

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.01	X			

TEC2.01 Low

**TEKNOLAC PRIMER 0168-00
Paint systems 80 µm**

1 1.8.2018

TEKNOLAC PRIMER 0168-00 paint systems consist of different kind of fast drying alkyd paints having very good corrosion protection properties. TEKNOLAC PRIMER 0168-00 contains efficient active anticorrosive pigments.

These paint systems are designed for corrosivity category C2 with durability class low.

Paint		B1	B2
TEKNOLAC PRIMER 0168-00	AK	1x40 µm	1x40 µm
TEKNOLAC COMBI 50	AK	1x40 µm	
TEKNOLAC 0191	AK		1x40 µm
Total film thickness		80 µm	80 µm
Paint system VOC, g/m ²		85	82

Example of Teknos paint system code	Example of paint system structure
TEC2.01/L/B1	ISO 12944-5/C2.01-AK (AK80/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.02	X	X		
C3.01	X			

TEC2.02 Medium
TEC3.01 Low

TEKNOLAC PRIMER 0168-00

Paint systems 100 µm

1 1.8.2018

TEKNOLAC PRIMER 0168-00 paint systems consist of different kind of fast drying alkyd paints having very good corrosion protection properties. TEKNOLAC PRIMER 0168-00 contains efficient active anticorrosive pigments.

These paint systems are designed for corrosivity categories C2 - C3 with durability classes medium - low.

Paint		B1	B2
TEKNOLAC PRIMER 0168-00	AK	1x60 µm	1x60 µm
TEKNOLAC COMBI 50	AK	1x40 µm	
TEKNOLAC 0191	AK		1x40 µm
Total film thickness		100 µm	100 µm
Paint system VOC, g/m ²		105	102

Example of Teknos paint system code	Example of paint system structure
TEC2.02/M/B1	ISO 12944-5/C2.02-AK (AK100/2-FeSa 2½).
TEC3.01/L/B2	ISO 12944-5/C3.01-AK (AK100/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.03	X	X	X	
C3.02	X	X		
C4.01	X			

TEC2.03 High
TEC3.02 Medium
TEC4.01 Low

TEKNOLAC PRIMER 0168-00 Paint systems 160 µm

1 1.8.2018

TEKNOLAC PRIMER 0168-00 paint systems consist of different kind of fast drying alkyd paints having very good corrosion protection properties. TEKNOLAC PRIMER 0168-00 contains efficient active anticorrosive pigments.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

Paint		B1	B2
TEKNOLAC PRIMER 0168-00	AK	1x100 µm	1x100 µm
TEKNOLAC COMBI 50	AK	1x60 µm	
TEKNOLAC 0191	AK		1x60 µm
Total film thickness		160 µm	160 µm
Paint system VOC, g/m ²		167	163

Example of Teknos paint system code	Example of paint system structure
TEC2.03/H/B1	ISO 12944-5/C2.03-AK (AK160/2-FeSa 2½).
TEC3.02/M/B2	ISO 12944-5/C3.02-AK (AK160/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.04	X	X	X	X
C3.03	X	X	X	
C4.02	X	X		

TEC2.04 Very high
TEC3.03 High
TEC4.02 Medium

TEKNOLAC PRIMER 0168-00 Paint systems 200 µm

1 1.8.2018

TEKNOLAC PRIMER 0168-00 paint systems consist of different kind of fast drying alkyd paints having very good corrosion protection properties. TEKNOLAC PRIMER 0168-00 contains efficient active anticorrosive pigments.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes very high - low.

Paint		B1	B2
TEKNOLAC PRIMER 0168-00	AK	2x80 µm	2x80 µm
TEKNOLAC COMBI 50	AK	1x40 µm	
TEKNOLAC 0191	AK		1x40 µm
Total film thickness		200 µm	200 µm
Paint system VOC, g/m ²		202	200

Example of Teknos paint system code	Example of paint system structure
TEC2.04/VH/B1	ISO 12944-5/C2.04-AK (AK200/3-FeSa 2½).
TEC3.03/H/B2	ISO 12944-5/C3.03-AK (AK200/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.04	X	X	X	X
C4.03	X	X	X	

TEC3.04 Very high
TEC4.03 High

TEKNOLAC PRIMER 0168-00
Paint systems 260 µm

1 1.8.2018

TEKNOLAC PRIMER 0168-00 paint systems consist of different kind of fast drying alkyd paints having very good corrosion protection properties. TEKNOLAC PRIMER 0168-00 contains efficient active anticorrosive pigments.

These paint systems are designed for corrosivity categories C3 – C4 with durability classes very high - high.

Paint		B1	B2	B3	B4
TEKNOLAC PRIMER 0168-00	AK	1x80 µm	3x70 µm	1x60 µm	1x60 µm
TEKNOLAC PRIMER 0168-00	AK	1x100 µm		2x80 µm	2x80 µm
TEKNOLAC COMBI 50	AK	1x80 µm		1x40 µm	
TEKNOLAC 0191	AK		1x50 µm		1x40 µm
Total film thickness		260 µm	260 µm	260 µm	260 µm
Paint system VOC, g/m ²		268	258	261	258

Example of Teknos paint system code	Example of paint system structure
TEC3.04/VH/B1	ISO 12944-5/C3.04-AK (AK260/3-FeSa 2½).
TEC4.03/H/B3	ISO 12944-5/C4.03-AK (AK260/4-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.05	X	X	X	
C3.05	X	X		
C4.04	X			

TEC2.05 High
TEC3.05 Medium
TEC4.04 Low

2-COMPONENT COMBI Paint systems 120 µm

1 1.8.2018

2-COMPONENT COMBI paint systems consist of different types of paint chemistries. These direct to metal one layer paint systems have excellent adhesion to steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints and fast curing polyaspartics have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

Paint		A1	A2	A3	A4	A5	A6
TEKNOPLAST HS 150	EP	1x120 µm					
TEKNOMASTIC COMBI 80-500	EP		1x120 µm				
INERTA 271	EP			1x120 µm			
TEKNODUR COMBI 3430 -series	PUR				1x120 µm		
TEKNODUR COMBI 340-811	PUR					1x120 µm	
TEKNODUR COMBI 3560 -series	PAS						1x120 µm
Total film thickness		120 µm					
Paint system VOC, g/m ²		51	29	32	69 - 90	47	8 - 72

Example of Teknos paint system code	Example of paint system structure
TEC2.05/H/A1	ISO 12944-5/C2.05-EP (EP120/1-FeSa 2½).
TEC3.05/M/A4	ISO 12944-5/C3.05-PUR (PUR120/1-FeSa 2½)
TEC4.04/L/A6	ISO 12944-5/C4.04-PAS (PAS120/1-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.06	X	X	X	X
C3.06	X	X	X	
C4.05	X	X		
C5.01	X			

TEC2.06 Very high
TEC3.06 High
TEC4.05 Medium
TEC5.01 Low

**2-COMPONENT COMBI
Paint systems 180 µm**

1 1.8.2018

2-COMPONENT COMBI paint systems consist of different types of paint chemistries. These direct to metal two layer paint systems have excellent adhesion to steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints and fast curing polyaspartics have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

Paint		A1	A2	A3	A4	A5	A6
TEKNOPLAST HS 150	EP	2x90 µm					
TEKNOMASTIC COMBI 80-500	EP		2x90 µm				
INERTA 271	EP			2x90 µm			
TEKNODUR COMBI 3430 -series	PUR				2x90 µm		
TEKNODUR COMBI 340-811	PUR					2x90 µm	
TEKNODUR COMBI 3560 -series	PAS						2x90 µm
Total film thickness		180 µm	180 µm	180 µm	180 µm	180 µm	180 µm
Paint system VOC, g/m ²		77	44	47	103 - 135	71	12 - 108

Example of Teknos paint system code	Example of paint system structure
TEC2.06/VH/A1	ISO 12944-5/C2.06-EP (EP180/2-FeSa 2½).
TEC3.06/H/A4	ISO 12944-5/C3.06-PUR (PUR180/2-FeSa 2½)
TEC4.05/M/A6	ISO 12944-5/C4.05-PAS (PAS180/2-FeSa 2½)
TEC5.01/L/A6	ISO 12944-5/C5.01-PAS (PAS180/2-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.07	X	X	X	X
C4.06	X	X	X	
C5.02	X	X		

TEC3.07 Very high
TEC4.06 High
TEC5.02 Medium

2-COMPONENT COMBI Paint systems 240 µm

1 1.8.2018

2-COMPONENT COMBI paint systems consist of different types of paint chemistries. These direct to metal two layer paint systems have excellent adhesion to steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints and fast curing polyaspartics have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		A1	A2	A3	A4	A5	A6
TEKNOPLAST HS 150	EP	2x120 µm					
TEKNOMASTIC COMBI 80-500	EP		2x120 µm				
INERTA 271	EP			2x120 µm			
TEKNODUR COMBI 3430 -series	PUR				2x120 µm		
TEKNODUR COMBI 340-811	PUR					2x120 µm	
TEKNODUR COMBI 3560 -series	PAS						2x120 µm
Total film thickness		240 µm	240 µm	240 µm	240 µm	240 µm	240 µm
Paint system VOC, g/m ²		103	59	63	138 - 180	94	16 - 144

Example of Teknos paint system code	Example of paint system structure
TEC3.07/VH/A1	ISO 12944-5/C3.07-EP (EP240/2-FeSa 2½).
TEC4.06/H/A4	ISO 12944-5/C4.06-PUR (PUR240/2-FeSa 2½)
TEC5.02/M/A6	ISO 12944-5/C5.02-PAS (PAS240/2-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C4.07	X	X	X	X
C5.03	X	X	X	

TEC4.07 Very high
TEC5.03 High

2-COMPONENT COMBI Paint systems 300 µm

1 1.8.2018

2-COMPONENT COMBI paint systems consist of different types of paint chemistries. These direct to metal two layer paint systems have excellent adhesion to steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints and fast curing polyaspartics have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

Paint		A1	A2	A3	A4	A5	A6
TEKNOPLAST HS 150	EP	2x150 µm					
TEKNOMASTIC COMBI 80-500	EP		2x150 µm				
INERTA 271	EP			2x150 µm			
TEKNODUR COMBI 340-811	PUR				3x100 µm		
TEKNODUR COMBI 3430 -series	PUR					3x100 µm	
TEKNODUR COMBI 3560 -series	PAS						2x150 µm
Total film thickness		300 µm	300 µm				
Paint system VOC, g/m ²		129	73	79	118	172 - 225	20 - 180

Example of Teknos paint system code	Example of paint system structure
TEC4.07/VH/A1	ISO 12944-5/C4.07-EP (EP300/2-FeSa 2½).
TEC5.03/H/A4	ISO 12944-5/C5.03-PUR (PUR300/3-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C5.04	X	X	X	X

TEC5.04 Very high

2-COMPONENT COMBI Paint systems 360 µm

1 1.8.2018

2-COMPONENT COMBI paint systems consist of different types of paint chemistries. These direct to metal three layer paint systems have excellent adhesion to steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints and fast curing polyaspartics have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

Paint		A1	A2	A3	A4	A5	A6
TEKNOPLAST HS 150	EP	3x120 µm					
TEKNOMASTIC COMBI 80-500	EP		3x120 µm				
INERTA 271	EP			3x120 µm			
TEKNODUR COMBI 340-811	PUR				3x120 µm		
TEKNODUR COMBI 3430 -series	PUR					3x120 µm	
TEKNODUR COMBI 3560 -series	PAS						3x120 µm
Total film thickness		360 µm	360 µm				
Paint system VOC, g/m ²		154	88	95	141	207 - 270	24 - 216

Example of Teknos paint system code	Example of paint system structure
TEC5.04/VH/A1	ISO 12944-5/C5.04-EP (EP360/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.07	X	X	X	
C3.08	X	X		
C4.08	X			

TEC2.07 High
TEC3.08 Medium
TEC4.08 Low

ZINC RICH Paint systems 60 µm

1 1.8.2018

TEKNOZINC zinc rich paint systems consist of zinc rich paints, in which the zinc content is at least 80% by weight in a dry paint film.

Paints containing zinc give steel a very good protection against corrosion. Below mentioned zinc rich paint systems can be used in corrosivity categories C2 – C4 with durability classes high - low.

Paint		A1	A2	A3	A4
TEKNOZINC 80 SE	EP	1x60 µm			
TEKNOZINC 3480 SE	EP		1x60 µm		
TEKNOZINC SS	ESI			1x60 µm	
TEKNOZINC SS 1K	ESI				1x60 µm
Total film thickness		60 µm	60 µm	60 µm	60 µm
Paint system VOC, g/m ²		54	27	59	60

Example of Teknos paint system code	Example of paint system structure
TEC2.07/H/A1	ISO 12944-5/C2.0-EPZn(R) (EPZn(R)60/1-FeSa 2½).
TEC3.08/M/A3	ISO 12944-5/C3.08-ESIZn(R) (ESIZn(R)60/1-FeSa 2½)
TEC4.08/L/A4	ISO 12944-5/C4.08-ESIZn(R) (ESIZn(R)60/1-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.08	X	X	X	X
C3.09	X	X	X	
C4.09	X	X		
C5.05	X			

TEC2.08 Very high
TEC3.09 High
TEC4.09 Medium
TEC5.05 Low

TEKNOZINC 80 SE, High Solid TOP COATS
Paint systems 160 µm

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems containing zinc rich TEKNOZINC 80 SE primer give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy, polyurethane or fast curing polyaspartic chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

Paint		EP- top coat	PUR- top coat		PAS- top coat
		A1	A2	A3	A4
TEKNOZINC 80 SE	EP	1x60 µm	1x60 µm	1x60 µm	1x60 µm
TEKNOPLAST HS 150	EP	1x100 µm			
TEKNODUR COMBI 3430 -series	PUR		1x100 µm		
TEKNODUR COMBI 340-811	PUR			1x100 µm	
TEKNODUR COMBI 3560 -series	PAS				1x100 µm
Total film thickness		160 µm	160 µm	160 µm	160 µm
Paint system VOC, g/m ²		97	111 - 129	93	60 - 114

Example of Teknos paint system code	Example of paint system structure
TEC2.08/VH/A1	12944-5/C2.08-EPZn(R)/EP (EPZn(R)EP160/2-FeSa 2½).
TEC3.09/H/A2	12944-5/C3.09-EPZn(R)/PUR (EPZn(R)PUR160/2-FeSa 2½)
TEC4.09/M/A3	12944-5/C4.09-EPZn(R)/PUR (EPZn(R)PUR160/2-FeSa 2½)
TEC5.05/L/A4	12944-5/C5.05-EPZn(R)/PAS (EPZn(R)PAS160/2-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.10	X	X	X	X
C4.10	X	X	X	
C5.06	X	X		

TEC3.10 Very high
TEC4.10 High
TEC5.06 Medium

TEKNOZINC 80 SE, High Solid TOP COATS Paint systems 200 µm

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems containing zinc rich TEKNOZINC 80 SE primer give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy, polyurethane or fast curing polyaspartic chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		EP- top coat	PUR- top coat		PAS- top coat
		A1	A2	A3	A4
TEKNOZINC 80 SE	EP	1x60 µm	1x60 µm	1x60 µm	1x60 µm
TEKNOPLAST HS 150	EP	1x140 µm			
TEKNODUR COMBI 3430 -series	PUR		2x70 µm		
TEKNODUR COMBI 340-811	PUR			1x140 µm	
TEKNODUR COMBI 3560 -series	PAS				1x140 µm
Total film thickness		200 µm	200 µm	200 µm	200 µm
Paint system VOC, g/m ²		114	134 - 159	109	63 - 138

Example of Teknos paint system code	Example of paint system structure
TEC3.10/VH/A1	ISO 12944-5/C3.10-EPZn(R)/EP (EPZn(R)EP200/2-FeSa 2½)
TEC4.10/H/A2	ISO 12944-5/C4.10-EPZn(R)/PUR (EPZn(R)PUR200/3-FeSa 2½)
TEC5.06/M/A4	ISO 12944-5/C5.06-EPZn(R)/PAS (EPZn(R)PAS200/2-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C4.11	X	X	X	X
C5.07	X	X	X	

TEC4.11 Very high
TEC5.07 High

TEKNOZINC 80 SE, High Solid TOP COATS

Paint systems 260 µm

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems containing zinc rich TEKNOZINC 80 SE primer give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy, polyurethane or fast curing polyaspartic chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

Paint		EP- top coat	PUR- top coat		PAS- top coat
		A1	A2	A3	A4
TEKNOZINC 80 SE	EP	1x60 µm	1x60 µm	1x60 µm	1x60 µm
TEKNOPLAST HS 150	EP	2x100 µm			
TEKNODUR COMBI 3430 -series	PUR		2x100 µm		
TEKNODUR COMBI 340-811	PUR			2x100 µm	
TEKNODUR COMBI 3560 -series	PAS				2x100 µm
Total film thickness		260 µm	260 µm	260 µm	260 µm
Paint system VOC, g/m ²		140	169 - 204	133	67 - 174

Example of Teknos paint system code	Example of paint system structure
TEC4.11/VH/A1	ISO 12944-5/C4.11-EPZn(R)/EP (EPZn(R)EP260/3-FeSa 2½)
TEC5.07/H/A4	ISO 12944-5/C5.07-EPZn(R)/PAS (EPZn(R)PAS260/3-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C5.08	X	X	X	X

TEC5.08 Very high

TEKNOZINC 80 SE, High Solid TOP COATS Paint systems 320 µm

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems containing zinc rich TEKNOZINC 80 SE primer give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy, polyurethane or fast curing polyaspartic chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

Paint		EP- top coat	PUR- top coat		PAS- top coat
		A1	A2	A3	A4
TEKNOZINC 80 SE	EP	1x60 µm	1x60 µm	1x60 µm	1x60 µm
TEKNOPLAST HS 150	EP	2x130 µm			
TEKNODUR COMBI 3430 -series	PUR		1x80 µm		
TEKNODUR COMBI 3430 -series	PUR		2x90 µm		
TEKNODUR COMBI 340-811	PUR			2x130 µm	
TEKNODUR COMBI 3560 -series	PAS				2x130 µm
Total film thickness		320 µm	320 µm	320 µm	320 µm
Paint system VOC, g/m ²		165	203 - 249	156	71 - 210

Example of Teknos paint system code	Example of paint system structure
TEC5.08/VH/A1	ISO 12944-5/C5.08-EPZn(R)/EP (EPZn(R)EP320/3-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

Im

Paint system ISO 12944-5	Low	Medium	High	Very high
I.01	X	X	X	

TEI.01 High

TEKNOZINC 80 SE and TEKNOZINC 3480 SE, IMMERSION Paint systems 360 µm

1 1.8.2018

TEKNOZINC 80 SE and TEKNOZINC 3480 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film. Top coats are based on epoxy chemistry.

Below mentioned zinc rich paint systems are designed for carbon steel for immersion categories Im 1, Im 2 and Im 3.

Paint		A1	A2	A3
TEKNOZINC 80 SE	EP	1x60 µm	1x60 µm	
TEKNOZINC 3480 SE	EP			1x60 µm
TEKNOPLAST HS 150	EP	2x150 µm		2x150 µm
TEKNOMASTIC COMBI 80-500	EP		2x150 µm	
Total film thickness		360 µm	360 µm	360 µm
Paint system VOC, g/m ²		182	73	155

Example of Teknos paint system code	Example of paint system structure
TEI.01/H/A1	ISO 12944-5/I.01-EPZn(R)/EP (EPZn(R)EP360/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

Im

Paint system ISO 12944-5	Low	Medium	High	Very high
I.02	X	X	X	X

TEI.02 Very high

TEKNOZINC 80 SE and TEKNOZINC 3480 SE, IMMERSION Paint systems 500 µm

1 1.8.2018

TEKNOZINC 80 SE and TEKNOZINC 3480 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film. Top coats are based on epoxy chemistry.

Below mentioned zinc rich paint systems are designed for carbon steel for immersion categories Im 1, Im 2 and Im 3.

Paint		A1	A2	A3	A4	A5	A6
TEKNOZINC 80 SE	EP	1x60 µm	1x60 µm	1x60 µm			
TEKNOZINC 3480 SE	EP				1x60 µm	1x80 µm	1x80 µm
TEKNOPLAST HS 150	EP	1x120 µm			1x120 µm		
TEKNOPLAST HS 150	EP	2x160 µm			2x160 µm		
TEKNOMASTIC 80 PRIMER	EP		2x220 µm			2x210 µm	
TEKNOMASTIC COMBI 80-500	EP			2x220 µm			2x210 µm
Total film thickness		500 µm					
Paint system VOC, g/m ²		242	161	161	215	139	139

Example of Teknos paint system code	Example of paint system structure
TEI.02/VH/A3	ISO 12944-5/I.02-EPZn(R)/EP (EPZn(R)EP500/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

Im

Paint system ISO 12944-5	Low	Medium	High	Very high
I.03	X	X	X	

TEI.03 High

TEKNOMASTIC 80 PRIMER, IMMERSION Paint systems 380 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems for carbon steel for immersion categories Im 1, Im 2 and Im 3 are described in the table below.

Paint systems are designed so that a high solids TEKNOMASTIC 80 PRIMER is used as primer and a high solids or solvent-free epoxy coating is used as a topcoat. The topcoat epoxy is chosen according to the technical needs. The expected durability class for these paint systems is high.

Paint		A1	A2	A3	A4	A5
TEKNOMASTIC 80 PRIMER	EP	1x80 µm				
TEKNOMASTIC 80 PRIMER	EP	2x150 µm				
INERTA 165	EP		1x300 µm			
INERTA 270	EP			2x150 µm		
INERTA 280	EP				1x300 µm	
TEKNOMASTIC COMBI 80-500	EP					2x150 µm
Total film thickness		380 µm				
Paint system VOC, g/m ²		92	52	99	35	92

Example of Teknos paint system code	Example of paint system structure
TEI.03/H/A1	ISO 12944-5/I.03-EP (EP380/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

Im

Paint system ISO 12944-5	Low	Medium	High	Very high
I.04	X	X	X	X

TEI.04 Very high

TEKNOMASTIC 80 PRIMER, IMMERSION Paint systems 540 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems for carbon steel for immersion categories Im 1, Im 2 and Im 3 are described in the table below.

Paint systems are designed so that a high solids TEKNOMASTIC 80 PRIMER is used as primer and a high solids or solvent-free epoxy coating is used as a topcoat. The topcoat epoxy is chosen according to the technical needs. The expected durability class for these paint systems is very high.

Paint		A1	A2	A3	A4	A5
TEKNOMASTIC 80 PRIMER	EP	1x80 µm				
TEKNOMASTIC 80 PRIMER	EP	2x230 µm				
INERTA 165	EP		2x230 µm			
INERTA 270	EP			2x230 µm		
INERTA 280	EP				1x460 µm	
TEKNOMASTIC COMBI 80-500	EP					2x230 µm
Total film thickness		540 µm				
Paint system VOC, g/m ²		131	69	142	43	131

Example of Teknos paint system code	Example of paint system structure
TEI.04/VH/A1	ISO 12944-5/I.04-EP (EP540/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

Im

Paint system ISO 12944-5	Low	Medium	High	Very high
I.05	X	X	X	

TEI.05 High

EPOXY COATINGS FOR IMMERSION Paint systems 400 µm

1 1.8.2018

These paint systems for immersion use consist of high solids or almost solvent-free epoxy coatings for durability class high. The suitable paint is chosen according to the technical needs.

The paint systems are designed for carbon steel for immersion categories Im 1, Im 2 and Im 3.

Paint		A1	A2	A3	A4	A5
INERTA 160	EP	1x400 µm				
INERTA 165	EP		1x400 µm			
INERTA 280	EP			1x400 µm		
INERTA 270	EP				2x200 µm	
TEKNOMASTIC 80 PRIMER	EP					2x200 µm
Total film thickness		400 µm				
Paint system VOC, g/m ²		17	43	21	106	97

Example of Teknos paint system code	Example of paint system structure
TEI.05/H/A1	ISO 12944-5/I.05-EP (EP400/1-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

Im

Paint system ISO 12944-5	Low	Medium	High	Very high
I.06	X	X	X	X

TEI.06 Very high

**EPOXY COATINGS FOR IMMERSION
Paint systems 600 µm**

1 1.8.2018

These paint systems for immersion use consist of high solids or almost solvent-free epoxy coatings for durability class high. The suitable paint is chosen according to the technical needs.

The paint systems are designed for carbon steel for immersion categories Im 1, Im 2 and Im 3.

Paint		A1	A2	A3	A4
INERTA 160	EP	1x600 µm			
INERTA 165	EP		2x300 µm		
INERTA 280	EP			1x600 µm	
INERTA 160 FILL	EP				1x600 µm
Total film thickness		600 µm	600 µm	600 µm	600 µm
Paint system VOC, g/m ²		25	65	31	25

Example of Teknos paint system code	Example of paint system structure
TEI.06/VH/A1	ISO 12944-5/I.06-EP (EP600/1-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.01	X			

TEC2.01 Low

TEKNOSYNT PRIMER 3 Paint systems 80 µm

1 1.8.2018

TEKNOSYNT PRIMER 3 paint systems consist of white spirit containing thixotropic paints, that contain active anticorrosive pigments.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity category C2 with durability class low.

Paint		D1	D2
TEKNOSYNT PRIMER 3	AK	1x40 µm	1x40 µm
TEKNOSYNT COMBI 50	AK	1x40 µm	
TEKNOSYNT 90	AK		1x40 µm
Total film thickness		80 µm	80 µm
Paint system VOC, g/m ²		74	84

Example of Teknos paint system code	Example of paint system structure
TEC2.01/L/D1	ISO 12944-5/C2.01-AK (AK80/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.02	X	X		
C3.01	X			

TEC2.02 Medium
TEC3.01 Low

TEKNOSYNT PRIMER 3
Paint systems 100 µm

1 1.8.2018

TEKNOSYNT PRIMER 3 paint systems consist of white spirit containing thixotropic paints, that contain active anticorrosive pigments.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 – C3 with durability classes medium - low.

Paint		D1	D2
TEKNOSYNT PRIMER 3	AK	1x60 µm	1x60 µm
TEKNOSYNT COMBI 50	AK	1x40 µm	
TEKNOSYNT 90	AK		1x40 µm
Total film thickness		100 µm	100 µm
Paint system VOC, g/m ²		95	106

Example of Teknos paint system code	Example of paint system structure
TEC2.02/M/D1	ISO 12944-5/C2.02-AK (AK100/2-FeSa 2½).
TEC3.01/L/D2	ISO 12944-5/C3.01-AK (AK100/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.03	X	X	X	
C3.02	X	X		
C4.01	X			

TEC2.03 High
TEC3.02 Medium
TEC4.01 Low

TEKNOSYNT PRIMER 3

Paint systems 160 µm

1 1.8.2018

TEKNOSYNT PRIMER 3 paint systems consist of white spirit containing thixotropic paints, that contain active anticorrosive pigments.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

Paint		D1	D2
TEKNOSYNT PRIMER 3	AK	1x100 µm	1x100 µm
TEKNOSYNT COMBI 50	AK	1x60 µm	
TEKNOSYNT 90	AK		1x60 µm
Total film thickness		160 µm	160 µm
Paint system VOC, g/m ²		155	170

Example of Teknos paint system code	Example of paint system structure
TEC2.03/H/D1	ISO 12944-5/C2.03-AK (AK160/2-FeSa 2½).
TEC3.02/M/D2	ISO 12944-5/C3.02-AK (AK160/2-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.04	X	X	X	X
C3.03	X	X	X	
C4.02	X	X		

TEC2.04 Very high
TEC3.03 High
TEC4.02 Medium

TEKNOSYNT PRIMER 3 Paint systems 200 µm

1 1.8.2018

TEKNOSYNT PRIMER 3 paint systems consist of white spirit containing thixotropic paints, that contain active anticorrosive pigments.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes very high - medium.

Paint		D1	D2
TEKNOSYNT PRIMER 3	AK	2x80 µm	2x80 µm
TEKNOSYNT COMBI 50	AK	1x40 µm	
TEKNOSYNT 90	AK		1x40 µm
Total film thickness		200 µm	200 µm
Paint system VOC, g/m ²		202	212

Example of Teknos paint system code	Example of paint system structure
TEC2.04/VH/D1	ISO 12944-5/C2.04-AK (AK200/3-FeSa 2½).
TEC3.03/H/D2	ISO 12944-5/C3.03-AK (AK200/3-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.04	X	X	X	X
C4.03	X	X	X	

TEC3.04 Very high
TEC4.03 High

TEKNOSYNT PRIMER 3 Paint systems 260 µm

1 1.8.2018

TEKNOSYNT PRIMER 3 paint systems consist of white spirit containing thixotropic paints, that contain active anticorrosive pigments.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C3 – C4 with durability classes very high - medium.

Paint		D1	D2
TEKNOSYNT PRIMER 3	AK	1x70 µm	1x80 µm
TEKNOSYNT PRIMER 3	AK	2x70 µm	2x60 µm
TEKNOSYNT COMBI 50	AK	1x50 µm	
TEKNOSYNT 90	AK		1x60 µm
Total film thickness		260 µm	260 µm
Paint system VOC, g/m ²		263	276

Example of Teknos paint system code	Example of paint system structure
TEC3.04/VH/D1	ISO 12944-5/C3.04-AK (AK260/4-FeSa 2½)
TEC4.03/H/D2	ISO 12944-5/C4.03-AK (AK260/4-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.05	X	X	X	
C3.05	X	X		
C4.04	X			

TEC2.05 High
TEC3.05 Medium
TEC4.04 Low

TEKNOPLAST PRIMER 3 / 5 Paint systems 120 µm

1 1.8.2018

TEKNOPLAST PRIMER 3 / 5 paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties. TEKNOPOX PRIMER 4 can also be used as a primer in these paint systems instead of TEKNOPLAST PRIMER 3 or 5.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid polyurethane top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

Paint		EP-	PUR-			
		top coat	top coat			
		B1	B2	B3	B4	B5
TEKNOPLAST PRIMER 3 / 5	EP	1x80 µm	1x80 µm	1x60 µm	1x60 µm	1x60 µm
TEKNOPLAST 50 / 90	EP	1x40 µm				
TEKNODUR 0050 / 0090	PUR		1x40 µm			
TEKNODUR 3410-series	PUR			1x60 µm		
TEKNODUR COMBI 3430-series	PUR				1x60 µm	
TEKNODUR COMBI 340-811	PUR					1x60 µm
Total film thickness		120 µm	120 µm	120 µm	120 µm	120 µm
Paint system VOC, g/m ²		98	97 / 103	81 - 88	84 - 95	73

Example of Teknos paint system code	Example of paint system structure
TEC2.05/H/B1	ISO 12944-5/C2.05-EP (EP120/2-FeSa 2½).
TEC3.05/M/B4	ISO 12944-5/C3.05-EP/PUR (EPPUR120/2-FeSa 2½).
TEC4.04/L/B5	ISO 12944-5/C4.04-EP/PUR (EPPUR120/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.06	X	X	X	X
C3.06	X	X	X	
C4.05	X	X		
C5.01	X			

TEC2.06 Very high
TEC3.06 High
TEC4.05 Medium
TEC5.01 Low

TEKNOPLAST PRIMER 3 / 5
Paint systems 180 µm

1 1.8.2018

TEKNOPLAST PRIMER 3 / 5 paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties. TEKNOPOX PRIMER 4 can also be used as a primer in these paint systems instead of TEKNOPLAST PRIMER 3 or 5.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing aspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

Paint		EP- top coat		PUR- top coat				PAS- top coat
		B1	B2	B3	B4	B5	B6	B7
TEKNOPLAST PRIMER 3 / 5	EP	1x100 µm	1x120 µm	2x70 µm	1x100 µm	1x100 µm	1x100 µm	1x100 µm
TEKNOPLAST HS 150	EP	1x80 µm						
TEKNOPLAST 50 / 90	EP		1x60 µm					
TEKNODUR 0050 / 0090	PUR			1x40 µm				
TEKNODUR 3410-series	PUR				1x80 µm			
TEKNODUR COMBI 3430-series	PUR					1x80 µm		
TEKNODUR COMBI 340-811	PUR						1x80 µm	
TEKNODUR COMBI 3560-series	PAS							1x80 µm
Total film thickness		180 µm	180 µm	180 µm	180 µm	180 µm	180 µm	180 µm
Paint system VOC, g/m ²		118	148	147 / 153	126 - 135	130 - 144	115	89 - 132

Example of Teknos paint system code	Example of paint system structure
TEC2.06/VH/B1	ISO 12944-5/C2.06-EP (EP180/2-FeSa 2½).
TEC3.06/H/B3	ISO 12944-5/C3.06-EP/PUR (EPPUR180/3-FeSa 2½).
TEC4.05/M/B4	ISO 12944-5/C4.05-EP/PUR (EPPUR180/2-FeSa 2½).
TEC5.01/L/B7	ISO 12944-5/C5.01-EP/PAS (EPPAS180/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.07	X	X	X	X
C4.06	X	X	X	
C5.02	X	X		

TEC3.07 Very high
TEC4.06 High
TEC5.02 Medium

TEKNOPLAST PRIMER 3 / 5
Paint systems 240 µm

1 1.8.2018

TEKNOPLAST PRIMER 3 / 5 paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties. TEKNOPOX PRIMER 4 can also be used as a primer in these paint systems instead of TEKNOPLAST PRIMER 3 or 5.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing aspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		EP-top coat		PUR-top coat				PAS-top coat
		B1	B2	B3	B4	B5	B6	B7
TEKNOPLAST PRIMER 3 / 5	EP	2x80 µm	2x100 µm	2x100 µm	2x90 µm	2x80 µm	2x80 µm	2x80 µm
TEKNOPLAST HS 150	EP	1x80 µm						
TEKNOPLAST 50 / 90	EP		1x40 µm					
TEKNODUR 0050 / 0090	PUR			1x40 µm				
TEKNODUR 3410-series	PUR				1x60 µm			
TEKNODUR COMBI 3430-series	PUR					1x80 µm		
TEKNODUR COMBI 340-811	PUR						1x80 µm	
TEKNODUR COMBI 3560-series	PAS							1x80 µm
Total film thickness		240 µm	240 µm	240 µm	240 µm	240 µm	240 µm	240 µm
Paint system VOC, g/m ²		166	200	198 / 204	181 - 188	179 - 193	165	138 - 181

Example of Teknos paint system code	Example of paint system structure
TEC3.07/VH/B1	ISO 12944-5/C3.07-EP (EP240/3-FeSa 2½).
TEC4.06/H/B3	ISO 12944-5/C4.06-EP/PUR (EPPUR240/3-FeSa 2½).
TEC5.02/M/B7	ISO 12944-5/C5.02-EP/PAS (EPPAS240/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C4.07	X	X	X	X
C5.03	X	X	X	

TEC4.07 Very high
TEC5.03 High

TEKNOPLAST PRIMER 3 / 5

Paint systems 300 µm

1 1.8.2018

TEKNOPLAST PRIMER 3 / 5 paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties. TEKNOPOX PRIMER 4 can also be used as a primer in these paint systems instead of TEKNOPLAST PRIMER 3 or 5.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing aspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

Paint		EP-top coat		PUR-top coat				PAS-top coat
		B1	B2	B3	B4	B5	B6	B7
TEKNOPLAST PRIMER 3 / 5	EP	2x100 µm	2x120 µm	1x100 µm	2x120 µm	2x100 µm	2x100 µm	2x100 µm
TEKNOPLAST HS 150	EP	1x100 µm						
TEKNOPLAST PRIMER 3 / 5	EP			2x80 µm				
TEKNOPLAST 50 / 90	EP		1x60 µm					
TEKNODUR 0050 / 0090	PUR			1x40 µm				
TEKNODUR 3410-series	PUR				1x60 µm			
TEKNODUR COMBI 3430-series	PUR					1x100 µm		
TEKNODUR COMBI 340-811	PUR						1x100 µm	
TEKNODUR COMBI 3560-series	PAS							1x100 µm
Total film thickness		300 µm	300 µm	300 µm	300 µm	300 µm	300 µm	300 µm
Paint system VOC, g/m ²		210	247	247 / 254	230 - 237	224 - 242	206	173 - 227

Example of Teknos paint system code	Example of paint system structure
TEC4.07/VH/B1	ISO 12944-5/C4.07-EP (EP300/3-FeSa 2½).
TEC5.03/H/B7	ISO 12944-5/C5.03-EP/PAS (EPPAS300/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C5.04	X	X	X	X

TEC5.04 Very high

TEKNOPLAST PRIMER 3 / 5

Paint systems 360 µm

1 1.8.2018

TEKNOPLAST PRIMER 3 / 5 paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties. TEKNOPOX PRIMER 4 can also be used as a primer in these paint systems instead of TEKNOPLAST PRIMER 3 or 5.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing aspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

Paint		EP- top coat		PUR- top coat				PAS- top coat
		B1	B2	B3	B4	B5	B6	B7
TEKNOPLAST PRIMER 3 / 5	EP	2x120 µm	3x100 µm	1x100 µm	1x100 µm	1x100 µm	1x100 µm	1x100 µm
TEKNOPLAST HS 150	EP	1x120 µm						
TEKNOPLAST PRIMER 3 / 5	EP			2x110 µm	2x80 µm	2x80 µm	2x80 µm	2x80 µm
TEKNOPLAST 50 / 90	EP		1x60 µm					
TEKNODUR 0050 / 0090	PUR			1x40 µm				
TEKNODUR 3410-series	PUR				1x100 µm			
TEKNODUR COMBI 3430-series	PUR					1x100 µm		
TEKNODUR COMBI 340-811	PUR						1x100 µm	
TEKNODUR COMBI 3560-series	PAS							1x100 µm
Total film thickness		360 µm	360 µm	360 µm	360 µm	360 µm	360 µm	360 µm
Paint system VOC, g/m ²		249	299	297 / 303	269 - 278	273 - 291	255	222 - 276

Example of Teknos paint system code	Example of paint system structure
TEC5.04/VH/B3	ISO 12944-5/C5.04-EP/PUR (EPPUR360/4-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.08	X	X	X	X
C3.09	X	X	X	
C4.09	X	X		
C5.05	X			

TEC2.08 Very high
TEC3.09 High
TEC4.09 Medium
TEC5.05 Low

TEKNOZINC 3480 SE, High Solid TOP COATS Paint systems 160 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of high-solid zinc rich epoxy primer, which can be applied with film thicknesses between 60–80 µm.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

		EP- top coat	PUR- top coat
Paint		B1	B2
TEKNOZINC 3480 SE	EP	1x60 µm	1x60 µm
TEKNOPLAST HS 150	EP	1x100 µm	
TEKNODUR COMBI 3430-series	PUR		1x100 µm
Total film thickness		160 µm	160 µm
Paint system VOC, g/m ²		70	84 – 102

Example of Teknos paint system code	Example of paint system structure
TEC2.08/VH/B1	ISO 12944-5/C2.08-EPZn(R)/EP (EPZn(R)EP160/2-FeSa 2½).
TEC3.09/H/B2	ISO 12944-5/C3.09-EPZn(R)/PUR (EPZn(R)PUR160/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.10	X	X	X	X
C4.10	X	X	X	
C5.06	X	X		

TEC3.10 Very high
TEC4.10 High
TEC5.06 Medium

TEKNOZINC 3480 SE, High Solid TOP COATS Paint systems 200 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of high-solid zinc rich epoxy primer, which can be applied with film thicknesses between 60–80 µm.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

		EP- top coat	PUR- top coat
Paint		B1	B2
TEKNOZINC 3480 SE	EP	1x80 µm	1x80 µm
TEKNOPLAST HS 150	EP	1x120 µm	
TEKNODUR COMBI 3430-series	PUR		1x120 µm
Total film thickness		200 µm	200 µm
Paint system VOC, g/m ²		88	105 - 126

Example of Teknos paint system code	Example of paint system structure
TEC3.10/VH/B1	ISO 12944-5/C3.10-EPZn(R)/EP (EPZn(R)EP200/2-FeSa 2½).
TEC4.10/H/B2	ISO 12944-5/C4.10-EPZn(R)/PUR (EPZn(R)PUR200/2-FeSa 2½).
TEC5.06/M/B1	ISO 12944-5/C5.06-EPZn(R)/EP (EPZn(R)EP200/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C4.11	X	X	X	X
C5.07	X	X	X	

TEC4.11 Very high
TEC5.07 High

TEKNOZINC 3480 SE, High Solid TOP COATS

Paint systems 260 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of high-solid zinc rich epoxy primer, which can be applied with film thicknesses between 60–80 µm.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

		EP- top coat	PUR- top coat
Paint		B1	B2
TEKNOZINC 3480 SE	EP	1x60 µm	1x60 µm
TEKNOPLAST HS 150	EP	2x100 µm	
TEKNODUR COMBI 3430-series	PUR		2x100 µm
Total film thickness		260 µm	260 µm
Paint system VOC, g/m ²		113	79 – 94

Example of Teknos paint system code	Example of paint system structure
TEC4.11/VH/B1	ISO 12944-5/C4.10-EPZn(R)/EP (EPZn(R)EP260/3-FeSa 2½).
TEC5.07/H/B2	ISO 12944-5/C5.07-EPZn(R)/PUR (EPZn(R)PUR260/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C5.08	X	X	X	X

TEC5.08 Very high

TEKNOZINC 3480 SE, High Solid TOP COATS Paint systems 320 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of high-solid zinc rich epoxy primer, which can be applied with film thicknesses between 60–80 µm.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

		EP- top coat	PUR- top coat
Paint		B1	B2
TEKNOZINC 3480 SE	EP	1x60 µm	1x60 µm
TEKNOPLAST HS 150	EP	2x130 µm	
TEKNODUR COMBI 3430-series	PUR		2x130 µm
Total film thickness		320 µm	320 µm
Paint system VOC, g/m ²		138	102 - 124

Example of Teknos paint system code	Example of paint system structure
TEC5.08/VH/B1	ISO 12944-5/C5.08-EPZn(R)/EP (EPZn(R)EP320/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.01	X			

TEC2.01 Low

TEKNOCRYL PRIMER 3-11 Paint systems 80 µm

1 1.8.2018

TEKNOCRYL PRIMER 3-11 paint system is an acrylic based physically drying paint system with good adhesion to the substrate and good corrosion protection properties.

These paint systems are designed for corrosivity category C2 with durability class low.

Paint		E1
TEKNOCRYL PRIMER 3-11	AY	1x40 µm
TEKNOCRYL 100-500	AY	1x40 µm
Total film thickness		80 µm
Paint system VOC, g/m ²		78

Example of Teknos paint system code	Example of paint system structure
TEC2.01/L/E1	ISO 12944-5/C2.01-AY (AY80/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.02	X	X		
C3.01	X			

TEC2.02 Medium
TEC3.01 Low

TEKNOCRYL PRIMER 3-11

Paint systems 100 µm

1 1.8.2018

TEKNOCRYL PRIMER 3-11 paint system is an acrylic based physically drying paint system with good adhesion to the substrate and good corrosion protection properties.

These paint systems are designed for corrosivity categories C2 – C3 with durability classes medium - low.

Paint		E1
TEKNOCRYL PRIMER 3-11	AY	1x60 µm
TEKNOCRYL 100-500	AY	1x40 µm
Total film thickness		100 µm
Paint system VOC, g/m ²		96

Example of Teknos paint system code	Example of paint system structure
TEC2.02/M/E1	ISO 12944-5/C2.02-AY (AY100/2-FeSa 2½).
TEC3.01/L/E1	ISO 12944-5/C3.01-AY (AY100/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.04	X	X	X	X
C3.03	X	X	X	
C4.02	X	X		

TEC2.04 Very high
TEC3.03 High
TEC4.02 Medium

TEKNOCRYL PRIMER 3-11 Paint systems 200 µm

1 1.8.2018

TEKNOCRYL PRIMER 3-11 paint system is an acrylic based physically drying paint system with good adhesion to the substrate and good corrosion protection properties.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes very high - medium.

Paint		E1
TEKNOCRYL PRIMER 3-11	AY	2x80 µm
TEKNOCRYL 100-500	AY	1x40 µm
Total film thickness		200 µm
Paint system VOC, g/m ²		181

Example of Teknos paint system code	Example of paint system structure
TEC2.04/VH/E1	ISO 12944-5/C2.04-AY (AY200/3-FeSa 2½).
TEC3.03/H/E1	ISO 12944-5/C3.03-AY (AY200/3-FeSa 2½).
TEC4.02/M/E1	ISO 12944-5/C4.02-AY (AY200/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.04	X	X	X	X
C4.03	X	X	X	

TEC3.04 Very high
TEC4.03 High

TEKNOCRYL PRIMER 3-11

Paint systems 260 µm

1 1.8.2018

TEKNOCRYL PRIMER 3-11 paint system is an acrylic based physically drying paint system with good adhesion to the substrate and good corrosion protection properties.

These paint systems are designed for corrosivity categories C3 – C4 with durability classes very high – high.

Paint		E1
TEKNOCRYL PRIMER 3-11	AY	1x60 µm
TEKNOCRYL PRIMER 3-11	AY	2x80 µm
TEKNOCRYL 100-500	AY	1x40 µm
Total film thickness		260 µm
Paint system VOC, g/m ²		233

Example of Teknos paint system code	Example of paint system structure
TEC3.04/VH/E1	ISO 12944-5/C3.04-AY (AY260/4-FeSa 2½).
TEC4.03/H/E1	ISO 12944-5/C4.03-AY (AY260/4-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.05	X	X	X	
C3.05	X	X		
C4.04	X			

TEC2.05 High
TEC3.05 Medium
TEC4.04 Low

TEKNOPLAST PRIMER 7

Paint systems 120 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems consist of an high-solid epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid polyurethane top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

Paint		EP- top coat	PUR- top coat	
		D1	D2	D3
TEKNOPLAST PRIMER 7	EP	1x80 µm	1x80 µm	1x80 µm
TEKNOPLAST 50 / 90	EP	1x40 µm		
TEKNODUR 0050 / 0090	PUR		1x40 µm	
TEKNODUR 3410-series	PUR			1x40 µm
Total film thickness		120 µm	120 µm	120 µm
Paint system VOC, g/m ²		66	65 / 71	55 - 59

Example of Teknos paint system code	Example of paint system structure
TEC2.05/H/D1	ISO 12944-5/C2.05-EP (EP120/2-FeSa 2½).
TEC3.05/M/D2	ISO 12944-5/C3.05-EP/PUR (EPPUR120/2-FeSa 2½).
TEC4.04/L/D3	ISO 12944-5/C4.04-EP/PUR (EPPUR120/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.06	X	X	X	X
C3.06	X	X	X	
C4.05	X	X		
C5.01	X			

TEC2.06 Very high
TEC3.06 High
TEC4.05 Medium
TEC5.01 Low

TEKNOPLAST PRIMER 7
Paint systems 180 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems consist of an high-solid epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

Paint		EP- top coat		PUR- top coat				PAS- top coat
		D1	D2	D3	D4	D5	D6	D7
TEKNOPLAST PRIMER 7	EP	1x100 µm	1x140 µm	1x140 µm	1x100 µm	1x100 µm	1x100 µm	1x100 µm
TEKNOPLAST HS 150	EP	1x80 µm						
TEKNOPLAST 50 / 90	EP		1x40 µm					
TEKNODUR 0050 / 0090	PUR			1x40 µm				
TEKNODUR 3410-series	PUR				1x80 µm			
TEKNODUR COMBI 3430-series	PUR					1x80 µm		
TEKNODUR COMBI 340-811	PUR						1x80 µm	
TEKNODUR COMBI 3560-series	PAS							1x80 µm
Total film thickness		180 µm	180 µm	180 µm	180 µm	180 µm	180 µm	180 µm
Paint system VOC, g/m ²		77	92	91 - 97	85 - 94	89 - 103	74	48 - 91

Example of Teknos paint system code	Example of paint system structure
TEC2.06/VH/D1	ISO 12944-5/C2.06-EP (EP180/2-FeSa 2½).
TEC3.06/H/D3	ISO 12944-5/C3.06-EP/PUR (EPPUR180/2-FeSa 2½).
TEC4.05/M/D4	ISO 12944-5/C4.05-EP/PUR (EPPUR180/2-FeSa 2½).
TEC5.01/L/D7	ISO 12944-5/C5.01-EP/PAS (EPPAS180/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.07	X	X	X	X
C4.06	X	X	X	
C5.02	X	X		

TEC3.07 Very high
TEC4.06 High
TEC5.02 Medium

TEKNOPLAST PRIMER 7
Paint systems 240 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems consist of an high-solid epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		EP-top coat		PUR-top coat				PAS-top coat
		D1	D2	D3	D4	D5	D6	D7
TEKNOPLAST PRIMER 7	EP	1x160 µm	2x100 µm	2x100 µm	1x160 µm	1x160 µm	1x160 µm	1x160 µm
TEKNOPLAST HS 150	EP	1x80 µm						
TEKNOPLAST 50 / 90	EP		1x40 µm					
TEKNODUR 0050 / 0090	PUR			1x40 µm				
TEKNODUR 3410-series	PUR				1x80 µm			
TEKNODUR COMBI 3430-series	PUR					1x80 µm		
TEKNODUR COMBI 340-811	PUR						1x80 µm	
TEKNODUR COMBI 3560-series	PAS							1x80 µm
Total film thickness		240 µm	240 µm	240 µm	240 µm	240 µm	240 µm	240 µm
Paint system VOC, g/m ²		103	117	116 / 122	110 - 119	114 - 128	100	73 - 116

Example of Teknos paint system code	Example of paint system structure
TEC3.07/VH/D1	ISO 12944-5/C3.07-EP (EP240/2-FeSa 2½).
TEC4.06/H/D3	ISO 12944-5/C4.06-EP/PUR (EPPUR240/2-FeSa 2½).
TEC5.02/M/D7	ISO 12944-5/C5.02-EP/PAS (EPPAS240/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C4.07	X	X	X	X
C5.03	X	X	X	

TEC4.07 Very high
TEC5.03 High

TEKNOPLAST PRIMER 7

Paint systems 300 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems consist of an high-solid epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

Paint		EP- top coat		PUR- top coat				PAS- top coat
		D1	D2	D3	D4	D5	D6	D7
TEKNOPLAST PRIMER 7	EP	2x100 µm	2x130 µm	2x130 µm	2x120 µm	2x100 µm	2x100 µm	2x100 µm
TEKNOPLAST HS 150	EP	1x100 µm						
TEKNOPLAST 50 / 90	EP		1x40 µm					
TEKNODUR 0050 / 0090	PUR			1x40 µm				
TEKNODUR 3410-series	PUR				1x60 µm			
TEKNODUR COMBI 3430-series	PUR					1x100 µm		
TEKNODUR COMBI 340-811	PUR						1x100 µm	
TEKNODUR COMBI 3560-series	PAS							1x100 µm
Total film thickness		300 µm	300 µm	300 µm	300 µm	300 µm	300 µm	300 µm
Paint system VOC, g/m ²		128	143	142 / 148	134 - 141	142 - 160	124	91 - 145

Example of Teknos paint system code	Example of paint system structure
TEC4.07/VH/D3	ISO 12944-5/C4.07-EP/PUR (EPPUR300/3-FeSa 2½).
TEC5.03/H/D7	ISO 12944-5/C5.03-EP/PAS (EPPAS300/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C5.04	X	X	X	X

TEC5.04 Very high

TEKNOPLAST PRIMER 7

Paint systems 360 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems consist of an high-solid epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

Paint		EP-top coat		PUR-top coat				PAS-top coat
		D1	D2	D3	D4	D5	D6	D7
TEKNOPLAST PRIMER 7	EP	2x130 µm	2x160 µm	2x160 µm	2x130 µm	2x130 µm	2x130 µm	2x120 µm
TEKNOPLAST HS 150	EP	1x100 µm						
TEKNOPLAST 50 / 90	EP		1x40 µm					
TEKNODUR 0050 / 0090	PUR			1x40 µm				
TEKNODUR 3410-series	PUR				1x100 µm			
TEKNODUR COMBI 3430-series	PUR					1x100 µm		
TEKNODUR COMBI 340-811	PUR						1x100 µm	
TEKNODUR COMBI 3560-series	PAS							1x120 µm
Total film thickness		360 µm	360 µm	360 µm	360 µm	360 µm	360 µm	360 µm
Paint system VOC, g/m ²		154	169	167 / 174	164 - 175	168 - 186	150	109 - 163

Example of Teknos paint system code	Example of paint system structure
TEC5.04/VH/D3	ISO 12944-5/C5.04-EP/PUR (EPPUR360/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.10	X	X	X	X
C4.10	X	X	X	
C5.06	X	X		

TEC3.10 Very high
TEC4.10 High
TEC5.06 Medium

TEKNOZINC 80 SE
Paint systems 200 µm

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems, containing zinc rich TEKNOZINC 80 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		EP- top coat		PUR- top coat			
		D1	D2	D3	D4	D5	D6
TEKNOZINC 80 SE	EP	1x60 µm	1x60 µm	1x60 µm	1x60 µm	1x60 µm	1x60 µm
TEKNOPLAST PRIMER 3 / 5	EP	1x100 µm		1x100 µm			
TEKNOPLAST PRIMER 7	EP		1x100 µm		1x100 µm	1x80 µm	
TEKNOPOX PRIMER 9-00	EP						1x100 µm
TEKNOPLAST 50/90	EP	1x40 µm	1x40 µm				
TEKNODUR 0050/0090	PUR			1x40 µm	1x40 µm		
TEKNODUR 3410-series	PUR					1x60 µm	
TEKNODUR 100 9-00	PUR						1x40 µm
Total film thickness		200 µm	200 µm	200 µm	200 µm	200 µm	200 µm
Paint system VOC, g/m ²		170	129	168 / 174	127 / 133	119 - 126	147

Example of Teknos paint system code	Example of paint system structure
TEC3.10/VH/D1	ISO 12944-5/C3.10-EPZn(R)/EP (EPZn(R)EP200/3-FeSa 2½)
TEC4.10/H/D3	ISO 12944-5/C4.10-EPZn(R)/EP/PUR (EPZn(R)EPPUR200/3-FeSa 2½)
TEC5.06/M/D5	ISO 12944-5/C5.06-EPZn(R)/EP/PUR (EPZn(R)EPPUR200/3-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C4.11	X	X	X	X
C5.07	X	X	X	

TEC4.11 Very high
TEC5.07 High

TEKNOZINC 80 SE Paint systems 260 µm

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems, containing zinc rich TEKNOZINC 80 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

Paint		EP- top coat		PUR- top coat			
		D1	D2	D3	D4	D5	D6
TEKNOZINC 80 SE	EP	1x60 µm	1x60 µm	1x60 µm	1x60 µm	1x60 µm	1x60 µm
TEKNOPLAST PRIMER 3 / 5	EP	2x80 µm		2x80 µm			
TEKNOPLAST PRIMER 7	EP		2x80 µm		2x80 µm	1x120 µm	
TEKNOPOX PRIMER 9-00	EP						2x80 µm
TEKNOPLAST 50/90	EP	1x40 µm	1x40 µm				
TEKNODUR 0050/0090	PUR			1x40 µm	1x40 µm		
TEKNODUR 3410-series	PUR					1x80 µm	
TEKNODUR 100 9-00	PUR						1x40 µm
Total film thickness		260 µm	260 µm	260 µm	260 µm	260 µm	260 µm
Paint system VOC, g/m ²		218	155	217 / 223	153 / 159	147 - 156	181

Example of Teknos paint system code	Example of paint system structure
TEC4.11/VH/D1	ISO 12944-5/C4.11-EPZn(R)/EP (EPZn(R)EP260/4-FeSa 2½)
TEC5.07/H/D3	ISO 12944-5/C5.07-EPZn(R)/EP/PUR (EPZn(R)EPPUR260/4-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C5.08	X	X	X	X

TEC5.08 Very high

**TEKNOZINC 80 SE
Paint systems 320 µm**

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems, containing zinc rich TEKNOZINC 80 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

Paint		EP- top coat	PUR- top coat		
		D1	D2	D3	D4
TEKNOZINC 80 SE	EP	1x60 µm	1x60 µm	1x60 µm	1x60 µm
TEKNOPLAST PRIMER 7	EP	2x110 µm	2x110 µm	2x100 µm	
TEKNOPOX PRIMER 9-00	EP				2x110 µm
TEKNOPLAST 50/90	EP	1x40 µm			
TEKNODUR 0050/0090	PUR		1x40 µm		
TEKNODUR 3410-series	PUR			1x60 µm	
TEKNODUR 100 9-00	PUR				1x40 µm
Total film thickness		320 µm	320 µm	320 µm	320 µm
Paint system VOC, g/m ²		180	179 / 185	170 - 177	214

Example of Teknos paint system code	Example of paint system structure
TEC5.08/VH/D1	ISO 12944-5/C5.08-EPZn(R)/EP (EPZn(R)EP320/4-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.05	X	X	X	
C3.05	X	X		
C4.04	X			

TEC2.05 High
TEC3.05 Medium
TEC4.04 Low

TEKNOMASTIC 80 PRIMER

Paint systems 120 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid polyurethane top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

Paint		EP- top coat	PUR- top coat	
		E1	E2	E3
TEKNOMASTIC 80 PRIMER	EP	1x80 µm	1x80 µm	1x80 µm
TEKNOPLAST 50 / 90	EP	1x40 µm		
TEKNODUR 0050 / 0090	PUR		1x40 µm	
TEKNODUR 3410-series	PUR			1x40 µm
Total film thickness		120 µm	120 µm	120 µm
Paint system VOC, g/m ²		52	50 / 56	40 - 44

Example of Teknos paint system code	Example of paint system structure
TEC2.05/H/E1	ISO 12944-5/C2.06-EP (EP120/2-FeSa 2½).
TEC3.05/M/E2	ISO 12944-5/C3.05-EP/PUR (EPPUR120/2-FeSa 2½).
TEC4.04/L/E3	ISO 12944-5/C4.04-EP/PUR (EPPUR120/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.06	X	X	X	X
C3.06	X	X	X	
C4.05	X	X		
C5.01	X			

TEC2.06 Very high
TEC3.06 High
TEC4.05 Medium
TEC5.01 Low

TEKNOMASTIC 80 PRIMER
Paint systems 180 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

Paint		EP- top coat		PUR- top coat				PAS- top coat
		E1	E2	E3	E4	E5	E6	E7
TEKNOMASTIC 80 PRIMER	EP	1x100 µm	1x120 µm	1x120 µm	1x100 µm	1x100 µm	1x100 µm	1x100 µm
TEKNOPLAST HS 150	EP	1x80 µm						
TEKNOPLAST 50 / 90	EP		1x60 µm					
TEKNODUR 0050 / 0090	PUR			1x60 µm				
TEKNODUR 3410-series	PUR				1x80 µm			
TEKNODUR COMBI 3430-series	PUR					1x80 µm		
TEKNODUR COMBI 340-811	PUR						1x80 µm	
TEKNODUR COMBI 3560-series	PAS							1x80 µm
Total film thickness		180 µm	180 µm	180 µm	180 µm	180 µm	180 µm	180 µm
Paint system VOC, g/m ²		58	78	60 / 66	66 - 75	70 - 84	56	29 - 72

Example of Teknos coding	Example of paint system structure
TEC2.06/VH/E1	ISO 12944-5/C2.06-EP (EP180/2-FeSa 2½).
TEC3.06/H/E3	ISO 12944-5/C3.06-EP/PUR (EPPUR180/2-FeSa 2½).
TEC4.05/M/E5	ISO 12944-5/C4.05-EP/PUR (EPPUR180/2-FeSa 2½).
TEC5.01/L/E7	ISO 12944-5/C5.01-EP/PAS (EPPAS180/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.07	X	X	X	X
C4.06	X	X	X	
C5.02	X	X		

TEC3.07 Very high
TEC4.06 High
TEC5.02 Medium

TEKNOMASTIC 80 PRIMER
Paint systems 240 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		EP- top coat		PUR- top coat				PAS- top coat
		E1	E2	E3	E4	E5	E6	E7
TEKNOMASTIC 80 PRIMER	EP	1x160 µm	2x100 µm	2x100 µm	1x160 µm	1x160 µm	1x160 µm	1x160 µm
TEKNOPLAST HS 150	EP	1x80 µm						
TEKNOPLAST 50 / 90	EP		1x40 µm					
TEKNODUR 0050 / 0090	PUR			1x40 µm				
TEKNODUR 3410-series	PUR				1x80 µm			
TEKNODUR COMBI 3430-series	PUR					1x80 µm		
TEKNODUR COMBI 340-811	PUR						1x80 µm	
TEKNODUR COMBI 3560-series	PAS							1x80 µm
Total film thickness		240 µm	240 µm	240 µm	240 µm	240 µm	240 µm	240 µm
Paint system VOC, g/m ²		73	81	79 / 85	81 - 90	85 - 99	70	44 - 87

Example of Teknos paint system code	Example of paint system structure
TEC3.07/VH/E1	ISO 12944-5/C3.07-EP (EP240/2-FeSa 2½).
TEC4.06/H/E3	ISO 12944-5/C4.06-EP/PUR (EPPUR240/3-FeSa 2½).
TEC5.02/M/E7	ISO 12944-5/C5.02-EP/PAS (EPPAS240/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C4.07	X	X	X	X
C5.03	X	X	X	

TEC4.07 Very high
TEC5.03 High

TEKNOMASTIC 80 PRIMER

Paint systems 300 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

Paint		EP-	PUR-					PAS-
		top coat	top coat					top coat
		E1	E2	E3	E4	E5	E6	
TEKNOMASTIC 80 PRIMER	EP	1x200 µm	2x130 µm	2x120 µm	1x200 µm	1x200 µm	1x200 µm	
TEKNOPLAST HS 150	EP	1x100 µm						
TEKNODUR 0050 / 0090	PUR		1x40 µm					
TEKNODUR 3410-series	PUR			1x60 µm				
TEKNODUR COMBI 3430-series	PUR				1x100 µm			
TEKNODUR COMBI 340-811	PUR					1x100 µm		
TEKNODUR COMBI 3560-series	PAS						1x100 µm	
Total film thickness		300 µm	300 µm	300 µm	300 µm	300 µm	300 µm	
Paint system VOC, g/m ²		92	94 / 99	89 - 96	105 - 123	87	54 - 108	

Example of Teknos paint system code	Example of paint system structure
TEC4.07/VH/E2	ISO 12944-5/C4.07-EP/PUR (EPPUR300/3-FeSa 2½).
TEC5.03/H/E6	ISO 12944-5/C5.03-EP/PAS (EPPAS300/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C5.04	X	X	X	X

TEC5.04 Very high

TEKNOMASTIC 80 PRIMER

Paint systems 360 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

Paint		EP-	PUR-				PAS-
		top coat	top coat				top coat
		E1	E2	E3	E4	E5	E6
TEKNOMASTIC 80 PRIMER	EP	2x140 µm	2x160 µm	2x140 µm	2x140 µm	2x140 µm	2x120 µm
TEKNOPLAST HS 150	EP	1x80 µm					
TEKNODUR 0050 / 0090	PUR		1x40 µm				
TEKNODUR 3410-series	PUR			1x80 µm			
TEKNODUR COMBI 3430-series	PUR				1x80 µm		
TEKNODUR COMBI 340-811	PUR					1x80 µm	
TEKNODUR COMBI 3560-series	PAS						1x120 µm
Total film thickness		360 µm	360 µm	360 µm	360 µm	360 µm	360 µm
Paint system VOC, g/m ²		102	109 / 115	110 - 119	114 - 128	99	37 - 101

Example of Teknos paint system code	Example of paint system structure
TEC5.04/VH/E2	ISO 12944-5/C5.04-EP/PUR (EPPUR360/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.10	X	X	X	X
C4.10	X	X	X	
C5.06	X	X		

TEC3.10 Very high
TEC4.10 High
TEC5.06 Medium

TEKNOZINC 3480 SE
Paint systems 200 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of zinc rich paints, in which the zinc content is at least 80% by weight in a dry paint film.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		EP- top coat		PUR- top coat			
		E1	E2	E3	E4	E5	E6
TEKNOZINC 3480 SE	EP	1x60 µm	1x60 µm	1x60 µm	1x60 µm	1x60 µm	1x60 µm
TEKNOPLAST PRIMER 3 / 5	EP	1x100 µm		1x100 µm			
TEKNOPLAST PRIMER 7	EP		1x100 µm		1x100 µm	1x80 µm	
TEKNOPOX PRIMER 9-00	EP						1x100 µm
TEKNOPLAST 50/90	EP	1x40 µm	1x40 µm				
TEKNODUR 0050/0090	PUR			1x40 µm	1x40 µm		
TEKNODUR 3410-series	PUR					1x60 µm	
TEKNODUR 100-09	PUR						1x40 µm
Total film thickness		200 µm	200 µm	200 µm	200 µm	200 µm	200 µm
Paint system VOC, g/m ²		143	102	141 / 147	100 / 106	92 - 99	120

Example of Teknos paint system code	Example of paint system structure
TEC3.10/VH/E1	ISO 12944-5/C3.10-EPZn(R)/EP (EPZn(R)EP200/3-FeSa 2½)
TEC4.10/H/E2	ISO 12944-5/C4.10-EPZn(R)/EP (EPZn(R)EP200/3-FeSa 2½)
TEC5.06/M/E5	ISO 12944-5/C5.06-EPZn(R)/EP/PUR (EPZn(R)EPPUR200/3-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C4.11	X	X	X	X
C5.07	X	X	X	

TEC4.11 Very high
TEC5.07 High

TEKNOZINC 3480 SE Paint systems 260 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of zinc rich paints, in which the zinc content is at least 80% by weight in a dry paint film.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

Paint		EP- top coat		PUR- top coat			
		E1	E2	E3	E4	E5	E6
TEKNOZINC 3480 SE	EP	1x60 µm	1x60 µm	1x60 µm	1x60 µm	1x60 µm	1x60 µm
TEKNOPLAST PRIMER 3 / 5	EP	2x80 µm		2x80 µm			
TEKNOPLAST PRIMER 7	EP		2x80 µm		2x80 µm	1x120 µm	
TEKNOPOX PRIMER 9-00	EP						2x80 µm
TEKNOPLAST 50/90	EP	1x40 µm	1x40 µm				
TEKNODUR 0050/0090	PUR			1x40 µm	1x40 µm		
TEKNODUR 3410-series	PUR					1x80 µm	
TEKNODUR 100 9-00	PUR						1x40 µm
Total film thickness		260 µm	260 µm	260 µm	260 µm	260 µm	260 µm
Paint system VOC, g/m ²		191	128	190 / 196	126 / 132	120 - 129	154

Example of Teknos paint system code	Example of paint system structure
TEC4.11/VH/E1	ISO 12944-5/C4.11-EPZn(R)/EP (EPZn(R)EP260/4-FeSa 2½)
TEC5.07/H/E4	ISO 12944-5/C5.07-EPZn(R)/EP/PUR (EPZn(R)EPPUR260/4-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C5.08	X	X	X	X

TEC5.08 Very high

TEKNOZINC 3480 SE Paint systems 320 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of zinc rich paints, in which the zinc content is at least 80% by weight in a dry paint film.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		EP- top coat	PUR- top coat		
		E1	E2	E3	E4
TEKNOZINC 3480 SE	EP	1x60 µm	1x60 µm	1x60 µm	1x60 µm
TEKNOPLAST PRIMER 7	EP	2x110 µm	2x110 µm	2x100 µm	
TEKNOPOX PRIMER 9-00	EP				2x110 µm
TEKNOPLAST 50/90	EP	1x40 µm			
TEKNODUR 0050/0090	PUR		1x40 µm		
TEKNODUR 3410-series	PUR			1x60 µm	
TEKNODUR 100 9-00	PUR				1x40 µm
Total film thickness		320 µm	320 µm	320 µm	320 µm
Paint system VOC, g/m ²		153	152 / 158	143 -150	151

Example of Teknos paint system code	Example of paint system structure
TEC5.08/VH/E1	ISO 12944-5/C5.08-EPZn(R)/EP (EPZn(R)EP320/4-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.01	X			

TEC2.01 Low

1-COMPONENT COMBI Paint systems 80 µm

1 1.8.2018

1-COMPONENT COMBI paint systems consist of different kind of alkyd paints having very good corrosion protection properties. 1-COMPONENT COMBI paints contain efficient active anticorrosive pigments. TEKNOLAC COMBI 50 has the fastest drying properties and TEKNOSYNT COMBI 50 is a thixotropic urethane/alkyd based paint.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity category C2 with durability class low.

Paint		A1	A2	A3
TEKNOLAC COMBI 50	AK	1x80 µm		
TEKNOLAC COMBI 2280-02	AK		1x80 µm	
TEKNOSYNT COMBI 50	AK			1x80 µm
Total film thickness		80 µm	80 µm	80 µm
Paint system VOC, g/m ²		92	48	89

Example of Teknos paint system code	Example of paint system structure
TEC2.01/L/A1	ISO 12944-5/C2.01-AK (AK80/1-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.02	X	X		
C3.01	X			

TEC2.02 Medium
TEC3.01 Low

1-COMPONENT COMBI Paint systems 100 µm

1 1.8.2018

1-COMPONENT COMBI paint systems consist of different kind of alkyd paints having very good corrosion protection properties. 1-COMPONENT COMBI paints contain efficient active anticorrosive pigments. TEKNOLAC COMBI 50 has the fastest drying properties and TEKNOSYNT COMBI 50 is a thixotropic urethane/alkyd based paint.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 - C3 with durability classes medium - low.

Paint		A1	A2	A3
TEKNOLAC COMBI 50	AK	1x100 µm		
TEKNOLAC COMBI 2280-02	AK		1x100 µm	
TEKNOSYNT COMBI 50	AK			1x100 µm
Total film thickness		100 µm	100 µm	100 µm
Paint system VOC, g/m ²		60	60	80

Example of Teknos paint system code	Example of paint system structure
TEC2.02/M/A1	ISO 12944-5/C2.02-AK (AK100/1-FeSa 2½).
TEC3.01/L/A2	ISO 12944-5/C3.01-AK (AK100/1-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.03	X	X	X	
C3.02	X	X		
C4.01	X			

TEC2.03 High
TEC3.02 Medium
TEC4.01 Low

1-COMPONENT COMBI Paint systems 160 µm

1 1.8.2018

1-COMPONENT COMBI paint systems consist of different kind of alkyd paints having very good corrosion protection properties. 1-COMPONENT COMBI paints contain efficient active anticorrosive pigments. TEKNOLAC COMBI 50 has the fastest drying properties and TEKNOSYNT COMBI 50 is a thixotropic urethane/alkyd based paint.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

Paint		A1	A2	A3
TEKNOLAC COMBI 50	AK	2x80 µm		
TEKNOLAC COMBI 2280-02	AK		2x80 µm	
TEKNOSYNT COMBI 50	AK			2x80 µm
Total film thickness		160 µm	160 µm	160 µm
Paint system VOC, g/m ²		185	96	178

Example of Teknos paint system code	Example of paint system structure
TEC2.03/H/A1	ISO 12944-5/C2.03-AK (AK160/2-FeSa 2½).
TEC3.02/M/A2	ISO 12944-5/C3.02-AK (AK160/2-FeSa 2½).
TEC4.01/L/A3	ISO 12944-5/C4.01-AK (AK160/2-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C2.04	X	X	X	X
C3.03	X	X	X	
C4.02	X	X		

TEC2.04 Very high
TEC3.03 High
TEC4.02 Medium

1-COMPONENT COMBI Paint systems 200 µm

1 1.8.2018

1-COMPONENT COMBI paint systems consist of different kind of alkyd paints having very good corrosion protection properties. 1-COMPONENT COMBI paints contain efficient active anticorrosive pigments. TEKNOLAC COMBI 50 has the fastest drying properties and TEKNOSYNT COMBI 50 is a thixotropic urethane/alkyd based paint.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes very high - low.

Paint		A1	A2	A3
TEKNOLAC COMBI 50	AK	1x80 µm		
TEKNOLAC COMBI 50	AK	2x60 µm		
TEKNOLAC COMBI 2280-02	AK		1x80 µm	
TEKNOLAC COMBI 2280-02	AK		1x120 µm	
TEKNOSYNT COMBI 50	AK			1x80 µm
TEKNOSYNT COMBI 50	AK			2x60 µm
Total film thickness		200 µm	200 µm	200 µm
Paint system VOC, g/m ²		230	121	160

Example of Teknos paint system code	Example of paint system structure
TEC2.04/VH/A1	ISO 12944-5/C2.04-AK (AK200/3-FeSa 2½).
TEC3.03/H/A2	ISO 12944-5/C3.03-AK (AK200/2-FeSa 2½).
TEC4.02/M/A3	ISO 12944-5/C4.02-AK (AK200/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

C

Paint system ISO 12944-5	Low	Medium	High	Very high
C3.04	X	X	X	X
C4.03	X	X	X	

TEC3.04 Very high
TEC4.03 High

1-COMPONENT COMBI Paint systems 260 µm

1 1.8.2018

1-COMPONENT COMBI paint systems consist of different kind of alkyd paints having very good corrosion protection properties. 1-COMPONENT COMBI paints contain efficient active anticorrosive pigments. TEKNOLAC COMBI 50 has the fastest drying properties and TEKNOSYNT COMBI 50 is a thixotropic urethane/alkyd based paint.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C3 – C4 with durability classes very high - high.

Paint		A1	A2	A3
TEKNOLAC COMBI 50	AK	1x60 µm		
TEKNOLAC COMBI 50	AK	2x100 µm		
TEKNOLAC COMBI 2280-02	AK		1x60 µm	
TEKNOLAC COMBI 2280-02	AK		2x100 µm	
TEKNOSYNT COMBI 50	AK			1x60 µm
TEKNOSYNT COMBI 50	AK			2x100 µm
Total film thickness		260 µm	260 µm	260 µm
Paint system VOC, g/m ²		300	157	208

Example of Teknos paint system code	Example of paint system structure
TEC3.04/VH/A1	ISO 12944-5/C3.04-AK (AK260/3-FeSa 2½).
TEC4.03/H/A2	ISO 12944-5/C3.04-AK (AK260/3-FeSa 2½).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G2.01	Zn	Zn	Zn	
G3.01	Zn	Zn		
G4.01	Zn			

TEG2.01 High
TEG3.01 Medium
TEG4.01 Low

2-COMPONENT COMBI, HOT DIP GALVANIZED Paint systems 80 µm

1 1.8.2018

2-COMPONENT COMBI paint systems for hot dip galvanized steel consist of different types of paint chemistries. These one layer paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

Paint		R1	R2
TEKNOPLAST HS 150	EP	1x80 µm	
TEKNODUR COMBI 3430 -series	PUR		1x80 µm
Total film thickness		80 µm	80 µm
Paint system VOC, g/m ²		34	46 - 60

Example of Teknos paint system code	Example of paint system structure
TEG2.01/H/R1	ISO 12944-5/G2.01-EP (EP80/1-ZnSaS).
TEG3.01/M/R2	ISO 12944-5/G3.01-PUR (PUR80/1-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G2.03	Zn	Zn	Zn	Zn
G3.02	Zn	Zn	Zn	
G4.02	Zn	Zn		
G5.01	Zn			

TEG2.03 Very high
TEG3.02 High
TEG4.02 Medium
TEG5.01 Low

2-COMPONENT COMBI, HOT DIP GALVANIZED Paint systems 120 µm

1 1.8.2018

2-COMPONENT COMBI paint systems for hot dip galvanized steel consist of different types of paint chemistries. These one layer paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

Paint		R1	R2
TEKNOPLAST HS 150	EP	1x120 µm	
TEKNODUR COMBI 3430 -series	PUR		1x120 µm
Total film thickness		120 µm	120 µm
Paint system VOC, g/m ²		51	69 - 90

Example of Teknos paint system code	Example of paint system structure
TEG2.03/VH/R1	ISO 12944-5/G2.03-EP (EP120/1-ZnSaS).
TEG3.02/H/R2	ISO 12944-5/G3.02-PUR (PUR120/1-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G3.04	Zn	Zn	Zn	Zn
G4.04	Zn	Zn	Zn	
G5.02	Zn	Zn		

TEG3.04 Very high
TEG4.04 High
TEG5.02 Medium

2-COMPONENT COMBI, HOT DIP GALVANIZED Paint systems 160 µm

1 1.8.2018

2-COMPONENT COMBI paint systems for hot dip galvanized steel consist of different types of paint chemistries. These one layer paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		R1	R2
TEKNOPLAST HS 150	EP	2x80 µm	
TEKNODUR COMBI 3430 -series	PUR		2x80 µm
Total film thickness		160 µm	160 µm
Paint system VOC, g/m ²		68	92 - 120

Example of Teknos paint system code	Example of paint system structure
TEG3.04/VH/R1	ISO 12944-5/G3.04-EP (EP160/2-ZnSaS).
TEG4.04/H/R2	ISO 12944-5/G4.04-PUR (PUR160/2-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G4.06	Zn	Zn	Zn	Zn
G5.04	Zn	Zn	Zn	

TEG4.06 Very high
TEG5.04 High

2-COMPONENT COMBI, HOT DIP GALVANIZED Paint systems 200 µm

1 1.8.2018

2-COMPONENT COMBI paint systems for hot dip galvanized steel consist of different types of paint chemistries. These one layer paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

Paint		R1	R2
TEKNOPLAST HS 150	EP	1x80 µm	
TEKNOPLAST HS 150	EP	1x120 µm	
TEKNODUR COMBI 3430 -series	PUR		1x80 µm
TEKNODUR COMBI 3430 -series	PUR		1x120 µm
Total film thickness		200 µm	200 µm
Paint system VOC, g/m ²		85	115 - 150

Example of Teknos paint system code	Example of paint system structure
TEG4.06/VH/R1	ISO 12944-5/G4.06-EP (EP200/2-ZnSaS).
TEG5.04/H/R2	ISO 12944-5/G5.04-PUR (PUR200/2-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G5.05	Zn	Zn	Zn	Zn

TEG5.05 Very high

2-COMPONENT COMBI, HOT DIP GALVANIZED Paint systems 240 µm

1 1.8.2018

2-COMPONENT COMBI paint systems for hot dip galvanized steel consist of different types of paint chemistries. These one layer paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

Paint		R1	R2
TEKNOPLAST HS 150	EP	1x80 µm	
TEKNOPLAST HS 150	EP	1x160 µm	
TEKNODUR COMBI 3430 -series	PUR		1x80 µm
TEKNODUR COMBI 3430 -series	PUR		1x160 µm
Total film thickness		240 µm	240 µm
Paint system VOC, g/m ²		102	138 - 180

Example of Teknos paint system code	Example of paint system structure
TEG5.05/VH/R1	ISO 12944-5/G5.05-EP (EP240/2-ZnSaS).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G3.05	Zn	Zn	Zn	Zn
G4.05	Zn	Zn	Zn	
G5.03	Zn	Zn		

TEG3.05 Very high
TEG4.05 High
TEG5.03 Medium

TEKNOCRYL PRIMER 3-11, HOT DIP GALVANIZED Paint systems 200 µm

1 1.8.2018

TEKNOCRYL PRIMER 3-11 paint system is an acrylic based physically drying paint system with good adhesion on hot dip galvanized substrates.

This paint system is designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		R1
TEKNOCRYL PRIMER 3-11	AY	2x80 µm
TEKNOCRYL 100-500	AY	1x40 µm
Total film thickness		200 µm
Paint system VOC, g/m ²		181

Example of Teknos paint system code	Example of paint system structure
TEG3.05/VH/R1	ISO 12944-5/G3.05-AY (AY200/3-ZnSaS).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G2.03	Zn	Zn	Zn	Zn
G3.02	Zn	Zn	Zn	
G4.02	Zn	Zn		
G5.01	Zn			

TEG2.03 Very high
TEG3.02 High
TEG4.02 Medium
TEG5.01 Low

TEKNOPLAST PRIMER 5, HOT DIP GALVANIZED
Paint systems 120 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

Paint		EP- top coat	PUR- top coat	
		S1	S2	S3
TEKNOPLAST PRIMER 5	EP	1x80 µm	1x80 µm	1x80 µm
TEKNOPLAST 50 / 90	EP	1x40 µm		
TEKNODUR 0050 / 0090	PUR		1x40 µm	
TEKNODUR 3410-series	PUR			1x40 µm
Total film thickness		120 µm	120 µm	120 µm
Paint system VOC, g/m ²		98	97 / 103	87 - 91

Example of Teknos paint system code	Example of paint system structure
TEG2.03/VH/S1	ISO 12944-5/G2.03-EP (EP120/2-ZnSaS).
TEG3.02/H/S2	ISO 12944-5/G3.02-EP/PUR (EPPUR120/2-ZnSaS)
TEG4.02/M/S3	ISO 12944-5/G4.02-EP/PUR (EPPUR120/2-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G3.04	Zn	Zn	Zn	Zn
G4.04	Zn	Zn	Zn	
G5.02	Zn	Zn		

TEG3.04 Very high
TEG4.04 High
TEG5.02 Medium

TEKNOPLAST PRIMER 5, HOT DIP GALVANIZED Paint systems 160 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		EP- top coat	PUR- top coat		
		S1	S2	S3	S4
TEKNOPLAST PRIMER 5	EP	1x80 µm	1x80 µm	1x80 µm	1x80 µm
TEKNOPLAST HS 150	EP	1x80 µm			
TEKNODUR 3410-series	PUR		1x80 µm		
TEKNODUR COMBI 3430-series	PUR			1x80 µm	
TEKNODUR COMBI 340-811	PUR				1x80 µm
Total film thickness		160 µm	160 µm	160 µm	160 µm
Paint system VOC, g/m ²		100	108 - 117	112 - 126	97

Example of Teknos paint system code	Example of paint system structure
TEG3.04/VH/S1	ISO 12944-5/G3.04-EP (EP160/2-ZnSaS).
TEG4.04/H/S3	ISO 12944-5/G4.04-EP/PUR (EPPUR160/2-ZnSaS)
TEG5.02/M/S4	ISO 12944-5/G5.02-EP/PUR (EPPUR160/2-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G4.06	Zn	Zn	Zn	Zn
G5.04	Zn	Zn	Zn	

TEG4.06 Very high
TEG5.04 High

TEKNOPLAST PRIMER 5, HOT DIP GALVANIZED Paint systems 200 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

Paint		EP- top coat		PUR- top coat			PAS- top coat
		S1	S2	S3	S4	S5	S6
TEKNOPLAST PRIMER 5	EP	1x80 µm	1x80 µm	2x80 µm	1x80 µm	1x80 µm	1x80 µm
TEKNOPLAST HS 150	EP	1x120 µm					
TEKNOMASTIC COMBI 80-500	EP		1x120 µm				
TEKNODUR 3410-series	PUR			1x40 µm			
TEKNODUR COMBI 3430-series	PUR				1x120 µm		
TEKNODUR COMBI 340-811	PUR					1x120 µm	
TEKNODUR COMBI 3560-series	PUR						1x120 µm
Total film thickness		200 µm	200 µm	200 µm	200 µm	200 µm	200 µm
Paint system VOC, g/m ²		117	95	153 - 157	135 - 156	113	74 - 138

Example of Teknos paint system code	Example of paint system structure
TEG4.06/VH/S1	ISO 12944-5/G4.06-EP (EP200/2-ZnSaS).
TEG4.06/VH/S3	ISO 12944-5/G4.06-EP/PUR (EPPUR200/3-ZnSaS)
TEG5.04/H/S4	ISO 12944-5/G5.04-EP/PUR (EPPUR200/2-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G5.05	Zn	Zn	Zn	Zn

TEG5.05 Very high

TEKNOPLAST PRIMER 5, HOT DIP GALVANIZED Paint systems 240 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

Paint		EP- top coat		PUR- top coat			PAS- top coat
		S1	S2	S3	S4	S5	S6
TEKNOPLAST PRIMER 5	EP	2x80 µm	1x80 µm	2x80 µm	2x80 µm	2x80 µm	1x80 µm
TEKNOPLAST HS 150	EP	1x80 µm					
TEKNOMASTIC COMBI 80-500	EP		1x160 µm				
TEKNODUR 3410-series	PUR			1x80 µm			
TEKNODUR COMBI 3430-series	PUR				1x80 µm		
TEKNODUR COMBI 340-811	PUR					1x80 µm	
TEKNODUR COMBI 3560-series	PUR						1x160 µm
Total film thickness		240 µm	240 µm	240 µm	240 µm	240 µm	240 µm
Paint system VOC, g/m ²		166	105	174 - 183	178 - 192	163	76 - 162

Example of Teknos paint system code	Example of paint system structure
TEG5.05/VH/S1	ISO 12944-5/G5.05-EP (EP240/3-ZnSaS).
TEG5.05/VH/S6	ISO 12944-5/G5.05-EP/PAS (EPPAS240/2-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G2.03	Zn	Zn	Zn	Zn
G3.02	Zn	Zn	Zn	
G4.02	Zn	Zn		
G5.01	Zn			

TEG2.03 Very high
TEG3.02 High
TEG4.02 Medium
TEG5.01 Low

TEKNOPLAST PRIMER 7, HOT DIP GALVANIZED Paint systems 120 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

Paint		EP- top coat	PUR- top coat	
		T1	T2	T3
TEKNOPLAST PRIMER 7	EP	1x80 µm	1x80 µm	1x80 µm
TEKNOPLAST 50 / 90	EP	1x40 µm		
TEKNODUR 0050 / 0090	PUR		1x40 µm	
TEKNODUR 3410-series	PUR			1x40 µm
Total film thickness		120 µm	120 µm	120 µm
Paint system VOC, g/m ²		66	65 / 71	55 - 59

Example of Teknos paint system code	Example of paint system structure
TEG2.03/VH/T1	ISO 12944-5/G2.03-EP (EP120/2-ZnSaS).
TEG3.02/H/T2	ISO 12944-5/G3.02-EP/PUR (EPPUR120/2-ZnSaS)
TEG4.02/M/T3	ISO 12944-5/G4.02-EP/PUR (EPPUR120/2-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G3.04	Zn	Zn	Zn	Zn
G4.04	Zn	Zn	Zn	
G5.02	Zn	Zn		

TEG3.04 Very high
TEG4.04 High
TEG5.02 Medium

TEKNOPLAST PRIMER 7, HOT DIP GALVANIZED Paint systems 160 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

Paint		EP- top coat	PUR- top coat		
		T1	T2	T3	T4
TEKNOPLAST PRIMER 7	EP	1x80 µm	1x80 µm	1x80 µm	1x80 µm
TEKNOPLAST HS 150	EP	1x80 µm			
TEKNODUR 3410-series	PUR		1x80 µm		
TEKNODUR COMBI 3430-series	PUR			1x80 µm	
TEKNODUR COMBI 340-811	PUR				1x80 µm
Total film thickness		160 µm	160 µm	160 µm	160 µm
Paint system VOC, g/m ²		68	76 - 85	80 - 94	65

Example of Teknos paint system code	Example of paint system structure
TEG3.04/VH/T1	ISO 12944-5/G3.04-EP (EP160/2-ZnSaS).
TEG4.04/H/T3	ISO 12944-5/G4.04-EP/PUR (EPPUR160/2-ZnSaS)
TEG5.02/M/T4	ISO 12944-5/G5.02-EP/PUR (EPPUR160/2-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G4.06	Zn	Zn	Zn	Zn
G5.04	Zn	Zn	Zn	

TEG4.06 Very high
TEG5.04 High

TEKNOPLAST PRIMER 7, HOT DIP GALVANIZED Paint systems 200 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

Paint		EP- top coat		PUR- top coat			PAS- top coat
		T1	T2	T3	T4	T5	T6
TEKNOPLAST PRIMER 7	EP	1x80 µm	1x80 µm	2x80 µm	1x80 µm	1x80 µm	1x80 µm
TEKNOPLAST HS 150	EP	1x120 µm					
TEKNOMASTIC COMBI 80-500	EP		1x120 µm				
TEKNODUR 3410-series	PUR			1x40 µm			
TEKNODUR COMBI 3430-series	PUR				1x120 µm		
TEKNODUR COMBI 340-811	PUR					1x120 µm	
TEKNODUR COMBI 3560-series	PAS						1x120 µm
Total film thickness		200 µm	200 µm	200 µm	200 µm	200 µm	200 µm
Paint system VOC, g/m ²		86	63	89 - 93	103 - 124	81	40 - 104

Example of Teknos paint system code	Example of paint system structure
TEG4.06/VH/T1	ISO 12944-5/G4.06-EP (EP200/2-ZnSaS).
TEG4.06/VH/T3	ISO 12944-5/G4.06-EP/PUR (EPPUR200/3-ZnSaS)
TEG5.04/H/T4	ISO 12944-5/G5.04-EP/PUR (EPPUR200/2-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

G

Paint system ISO 12944-5	Low	Medium	High	Very high
G5.05	Zn	Zn	Zn	Zn

TEG5.05 Very high

TEKNOPLAST PRIMER 7, HOT DIP GALVANIZED Paint systems 240 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

Paint		EP- top coat		PUR- top coat			PAS- top coat
		T1	T2	T3	T4	T5	T6
TEKNOPLAST PRIMER 7	EP	2x80 µm	1x80 µm	2x80 µm	2x80 µm	2x80 µm	1x80 µm
TEKNOPLAST HS 150	EP	1x80 µm					
TEKNOMASTIC COMBI 80-500	EP		1x160 µm				
TEKNODUR 3410-series	PUR			1x80 µm			
TEKNODUR COMBI 3430-series	PUR				1x80 µm		
TEKNODUR COMBI 340-811	PUR					1x80 µm	
TEKNODUR COMBI 3560-series	PAS						1x160 µm
Total film thickness		240 µm	240 µm	240 µm	240 µm	240 µm	240 µm
Paint system VOC, g/m ²		102	73	110 - 119	114 - 128	99	44 - 130

Example of Teknos paint system code	Example of paint system structure
TEG5.05/VH/T1	ISO 12944-5/G5.05-EP (EP240/3-ZnSaS).
TEG5.05/VH/T6	ISO 12944-5/G5.05-EP/PAS (EPPAS240/2-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity category / offshore environments

CX

Paint system ISO 12944-9	High
CX	X
CX + Im4	
Im4	

OFFSHORE PAINT SYSTEMS FOR CARBON STEEL

Paint systems 280 µm

1 1.8.2018

These paint systems are designed for corrosion protection of carbon steel structures at offshore environments.

These paint systems consist of a zinc rich epoxy primer, an epoxy intermediate coat and a polyurethane top coat.

ISO 12944-9 describes paint systems for high durability according to ISO 12944-1.

Paint		CXA1
TEKNOZINC 90 SE	EP	1x60 µm
TEKNOMASTIC 80 PRIMER	EP	1x160 µm
TEKNODUR 0050	PUR	1x60 µm
Total film thickness		280 µm
Paint system VOC, g/m ²		136

Paint		CXA2
TEKNOZINC 80 SE	EP	1x60 µm
TEKNOPLAST PRIMER 7 MIOX	EP	1x80 µm
TEKNOPLAST PRIMER 7	EP	1x80 µm
TEKNODUR 0050	PUR	1x60 µm
Total film thickness		280 µm
Paint system VOC, g/m ²		168

Example of Teknos paint system code	Example of paint system structure
TECX/H/A1	ISO 12944-9/CX-EPZn(R)/EP/PUR (EPZn(R)EPPUR280/3-FeSa 2½)
TECX/H/A2	ISO 12944-9/CX-EPZn(R)/EP/PUR (EPZn(R)EPPUR280/4-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). The surface profile must be at least medium (G) as defined in standard ISO 8503-1.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity category / offshore environments

CX, Im4, CX + Im4

Paint system ISO 12944-9	High
CX	X
CX + Im4	X
Im4	X

OFFSHORE PAINT SYSTEMS FOR SPLASH AND TIDAL ZONES Paint system 600 µm

1 1.8.2018

This paint system is designed for corrosion protection of carbon steel structures in splash and tidal zones, at offshore environments.

This paint system consists of an epoxy paint.

ISO 12944-9 describes paint systems for high durability according to ISO 12944-1.

Paint		CXS1
TEKNOMASTIC 80 PRIMER	EP	3x200 µm
Total film thickness		600 µm
Paint system VOC, g/m ²		146

Example of Teknos paint system code	Example of paint system structure
TECX/H/S1	ISO 12944-9/CX-EP (EP600/3-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). The surface profile must be at least medium (G) as defined in standard ISO 8503-1.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity category / offshore environments

Im4

Paint system ISO 12944-9	High
CX	
CX + Im4	
Im4	X

OFFSHORE PAINT SYSTEMS FOR IMMERSION

Paint system 350 µm

1 1.8.2018

This paint system is designed for corrosion protection of carbon steel structures in immersion conditions at offshore environments.

This paint system consists of an epoxy paint.

ISO 12944-9 describes paint systems for high durability according to ISO 12944-1.

Paint		CX11
TEKNOMASTIC 80 PRIMER	EP	2x175 µm
Total film thickness		350 µm
Paint system VOC, g/m ²		85

Example of Teknos paint system code	Example of paint system structure
TECX/H/11	ISO 12944-9/CX-EP (EP350/2-FeSa 2½)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). The surface profile must be at least medium (G) as defined in standard ISO 8503-1.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity category / offshore environments

CXG

Paint system ISO 12944-9	High
CX	Zn
CX + Im4	
Im4	

OFFSHORE PAINT SYSTEMS FOR HOT DIP GALVANIZED
Paint system 220 µm

1 1.8.2018

These paint systems are designed for corrosion protection of hot dip galvanized steel structures at offshore environments.

These paint systems consist of an epoxy primer, an epoxy intermediate coat and a polyurethane top coat.

ISO 12944-9 describes paint systems for high durability according to ISO 12944-1.

Paint		CXG1
TEKNOPLAST PRIMER 3	EP	1x20 µm
TEKNOPLAST HS 150	EP	1x140 µm
TEKNODUR 0050	PUR	1x60 µm
Total film thickness		220 µm
Paint system VOC, g/m ²		122

Example of Teknos paint system code	Example of paint system structure
TECX/H/G1	ISO 12944-9/CX-EP/PUR (EPPUR220/3-ZnSaS)

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods.

Zinc surfaces: Hot dip galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

TSM

Paint system ISO 12944-5	Low	Medium	High	Very high
TSM4.01	TSM	TSM	TSM	

TETSM4.01 High

TEKNOPLAST PRIMER 5, THERMALLY SPRAYED METAL

Paint systems 160 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for thermally sprayed metal consist of epoxy and polyurethane top coats. TEKNOPLAST PRIMER 5 is also used as a sealer on thermally sprayed metal substrates. For sealer usage TEKNOPLAST PRIMER 5 is diluted 20–40 % by volume with TEKNOSOLV 9506. The function of the sealer is to fill the metal pores and to form an even, non-measurable layer on the surface. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C4 with durability class high.

		EP- top coat	PUR- top coat
Paint		A1	A2
TEKNOPLAST PRIMER 5 (Sealer)		NA	NA
TEKNOPLAST PRIMER 5	EP	1x80 µm	1x80 µm
TEKNOPLAST HS 150	EP	1x80 µm	
TEKNODUR COMBI 3430-series	PUR		1x80 µm
Total film thickness		160 µm	160 µm
Paint system VOC, g/m ²		100	112 - 126

Example of Teknos paint system code	Example of paint system structure
TETSM4.01/H/A1	ISO 12944-5/TSM4.01-EP (EP160/2-TSM).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Thermally sprayed metal coatings shall be painted immediately after thermal spraying before any condensation can take place.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

TSM

Paint system ISO 12944-5	Low	Medium	High	Very high
TSM4.02	TSM	TSM	TSM	TSM
TSM5.01	TSM	TSM	TSM	

TETSM4.02 Very high
TETSM5.01 High

TEKNOPLAST PRIMER 5, THERMALLY SPRAYED METAL

Paint systems 200 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for thermally sprayed metal consist of epoxy and polyurethane top coats. TEKNOPLAST PRIMER 5 is also used as a sealer on thermally sprayed metal substrates. For sealer usage TEKNOPLAST PRIMER 5 is diluted 20–40 % by volume with TEKNOSOLV 9506. The function of the sealer is to fill the metal pores and to form an even, non-measurable layer on the surface. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

		EP- top coat	PUR- top coat
Paint		A1	A2
TEKNOPLAST PRIMER 5 (Sealer)		NA	NA
TEKNOPLAST PRIMER 5	EP	1x80 µm	1x80 µm
TEKNOPLAST HS 150	EP	1x120 µm	
TEKNODUR COMBI 3430-series	PUR		1x120 µm
Total film thickness		200 µm	200 µm
Paint system VOC, g/m ²		117	135 - 156

Example of Teknos paint system code	Example of paint system structure
TETSM4.02/VH/A1	ISO 12944-5/TSM4.02-EP (EP200/2-TSM).
TETSM5.01/H/A2	ISO 12944-5/TSM5.01-EP/PUR (EPPUR200/2-TSM).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Thermally sprayed metal coatings shall be painted immediately after thermal spraying before any condensation can take place.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

TSM

Paint system ISO 12944-5	Low	Medium	High	Very high
TSM5.02	TSM	TSM	TSM	TSM

TETSM5.02 Very high

TEKNOPLAST PRIMER 5, THERMALLY SPRAYED METAL

Paint systems 240 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for thermally sprayed metal consist of epoxy and polyurethane top coats. TEKNOPLAST PRIMER 5 is also used as a sealer on thermally sprayed metal substrates. For sealer usage TEKNOPLAST PRIMER 5 is diluted 20–40 % by volume with TEKNOSOLV 9506. The function of the sealer is to fill the metal pores and to form an even, non-measurable layer on the surface. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

		EP- top coat	PUR- top coat
Paint		A1	A2
TEKNOPLAST PRIMER 5 (Sealer)		NA	NA
TEKNOPLAST PRIMER 5	EP	1x120 µm	1x120 µm
TEKNOPLAST HS 150	EP	1x120 µm	
TEKNODUR COMBI 3430-series	PUR		1x120 µm
Total film thickness		240 µm	240 µm
Paint system VOC, g/m ²		150	168 - 189

Example of Teknos paint system code	Example of paint system structure
TETSM5.02/VH/A1	ISO 12944-5/TSM5.02-EP (EP240/2-TSM).

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

Surface preparation Thermally sprayed metal coatings shall be painted immediately after thermal spraying before any condensation can take place.

For more detailed information about of the above-mentioned products please see individual product data sheets.