

**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 <sup>2</sup>		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.