrasive media suitable to achieve a sharp and angular surface profile.

Surface profile

Recommended surface profile 50-85 µm, grade Medium G (ISO 8503-2).

Dust contamination

At the completion of abrasive blasting the prepared surface shall be cleaned to remove residues of corrosion products and abrasive media, and inspected for surface particulate contamination. Maximum contamination level is rating 1 (ISO 8502-3) as per Figure 1. Dust size no greater than class 2.

Hand and Power Tool Cleaning

Power tool cleaning

Minor areas of damaged coating may be prepared to St 2 (ISO 8501-1). Suitable method is disc grinding with rough discs only. Ensure the surface is free from mill scale, residual corrosion, failed coating and is suitable for painting. The surface should appear rough and mat. Overlapping zones to intact coating shall have all leading edges feathered back by sanding methods to remove all sharp leading edges and establish a smooth transition from the exposed substrate to the surrounding coating. Consecutive layers of coating shall be feathered to expose each layer and new coating shall always overlap to an abraded existing layer. Abrade intact coatings around the damaged areas for a minimum 100 mm to ensure a mat, rough surface profile, suitable for over coating. Mechanical repairs are only accepted for minor areas of damage where abrasive blasting is expected to create

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more damage to the coating system than actual benefit to the performance of the coating system.

Galvanised steel

Abrasive blast cleaning

After removal of excess zinc and surface defects the area to be coated shall be degreased to ISO 12944-4, Part 6.2.4 Alkaline Cleaning. The galvanised surface shall be sweep blast-cleaned with the nozzle angle at 45-60° from perpendicular at reduced nozzle pressure to create a sharp and angular surface profile using approved non-metallic abrasive media. As a guide, a surface profile 25-55 µm, grade Fine G; Ry5 (ISO 8503-2) should be achieved. Care must be exercised when sweep blasting. The zinc coating thickness should be reduced as little as possible, preferably not more than 10 µm.

Smaller areas can be lightly treated with abrasive paper.

Finished surfaces shall be dull, profiled and show no areas of shiny metal.

Do not handle the prepared surface with bare hands.

Aluminium

Abrasive blast cleaning

The surface to be coated shall be dry abrasive blast cleaned as required for the specified surface profile using approved non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile. As a guide, a surface profile corresponding to 25-55 µm, grade Fine G; Ry5 (ISO 8503-2) should be achieved.

Examples of recommended abrasives are:

- Ferrite free almandite garnet grade 30/60 and 80 grade (US Mesh size)
- Aluminium oxide grade G24

Stainless steel

Abrasive blast cleaning

The surface to be coated shall be dry abrasive blast cleaned as required for the specified surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile. As a guide, a surface profile corresponding to 25-55 µm, grade Fine G; Ry5 (ISO 8503-2) should be achieved. Examples of recommended abrasives are:

- Ferrite free almandite garnet grade 30/60 and 80 grade (US Mesh size)
- Aluminium oxide grade G24

Chlorinated or chlorine containing solvents or detergents must not be used on stainless steel.

Coated surfaces

Shop primers

Shop primers are accepted as temporary protection of steel plates and profiles. However the shopprimer should be completely removed through blast cleaning to minimum Sa 2½ (ISO 8501-1) using abrasive media suitable to achieve a sharp and angular surface profile 45-85 µm, grade Medium G; Ry5 (ISO 8503- 2).

Application

Acceptable environmental conditions - before and during application

Before application, test the atmospheric conditions in the vicinity of the substrate for the dew formation according to ISO 8502-4.

Air temperature	10 - 60	°C
Substrate temperature	10 - 150	°C
Relative Humidity (RH)	10 - 85	%

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The following restrictions must be observed:

- Only apply the coating when the substrate temperature is at least 3 °C (5 °F) above the dew point
- Do not apply the coating if the substrate is wet or likely to become wet
- Do not apply the coating if the weather is clearly deteriorating or unfavourable for application or curing
- Do not apply the coating in high wind conditions

Product mixing

Product mixing ratio (by volume)

Epoxy HR Comp A	6.5 part(s)
Epoxy HR Comp B	1 part(s)

Induction time and Pot life

Paint temperature	23 °C
Induction time	20 min
Pot life	4 h

Reduced at higher temperatures.

The temperature of base and curing agent is recommended to be 18 °C or higher when the product is mixed.

Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 23

Application data

Spray application

Airless Spray Equipment

Pump ratio (minimum) :	42:1
Pressure at nozzle (minimum) :	150 bar/2100 psi
Nozzle tip (inch/1000) :	17-21
Nozzle output (litres/minute) :	1.3-1.9
Filters (mesh) :	70

Several factors influence, and need to be observed to maintain the recommended pressure at the nozzle. Among factors causing pressure drop are:

- extended hoses or hose bundles
- extended hose whip-end line
- small internal diameter hoses
- high paint viscosity
- large spray nozzle size
- inadequate air capacity from compressor
- incorrect or clogged filters

This Application Guide supersedes those previously issued.

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.
For your nearest local Jotun office, please visit our website at www.jotun.com.

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Film thickness per coat

Typical recommended specification range

Dry film thickness	100 - 200	µm
Wet film thickness	160 - 320	µm
Theoretical spreading rate	6.3 - 3.2	m ² /l

This product can be applied up to 50 % higher than maximum specified film thickness without loss of technical properties.

If the coating is used for temperatures above 150 °C, care must be taken to avoid DFT above 200 µm per coat.

Film thickness measurement

Wet film thickness (WFT) measurement and calculation

Assuming the temperature of the surface is practically making it possible, it is recommended to measure the wet film thickness continuously during application using a painter's wet film comb (ISO 2808 Method 1A). Use a wet-to-dry film calculation table to calculate the required wet film thickness per coat. A wet to dry film thickness chart is available on the Jotun Web site.

Dry film thickness (DFT) measurement

When the coating has cured to hard dry state the dry film thickness can be checked to SSPC PA 2 or equivalent standard using statistical sampling to verify the actual dry film thickness. Measurement and control of the WFT and DFT on welds is done by measuring adjacent to and no further than 15 mm from the weld.

Ventilation

Sufficient ventilation is very important to ensure proper drying/curing of the film.

Coating loss

The consumption of paint should be controlled carefully, with thorough planning and a practical approach to reducing loss. Application of liquid coatings will result in some material loss. Understanding the ways that coating can be lost during the application process, and making appropriate changes, can help reducing material loss.

Some of the factors that can influence the loss of coating material are:

- type of spray gun/unit used
- air pressure used for airless pump or for atomization
- orifice size of the spray tip or nozzle
- fan width of the spray tip or nozzle
- the amount of thinner added
- the distance between spray gun and substrate
- the profile or surface roughness of the substrate. Higher profiles will lead to a higher "dead volume"
- the shape of the substrate target
- environmental conditions such as wind and air temperature

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Drying and Curing time

Substrate temperature	10 °C	15 °C	23 °C	40 °C	100 °C
Surface (touch) dry	16 h	12 h	4 h	2 h	30 min
Walk-on-dry	26 h	20 h	10 h	4 h	1 h
Dry to over coat, minimum	26 h	20 h	10 h	4 h	1 h
Dried/cured for service	21 d	14 d	7 d	3 d	1 d

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The recommended shortest time before the next coat can be applied.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

Maximum over coating intervals

Maximum time before thorough surface preparation is required. The surface must be clean and dry and suitable for over coating. Inspect the surface for chalking and other contamination and if present, remove with an alkaline detergent. Agitate the surface to activate the cleaner and before it dries, wash the treated area by low-pressure water jetting using fresh water.

If maximum over coating interval is exceeded the surface should in addition be carefully roughened to ensure good inter coat adhesion.

Areas for atmospheric exposure

Average temperature during drying/curing	10 °C	15 °C	23 °C	40 °C	100 °C
Itself	21 d	14 d	7 d	3 d	1 h
silicone acrylic	7 d	5 d	5 d	1 d	1 h

Other conditions that can affect drying / curing / over coating

Repair of coating system

Damages to the coating layers:

Prepare the area through sandpapering or grinding, followed by thorough cleaning/vacuuming. When the surface is clean and dry the coating may be over coated by itself or by another product, ref. original specification.

Always observe the maximum over coating intervals. If the maximum over coating interval is exceeded the surface should be carefully roughened in order to ensure good intercoat adhesion.

Damages exposing bare substrate:

Remove all rust, loose paint, grease or other contaminants by spot blasting, mechanical grinding, water and/or solvent washing. Feather edges and roughen the overlap zone of surrounding intact coating. Apply the coating system specified for repair.

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Repair of damaged areas

Sags and runs can be caused by too high wet film thickness, too much thinner added or the spray gun used too close to the surface.

Repair by using a paint brush to smooth the film when still wet.

Sand down to a rough, even surface and re-coat if the coating is cured.

Orange peel can be caused by poor flow/levelling properties of the paint, poor atomization of the paint, thinner evaporating too fast or the spray gun held too close to the surface.

This can be rectified by abrading the surface and applying an additional coat after having adjusted the application properties or the application technique.

Dry spray can be caused by poor atomization of the paint, spray gun held too far from the surface, high air temperature, thinner evaporating too fast or coating applied in windy conditions.

Sand down to a rough even surface and re-coat.

Pinholes can be caused by entrapped solvents in the film or by incorrect application technique. Pinholes can be repaired as per procedure for damages to the coating layer or to the substrate, ref. above.

Coating film continuity

When required by the specification, the coating shall be tested for film discontinuity according to ASTM D 5162, test method A or B as appropriate for the actual dry film thickness.

All recorded defects shall be repaired by best practical means.

Quality assurance

The following information is the minimum required. The specification may have additional requirements.

- Confirm that all welding and other metal work has been completed before commencing pre-treatment and surface preparation
- Confirm that installed ventilation is balanced and has the capacity to deliver and maintain the RAQ
- Confirm that the required surface preparation standard has been achieved and is held prior to coating application
- Confirm that the climatic conditions are within recommendations in the AG, and are held during the application
- Confirm that the required number of stripe coats have been applied
- Confirm that each coat meets the DFT requirements in the specification
- Confirm that the coating has not been adversely affected by rain or other factors during curing
- Observe that adequate coverage has been achieved on corners, crevices, edges and surfaces where the spray gun cannot be positioned so that its spray impinges on the surface at 90° angle
- Observe that the coating is free from defects, discontinuities, insects, abrasive media and other contamination
- Observe that the coating is free from misses, sags, runs, wrinkles, fat edges, mud cracking, blistering, obvious pinholes, excessive dry spray, heavy brush marks and excessive film build
- Observe that the uniformity and colour are satisfactory

All noted defects shall be fully repaired to conform to the coating specification.

Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

For further advice please contact your local Jotun office.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Accuracy of information

Always refer to and use the current (last issued) version of the TDS, SDS and if available, the AG for this product. Always refer to and use the current (last issued) version of all International and Local Authority Standards referred to in the TDS, AG & SDS for this product.

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Colour variation

Some coatings used as the final coat may fade and chalk in time when exposed to sunlight and weathering effects. Coatings designed for high temperature service can undergo colour changes without affecting performance. Some slight colour variation can occur from batch to batch. When long term colour and gloss retention is required, please seek advice from your local Jotun office for assistance in selection of the most suitable top coat for the exposure conditions and durability requirements.

Reference to related documents

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

When applicable, refer to the separate application procedure for Jotun products that are approved to classification societies such as PSPC, IMO etc.

Symbols and abbreviations

min = minutes	TDS = Technical Data Sheet
h = hours	AG = Application Guide
d = days	SDS = Safety Data Sheet
°C = degree Celsius	VOC = Volatile Organic Compound
° = unit of angle	MCI = Jotun Multi Colour Industry (tinted colour)
µm = microns = micrometres	RAQ = Required air quantity
g/l = grams per litre	PPE = Personal Protective Equipment
g/kg = grams per kilogram	EU = European Union
m ² /l = square metres per litre	UK = United Kingdom
mg/m ² = milligrams per square metre	EPA = Environmental Protection Agency
psi = unit of pressure, pounds/inch ²	ISO = International Standards Organisation
Bar = unit of pressure	ASTM = American Society of Testing and Materials
RH = Relative humidity (% RH)	AS/NZS = Australian/New Zealand Standards
UV = Ultraviolet	NACE = National Association of Corrosion Engineers
DFT = dry film thickness	SSPC = The Society for Protective Coatings
WFT = wet film thickness	PSPC = Performance Standard for Protective Coatings
	IMO = International Maritime Organization
	ASFP = Association for Specialist Fire Protection

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.