

# NÁTĚROVÝ SYSTÉM

0100-4-HEM

0	Kovařík			21.7.2023
Revision	Elaborated	Checked	Approved	Date

1. In accordance with the standard DIN EN ISO 12944, part 1 to 8.
2. Accessible edges chamfered / rounded  $1 \times 45^\circ$  / R1.
3. Degrease surfaces for painting.
4. All stainless steel and machined surfaces will be properly protected during blasting.
5. Surface mechanically cleaned.
6. Blasting - degree of purity  $Sa = 2.5$  (ISO 8501-1) - roughness  $Rz = 40 \div 60$  ( $Ra = 12.5$ ).
7. After abrasive blasting blow dry the rest of compressed air.
8. Surface inspection and readiness for painting.
9. The first coat of paint must be conducted within 6 hours after blasting (at 60% RH) or 3 hours (at 80% RH).
10. Checking coating - visual inspection, film thickness ( $\pm 15\%$ ).

## **W1 – Continuous exposure to water and the internal atmosphere of high relative humidity**

Corrosivity category: Im – EN ISO 12 944

Service life 10-15 yer

Paint	Color	Depth NDFT	Coverage
HEMPADUR QUATTRO 17634	19990-black	120µm	3,6 m <sup>2</sup> /liter
THINNER 08450			5% paints
HEMPADUR QUATTRO 17634	50630-red	130µm	3,3 m <sup>2</sup> /liter
THINNER 08450			5% paints
HEMPADUR MASTIC 45880	RAL-On request	130µm	3.7 m <sup>2</sup> /liter
THINNER 08450			5% paints
Total thickness NDFT		380µm	

## **W2 – Inner painting of steel penstock**

Corrosivity category: Im – EN ISO 12 944

Service life 10-15 yer

Paint	Color	Depth NDFT	Coverage
HEMPADUR QUATTRO 17634	19990-black	150µm	2,9 m <sup>2</sup> /liter
THINNER 08450			5% paints
HEMPADUR QUATTRO 17634	50630-red	150µm	2,9 m <sup>2</sup> /liter
THINNER 08450			5% paints
HEMPADUR MASTIC 45880	19990-black	150µm	2,9 m <sup>2</sup> /liter
THINNER 08450			5% paints
Total thickness NDFT		450µm	

## **A1 – The surface in contact with the atmosphere - Internal**

Corrosivity category: C3 – EN ISO 12 944

Service life 10-15 yer

Paint	Color	Depth NDFT	Coverage
HEMPADUR FAST DRY 17410	50630-red	80µm	5,6 m <sup>2</sup> /liter
THINNER 08450			5% paints
HEMPADUR FAST DRY 45410	RAL-On request	80µm	4,9 m <sup>2</sup> /liter
THINNER 08450			5% paints
Total thickness NDFT		160µm	

## **A2 – The surface in contact with the atmosphere - External**

Corrosivity category: C4 – EN ISO 12 944

Service life 10-15 yer

Paint	Color	Depth NDFT	Coverage
HEMPADUR QUATTRO 17634	19990-black	90µm	4,8 m <sup>2</sup> /liter
THINNER 08450			5% paints
HEMPADUR QUATTRO 17634	50630 - red	90µm	4,8 m <sup>2</sup> /liter
THINNER 08450			5% paints
HEMPATHANE HS 55610	RAL-On request	60 µm	6,7 m <sup>2</sup> /liter
THINNER 08450			5% paints
Total thickness NDFT		240µm	

## **S1 – External painting of steel penstock - contack with soil**

Corrosivity category : Im – EN ISO 12 944

Service life 10-15 yer

Paint	Color	Depth NDFT	Coverage
HEMPADUR MULTI-STRENGTH 45753	50630 - red	200µm	2,4 m <sup>2</sup> /liter
THINNER 08450			5% paints
HEMPADUR MULTI-STRENGTH 45753	12340 - grey	200µm	2,4 m <sup>2</sup> /liter
THINNER 08450			5% paints
Total thickness NDFT		400µm	

## **B1 – Parts in concrete**

Paint	Color	Depth NDFT)	Coverage
HEMPADUR QUATTRO 17634	50630 - red	60µm	7,2 m <sup>2</sup> /liter
THINNER 08450			5% of coating
Total thickness NDFT		60µm	

## **O – Surface in contact with oil**

Paint	Color	Depth NDFT	Coverage
HEMPADUR QUATTRO 17634	50630 - red	100µm	4.3 m <sup>2</sup> /liter
THINNER 08450			5% of coating
Total thickness NDFT		100µm	

## **Z1 – Hot-dip galvanized – minimal thickness Zn 120µm**

## **Z2 – Metallization**

Paint	Color	Depth NDFT	Coverage
Metallization ZnAl15	Zinacor 850	150µm	
JOTUN Jotamastic 87 Aluminium	Grey	60µm	
Total thickness NDFT		210µm	

## **K - Preservation for transport**

Preservative, designation	Areas designated for preservation	Coverage
Preservative wax CORTEC VCI - 368	Trimmed seating surfaces and functional	8 m <sup>2</sup> /kg
Long-term protective efficacy for the degree of corrosivity of the atmosphere C5 according to ČSN EN ISO 12944-2		
Preservative oil KONKOR 101	Trimmed seating surfaces and functional	45 m <sup>2</sup> /liter
Short-term protection 3-5 months for the degree of corrosivity C3 (medium aggressiveness)		

**Stainless steel parts are without painting**