

	Toase-eh Park Sanati Gohar Ofogh Petrochemical Co. CONCEPTUAL, BASIC and DETAIL DESIGN ENGINEERING OF STYRENE PARK OFFSITE	 
	Document Title: Surface Blasting & Painting & Galvanizing Specification and Inspection Procedure	
	Document No.: EI027-DMF-VD-QC-PRO-024	Rev. R2

- RAL: 7038 (Grey)

- ADHESION DEGREE: ACCORDING TO ASTM D - 3359 / 4A

7.2. Specification for Structural Steel works

Header walk way & support mechanism & Bolts/Nuts shall be hot dip galvanized according to ASTM A123.

STRUCTURE PARTS

OPERATION TEMP. RANGE.: ≤ 100 °C

Surface Preparation: SA2 1/2

Primer: Zinc Ethyl silicate : 75 microns

Intermediate: 1- Tie coat, epoxy polyamide, 30 microns

2- Mid Coat, High Build Epoxy: 125 microns

Finish coat: Acrylic polyurethane: 75 microns

- TOTAL DRY FILM (DFT) 305 μ

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7.3. Curing And recoating time:

For the time and temperature required for curing, touch dry and over coating time

