

Anhui Hangxiao Steel Structure Company Painting Solution for Iraq Abu

Al Khaseeb Hospital Project

1. Rust removing of Steel Components

1.1 The primer of this project is Barrier 80 .epoxy zinc rich primer, Red, The thickness of the film: $60 \mu\text{m}$;

Intermediate coat: Penguard Middle coat MIO DFT 120.epoxy intermediate paint, gray, the thickness of the film: $120 \mu\text{m}$.

Top coat: Hardtopxp STDO 38. Aliphatic polyurethane surface paint, gray, The thickness of the film: $60 \mu\text{m}$;

According to the grades of derusting paint adaptability, Descaling grade must achieve or above Sa2.5.

1.2 Before polishing procedure of the steel components, the oil, grease, welding slag, spatter dust scale must be cleared from the surface of components.

1.3 After the procedure of polishing, commonly within 4 to 6 hours, the first primer coating will be done to prevent rust. If rust before primer has return, must make a new polishing procedure.

1.4 The diameter of steel shot used for polishing procedure is $\phi 0.5\text{--}2\text{mm}$, Pellet dry clean, not sticky oil, dirt grease, etc on the surface.

1.5 In the connection area of high strength bolts, there is special anti-skip factor. When the first shot inspection is unqualified, we will shot again or manual polishing to ensure the quality of rust removal and the slip.

1.6 In order to remove surface dust, iron pills and dust around the corner Air blowing method will be applied after polishing, special technology process will be applied for barrel shape components which is easy to set steel shot or dust before polishing process.

2. The paint of steel components

2.1 The preparation before painting.

2.1.1 All coating which will be used for painting should have qualified certificate, mix ratio description and other warranty date, unqualified coating will be rejected.

2.1.2 After components polishing procedure inspection, we can start the paint process, paint type, brush times, dry and wet film thickness should follow the engineering drawings requirements.

2.1.3 There is no water, oil, grease, sand, steel shot and dust, footprints, welding spatter and other on the surface of steel components.

2.1.4 Polishing procedure finish more than 6 hours, steel components can not spray paint and must be shot again.

2.2 Spraying of the steel components

2.2.1 For primer painting procedure, the thickness of wet film for first spraying