

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

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.

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

Paint		A1	A2	A3	A4	A5
TEKNOMASTIC 80 PRIMER	EP	1x80 µm	1x80 µm	1x80 µm	1x80 µm	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	540 µm	540 µm	540 µm	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.