

**PAINT SYSTEMS FOR HOT DIPPED GALVANISED STEEL TO AS/NZS 4680 TABLE 7.1**  
**AS PER THE GUIDE TO THE PROTECTION OF STRUCTURAL STEEL AGAINST ATMOSPHERIC CORROSION BY THE USE OF PROTECTIVE COATINGS**  
**AS/NZS 2312.1.2014 PART 2: HOT DIP GALVANISING**

Coating system details													Durability - Years to First Maintenance of paint component of duplex system			
System No	Service qualities	Surface preparation	1st Coat			2nd Coat			3rd Coat			Total nom DFT $\mu\text{m}$	Atmospheric corrosivity category			
			Type	PRN	Nom DFT $\mu\text{m}$	Type	PRN	Nom DFT $\mu\text{m}$	Type	PRN	Nom DFT $\mu\text{m}$		C2 Low	C3 Med	C4 High	C5-I Very high
2D	Decorative	Degrease, wash and dry followed by sweep blast cleaning	Epoxy Primer (2-pack) Inhibitive	C06	75	Polyurethane or acrylic gloss (2-pack)	C26 or C33	100				175	10-15	10-15	5-10	NR
3I	Wear and Tear Industrial	Degrease, wash and dry followed by sweep blast cleaning	Epoxy Primer (2-pack) Inhibitive	C06	75	High Build Epoxy (2-pack)	C13	150				225	>15	10-15	10-15	5-10
4D	Protective Long Term Industrial	Degrease, wash and dry followed by sweep blast cleaning	High Build Epoxy (2-pack)	C13	250	Polyurethane or acrylic gloss (2-pack)	C26 or C33	100				350	>15	>15	10-15	5-10
5D	Protective Long Term Industrial	Degrease, wash and dry followed by sweep blast cleaning	Epoxy Primer (2-pack) Inhibitive	C06	75	High Build Epoxy (2-pack)	C13	225	Polyurethane or acrylic gloss (2-pack)	C26 or C33	100	400	>15	>15	>15	10-15

**NOTES TO TABLE 7.1**

1. The systems shown in this table are generic systems only and are only applicable for hot dip galvanised substrates to AS/NZS 4680, and other systems may be available. Other hot dipped galv coatings have typically thinner hot dipped galvanised substrates, which often require proprierty systems for effectiveduplex protection. Refer to to manufacturer's information for other coating systems
2. The durability range is in this case related to the adhesion of the paint system to the hot-dip-galvanised substrate. Maintenance is often required at more frequent intervals because of paint fading, chalking, contaimination, wear and tear, for aesthetic or other reasons
3. The coating build (thickness) for each paint type has to comply with the paint manufacturer's recommendations. In some cases, this will mean the applicator will need to apply multiple coats to reach the designated NDFT for each paint type.

Notes - Continued

4. To properly assess the applied paint coating thickness, the actual thickness of the hot dip galvanized coating should be measured prior to painting commencing.
  
5. The specifier has to be aware that the micro environments can affect the life of coatings and a thorough investigation of micro-environments should be completed. The recommendations are freely draining exposed structures. For structures not exposed to the cleansing influence of rain and microclimates, such as water, ponding or soil contact, may require additional protection.
  
6. The durability range is not guaranteed. Durability is a technical consideration that can help the owner set up a maintenance program, there are no rules that link the durability of a system and guarantee. The guarantee time is usually shorter than the durability range (see AS/NZS 2312.1)
  
7. Category C5 covers atmospheres that could be generally encountered at various industrial locations. Special care should be taken when writing coating specifications for items of equipment or steelwork that could suffer from specific chemical spillages, leaking pipes or heavy air-borne contamination.