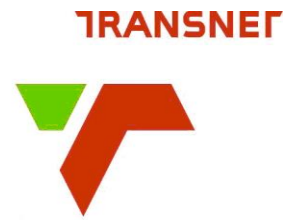




Annexure F

TNPA-SHEQ PD-QUAL- SPEC-008 CORROSION PROTECTION



TRANSNET

SPECIFICATION FOR CORROSION PROTECTION

TNPA-SHEQ PD-QUAL-SPEC-008

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DOCUMENTATION SIGN-OFF SHEET

I, the undersigned hereby approve this procedure.

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1. SCOPE

1.1 This specification covers Transnet requirements for protective coating of iron and steel structures, electrical motors, gear boxes etc. against corrosion and must be read in conjunction with the main specification as well as the following (latest editions): -

ISO 12944-4 – Types of Surface & Surface preparation

ISO 2409 - Paints and varnishes — Cross-cut test

SANS 1091 for National colour standard (NCS)

2. TYPES OF CORROSION PROTECTION TO BE USED

- 2.1 The coatings specified in this specification are chosen according to ISO 12944-4, as per Table A.1 to ensure adequate protection after 10 years in an environment of frequent salt spray, chemicals and polluted coastal atmosphere. During the 10 years, the normal maintenance painting will be done.
- 2.2 The paint manufacturer shall guarantee the paint for at least 10 years.
- 2.3 Should a tenderer wish to offer coating systems other than those specified, as an alternative, he shall submit full technical details and a list comparing all appropriate details of the alternatives proposed, with the original specified.
- 2.4 Tenderers must ensure that the different coats they offer in their tenders are compatible with each other.
- 2.5 The coating of proprietary items must be done according to Clause 3.
- 2.6 All galvanized components including bolts and nuts but excluding walkway gratings, must be painted with the specified system, unless otherwise approved.

The following coating systems must be used unless otherwise specified in the main specification: -

Substrate	Coat No	Generic Description	Dry Film Thickness (mm)
3CR12 steel	1	Surface tolerant epoxy primer	65-75
	2	Two component recoatable, polyurethane finish (Gloss)	65-75
Galvanized Steel	1	Surface tolerant epoxy primer	65-75
	2	Two component recoatable, polyurethane finish (Gloss)	65-75
Mild steel	1	Two component self-curing inorganic zinc ethyl silicate OR two component zinc rich polyamide cured epoxy primer	65-75
	2	Flexible recoatable high build polyamide cured MIO epoxy	125-150
	3	Two component recoatable, polyurethane finish (Gloss)	65-75

- 2.7 The paint manufacturer's recommendations for the application of the different coating systems, curing time before handling or application of subsequent coats, health and safety recommendations etc. must be carefully adhered to.
- 2.8 Paint contractors must have a quality management system which must be submitted to the Engineer for approval before commencement of the work.

- 2.9 Galvanizing shall be done to ISO 12944-4 heavy duty hot dip galvanizing to a thickness of at least 85µm. Electroplated components in zinc or cadmium are not acceptable.
- 2.10 All mounting bolts, nuts, washers and brackets as well as all fixing bolts, studs nuts and washers, less than 12mm, shall be of stainless steel. Fixing rivets shall be of either stainless steel or brass.
- 2.11 High tensile bolts for friction grip joints must not be galvanized and must be primed and painted after installation. High tensile bolts must be certified.
- 2.12 The full paint system shall be applied to all surfaces except for wear pads, linings etc., which are to be covered with appropriate protection.
- 2.13 For steelwork which will be transported over long distances and erected on site the two pack epoxy primers is preferred.

3. PROPRIETARY ITEMS

- 3.1 Proprietary items such as gearboxes, motors, brakes etc. must either be painted according to this specification or where the coating system is equal to or exceeds this specification sufficient proof of the coating system applied must be provided. Items which are nearly equal to this specification shall be given a finishing coat according to this specification's thicknesses and final colours and to the following procedure: -
 - 3.1.1 A crosscut test must be done to ISO 2409 to determine if the original coating adheres correctly to the substrate.
 - 3.1.2 The original coating shall be rubbed down to remove any smooth finishing to form a suitable key for the finish coat and any damaged areas prepared and patch primed with a suitable primer.
 - 3.1.3 The item must then be detergent washed to remove any foreign matter, taking care that no dust, solvent etc. contaminates any working part of the item.
 - 3.1.4 A test shall be done on the existing coat to ensure that the finish coat will not react with and cause undue dissolving and lifting of the existing coat. This can be done by applying a small quantity of the finishing coat thinners.
 - 3.1.5 Should any undue dissolving or lifting occur, a suitable intermediate or barrier coat must be applied before the finishing coat is applied.
 - 3.1.6 Proprietary items which failed the crosscut test and which generally have inadequate protection shall be dismantled and the full corrosion protection specification applied.

4. SURFACE PREPARATION

- 4.1 All steel surfaces shall be detergent washed and fresh water rinsed to remove all oil, grease and surface contaminates before shot blasting.
- 4.2 Sharp edges shall be radiused and major roughness of welds shall be removed by grinding. Welding spatter and flux shall be removed.
- 4.3 Components manufactured from hot rolled steel sections and steel plate shall be blast cleaned to base metal in accordance with ISO 12944 – 4, grade SA2½ - very thorough blast cleaning, to remove all mill scale, rust, weld spatter etc.
 - 4.3.1 "Sharp" chilled iron shot, chilled iron grit, or granular abrasive slag is to be used to produce a proper degree of surface roughness.
 - 4.3.2 Blast profile shall be determined by micrometer profile gauge, Keane-Tator surface profile comparator or Testex press-o-film.

- 4.3.3 The profile height shall be between 40 and 50 μ m at any point.
- 4.4 Good quality blast cleaning and spray-painting equipment shall be used. Air used for spraying and blast cleaning shall be free from all traces of oil, water and salinity. Water and oil traps must be fitted to all equipment.
- 4.5 Wheel abrading equipment shall not be used unless an angular profile the same as clause 4.3.3 is achieved.
- 4.6 When wet blasting is done the primer shall be applied before oxidization starts or surface contamination occurs.
- 4.7 Components manufactured from 3CR12 steel shall be lightly abraded. The components shall then be passivated by using a mixture of 10 - 15% nitric acid in water which is rinsed off after 10 - 15 minutes. The surface shall be neutralized to pH 7 before it is coated.
- 4.8 Hot-dip galvanized components, galvanized bolts and nuts etc. shall be lightly abraded with a galvanizing pre-cleaner. The components shall then be washed with detergent and water and washed down with clean water until a water break free surface is achieved. Allow it to dry thoroughly.

5. JOINTS AND MATING SURFACES OF MEMBERS

- 5.1 Mating (faying) surfaces of members which have to be joined by high tensile steel bolts in friction grip shall be cleaned according to Clause 4 and painted with primer only.
- 5.1.1 After being assembled joints so formed shall be seal welded and painted or after the intermediate coat was applied the edges shall be sealed with an approved brand of paintable flexible sealant or mastic (e.g., Butyl rubber, polyurethane sealer or two component epoxy), by means of a suitable caulking gun.
- 5.2 All rivets, bolts, welds, sharp edges etc. must be covered with a "stripe coat" of the primer or intermediate coat specified to ensure the correct dry film thickness on sharp edges, as well as sealing of bolt threads to head etc.
- 5.3 All other mating surfaces must be sealed with an approved brand of flexible Butyl rubber, paintable Silicone, polyurethane sealer or two component epoxy sealer, and joined while still wet. All excess compounds must be completely removed.

6. PAINTING PROCEDURES

- 6.1 Directly before the application of paint, the area to be painted shall be degreased with a suitable degreaser and left to dry.
- 6.2 Paint shall only be applied under the following conditions: -
- 6.2.1 There is adequate light.
- 6.2.2 The steel temperature is between 5 and 50°C and at least 3°C above the dew point of the air.
- 6.2.3 The relative humidity of the air is between the limits specified by the paint supplier.
- 6.2.4 Wind does not interfere with the method used and sand and dust cannot be blown onto wet paint.
- 6.3 Steelwork shall be supported on trestles, at least 900 mm off the ground for painting purposes.
- 6.4 An adequate number of test readings shall be taken per square meter in order to determine the dry film thickness.
- 6.4.1 The paintwork shall be acceptable if the average of the test readings taken falls within or exceeds the ranges given.

- 6.4.2 Paintwork shall not be acceptable if any single test reading is less than the specified minimum thickness.
- 6.5 An ultrasonic or electronic magnetic flux thickness measurement gauge shall be used, but in case of dispute, destructive testing shall be applied. The painted steelwork shall present a clean, neat appearance of uniform colour and gloss as applicable to the paint used. Each coat of paint shall be applied as a continuous, even film of uniform thickness. More than one application of paint may be required to achieve the dry film thicknesses specified or to obliterate the colour of the previous coating.
- 6.6 The use of thinners or solvents at any stage of the work is prohibited, unless specified by the paint manufacturer.
- 6.7 Precautions shall be taken to prevent coatings from being applied to equipment nameplates, instrument glasses, signs etc.

7. COLOUR CODES

Machinery and equipment shall be painted in the following final colours: -

Area	Colour	Code No. [SABS 1091 and International No's]
Mobile equipment (cranes, loaders etc.)		
a) Structure, machinery and electrical houses, operator's cabins, chutes, hoppers etc.	Transnet White	RAL 9016 RAL 7024 (Graphite gray)
b) Undercarriage, travel rubber tyred rims bogies, Industrial buildings, structures conveyor	Transnet dark grey	SABS 1091 GO4 (Blue grey) BS 381C-633
General		
a) Guards	Golden yellow	SABS 1091-B49 RAL 1003
b) Sheaves	Orange	RAL 2008
c) Cable reels (Stainless steel)	Orange	RAL 2008
d) Machine buffers and parts of machine which could constitute a serious hazard	Golden Yellow (High Gloss) with Luminous green stripes in chevron pattern	SABS B49 and Luminous green
e) Any exposed rotating part of machinery, electrical Switchgear (other than starting and stopping devices and emergency stop control), electrical services e.g. conduit and allied fittings	Light Orange (High Gloss)	SABS 1091 B26 BS 381C-557
f) Low voltage switchgear panels	Light grey	SABS 1091-G29
where orange is not aesthetically acceptable		BS 381C-631
g) medium voltage cable trays, switchgear and motors (3,3 kV and up)	Oxford Blue	SABS FO2 BS 381C-105 RAL5003
h) Starting devices, low voltage cable trays and switchgear	Mid Brunswick green (high gloss)	BS 381C-228 SABS1091-EO4 RAL6005
i) Parts of stationary machinery (Electrical, motors, gearboxes, brakes, transformers, etc.)	Light Grey	SABS G29 BS 381C-631

Area	Colour	Code No. [SABS 1091 and International No's]
j) Hand levers, hand wheels, oiling points, handrails on walkways, ladders	Golden Yellow (High Gloss)	SABS 1091 B49 BS 381C-356
k) Stopping devices, grease points, motor fan covers and danger signs (not symbolic safety signs for which see SABS 1186)	Signal red (High Gloss)	SABS 1091 A11 BS 381C-537 RAL3001
l) Walkways (non-slip surfaces) (galvanized gratings not to be painted)	Shop floor green	
m) Informatory signs and notices (not symbolic safety signs for which see SABS 1186)	White on Emerald Green (High Gloss)	White on SABS 1091 E14 BS 381C- 228
Pipelines		
a) Reclaim water piping	Aluminium	
b. Slurry pipelines	Dark admiralty grey	SABS 1091-G12
c. Fire protection piping	Signal red	SABS 1091-A11
d. Wash water drainpipes	Light grey	SABS 1091-G29
e. Instrument air	White with Strong blue band	White and SABS 1091-F11
f. Plant air	White with Flag blue band	White and SABS 1091-FO4
g. Potable water	Grass green	SABS 1091-D14

Colour bands for pipes shall be 75 mm wide for pipe sizes up to 150 mm diameter and 100 mm wide for 150 mm and above. The colour bands shall be applied to the pipe flanges, valves, junctions, walls or structures etc. in such a manner that the pipe may be easily identifiable. On straight sections the maximum spacing shall be 100 x the pipe diameter.

8. FIELD TOUCH-UP PAINTING

8.1 Damaged and unpainted areas, fasteners, welds, etc. shall be cleaned by wire brushing with a hand tool or power tool to minimize damage to sound paint. Grinding will not be allowed. Rust spots shall be cleaned to bright metal. Thick edges of old paint abutting bare metal surfaces shall be feathered by scraping and sanding.

8.1.1 Where welding is required on areas already coated with the coating system, the coat should be stepped back for ± 30 mm around the weld area.

8.2 The paint shall be applied to match the original coats in accordance with the manufacturer's recommendations for the specific paint system.

Note: Inorganic zinc primers shall not be re-covered with an inorganic primer, but only with an organic zinc primer.

8.3 Areas of damaged galvanizing shall be repaired with an approved cold galvanizing product or metal sprayed by the wire spraying process with Zinc, and then touched up with the specific paint system.

9. GENERAL

- 9.1 All walkways, floors, maintenance platforms etc. must be painted with a durable, nonskid coating of the appropriate colour.
- 9.2 Exposed machined surfaces must be coated with a strippable corrosion inhibitor (e.g., Tectyl).
- 9.3 Where different materials will be in contact with each other, and galvanic corrosion can occur the contact areas of the materials must be isolated from each other, or the joints made waterproof to prevent ingress of moisture.
- 9.4 All components must be designed with corrosion prevention in mind and specifically the following: -
- 9.4.1 No entrapment of dirt, product, moisture etc.
 - 9.4.2 No areas must be inaccessible for maintenance such as too narrow gaps etc.
 - 9.4.3 Large flat areas rather than complicated shapes and profiles.
 - 9.4.4 No sharp corners and discontinuous welds.
- 9.5 Parts of equipment which are exposed to high temperatures must be coated with the following system: -

Coat No	Generic Description	Dry Film Thickness (mm)
1	Two component self-curing inorganic zinc ethyl silicate	65-75
2	Single component high temperature moisture curing silicone with aluminium flakes	40

10. MAINTENANCE PAINTING OF STRUCTURES

- 10.1 Areas which are only lightly corroded must be cleaned by means of high-pressure water blasting or wire brushing by power tool and the following system applied: -

Coat No	Generic Description	Dry Film Thickness (mm)
1	Surface tolerant two pack epoxy primer with aluminium pigments	125-150
2	Same as first coat OR micaceous iron oxide (MIO) epoxy	125-150
3	Two component recoatable, polyurethane finish (Gloss)	65-75

- 10.2 Alternatively, the Noxyde paint system can be used, consisting of two to three coats of water based Noxyde paint to achieve a DFT of 350 to 400 microns. Where the Noxyde system is used on areas other than slightly corroded structural areas, the following additional requirements must be observed:

10.2.1 Very smooth surfaces (e.g., 3CR12, stainless steel or hot-dip galvanized components, bolts, nuts and fittings, and HT bolts): Parts must be thoroughly degreased using OptiDegreaser, washed down with potable water, and immediately when dry, a single coat of OptiPrimeAqua applied.

10.2.2 Paintable flexible sealant/mastic: Only sealant approved by the paint manufacturer may be used, and an initial coat of OptiPrimeAqua applied over it before the further coats of Noxyde are applied.

10.2.3 Bolted/riveted connections: After blasting or and/or cleaning as required, apply a coat of OptiPrimeAqua and an additional stripe coat of Noxyde, in contrasting colour, to all bolt/nut and plate edges and crevices.

- 10.3 The adhesion of old coatings must be verified by doing a crosscut adhesion test on selected areas.
- 10.4 The compatibility of the new paint system on the old coating must be tested and guaranteed in writing by the paint supplier.
- 10.5 The work and coating system must be guaranteed for a minimum of 12 months.
- 10.6 All heavily corroded areas must be shot blasted to minimum SA2 and the three-coat system indicated in clause 2.6 applied.
- 10.7 Areas where the old coating is still sound need only be high pressure cleaned with a suitable solvent and coated with one of the primers suggested in clause 10.3 (as tie coat) and then with one of the topcoats suggested in clause 2.6 to get the appropriate colour and finish. The minimum dry film thickness of this tie coat must be 75 microns and topcoat must be 50 microns, but the previous coating colour shall be completely obliterated to present a uniform colour.

Note: Inorganic zinc primers shall not be re-covered with an inorganic primer, but only with an organic zinc primer.

- 10.8 Repairs to the insides of all the enclosed sections of the booms as well as the insides of the crane legs, sill beams, cross beams, pylon cross bracing members etc. shall be done as above but the topcoat need not be applied.