

Repairs to Hot Dipped Galvanised Coatings

This procedure is for renovation of uncoated or damaged areas to comply with BS. EN.ISO1461 and ISO 3549 either in house or on site.

General

A. Un-galvanized areas may be up to 10 cm², but the sum of all un-galvanized areas must not exceed 0.5% of the surface area.

B. Renovation coating thickness shall be:

1) On work that is to be subsequently over coated with a paint (Duplex) system the renovating coating thickness shall be applied in coats until judged to be of a similar thickness to the surrounding H.D.G coating. 2) On all other work, then the renovating coating thickness shall be at least 30 µm greater than the local H.D.G. thickness for that material thickness appropriate to ISO1461 (See table below).

C) Only Metatec-Metaflux products are appropriate for this procedure.

D) Observe all health and safety instructions as supplied by Metatec-Metaflux on the container and / or on the Product Safety Data Sheets.

RENOVATION MATERIALS Either:

BASE COAT

Metatec Hyperflex (1 spray coat = 30 – 40 µm)

Metatec-Metaflux Zinc Sheen (1 spray coat = 30 – 40 µm)

Metatec-Metaflux Zinc Spray (1 spray coat = 30 – 40 µm)

Metaflux Zinc Paste (Up to 150 µm in one coat)

FINISHING COAT (NOT NECESSARY IF USING ZINC SHEEN)

Metatec-Metaflux Zinc-Alu Spray (1 spray coat = 25 –30 µm)

Porta Combi Zinc (1 spray coat = 25 –30 µm)

Metatec Cold Galv (1 spray coat = 25 –30 µm)

Tec Alloy Bi Metal (1 spray coat = 20 –30 µm)

PROCEDURE

E) All renovation areas shall be thoroughly cleaned down to bare metal clear of rust, dirt, weld slag, oil, grease etc, the edge of the galvanized coating shall be soundly fused to the steel but feathered back by 15-25 mm.

F) Shake the spray can as instructed to agitate and mix the coating.

G) Spray the area from approx 25-30 cm in 1-2 second bursts to produce the required coating. Allow to “touch dry” between coatings.