

SSPC: The Society for Protective Coatings

PAINTING SYSTEM NO. 1.12

Three-Coat Oil Base Zinc Chromate Painting System

1. Scope

1.1 This specification covers an oil base, zinc chromate painting system for steel cleaned with hand or power tools.

1.2 This system is suitable for use on parts or structures exposed in Environmental Zone 1A (interior, normally dry) and Zone 1B (exterior, normally dry).

1.3 The finish paint allows for a choice of durable, fade-resistant colors.

2. Description

2.1 This painting system consists of surface preparation by solvent cleaning and hand or power tool cleaning, one coat of zinc chromate linseed oil/alkyd primer, and two coats of alkyd white or tinted finish coat.

3. Reference Standards

3.1 The standards referenced in this guide are listed in Section 3.4 and 3.5 and form a part of the specification.

3.2 The latest issue, revision, or amendment of the reference standards in effect on the date of invitation to bid shall govern unless otherwise specified.

3.3 If there is a conflict between the requirements of any of the cited reference standards and the specification, the requirements of the specification shall prevail.

3.4 SSPC STANDARDS AND JOINT STANDARDS:

PA 1	Shop, Field, and Maintenance Painting of Steel
PA 2	Measurement of Dry Coating Thickness With Magnetic Gages
PA Guide 4	Guide to Maintenance Repainting with Oil Base or Alkyd Painting Systems
Paint 11*	Red Iron, Zinc Chromate, Raw Linseed Oil and Alkyd Primer
Paint 101	Aluminum Alkyd Paint
Paint 104	White or Tinted Alkyd Paint
Paint 108	High-Build Thixotropic Leafing Aluminum Paint
SP 2	Hand Tool Cleaning

SP 3	Power Tool Cleaning
SP 5/NACE No. 1	White Metal Blast Cleaning
SP 6/NACE No. 3	Commercial Blast Cleaning
SP 7/NACE No. 4	Brush-Off Blast Cleaning
SP 8	Pickling
SP 10/NACE No. 2	Near-White Blast Cleaning

3.5 AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM) STANDARD:

D 3925	Practice for Sampling Liquid Paints and Related Pigmented Coatings
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4. Surface Preparation

4.1 SSPC-SP 2, "Hand Tool Cleaning," or SSPC-SP 3, "Power Tool Cleaning." If specified in the procurement documents, blast cleaning or pickling shall be substituted (SSPC-SP 5, 6, 7, 8, or 10).

5. Paints

5.1 **PRIMER:** SSPC-Paint 11*, "Red Iron Oxide, Zinc Chromate, Raw Linseed Oil and Alkyd Primer."

5.2 **INTERMEDIATE (SECOND COAT):** SSPC-Paint 104, "White or Tinted Alkyd Paint," tinted with carbon black or lampblack dispersion to a color contrasting with that of the finish paint.

5.3 **FINISH COAT:** SSPC-Paint 104, "White or Tinted Alkyd Paint." The color must be specified.

5.4 **ALTERNATIVE FINISH COAT:** If specified in the procurement documents, a finish coat complying with specification SSPC-Paint 101, "Aluminum Alkyd Paint, Leafing (Type I)," shall be applied in place of the standard finish coat. If this alternative finish coat is used, then the intermediate coat shall consist of one coat of SSPC-Paint 101, "Alkyd Aluminum Paint, Non-Leafing (Type II)."

5.5 **ALTERNATIVE FINISH COAT:** If specified in the procurement documents, a finish coat complying with specification SSPC-Paint 108, "High-Build Thixotropic Leafing Aluminum Paint" shall be applied in place of the standard finish coat. If this alternative finish coat is used, then no intermediate coat shall be required, but the dry film thick-

ness shall not be less than 64 micrometers (2.5 mils) for the finish coat and 114 micrometers (4.5 mils) for the painting system.

6. Paint Application

6.1 PAINT APPLICATION: Follow requirements SSPC-PA 1, "Shop, Field, and Maintenance Painting of Steel."

6.2 TOUCH-UP PAINTING: In accordance with specification SSPC-PA 1, "Shop, Field, and Maintenance Painting of Steel" and in particular with the section thereof entitled "Field Painting."

6.3 MAINTENANCE PAINTING: The provisions of SSPC-PA Guide 4, "Guide to Maintenance Repainting with Oil Base or Alkyd Painting Systems" should be followed.

6.4 NUMBER OF COATS: Minimum of three.

6.5 DRY FILM THICKNESS OF PAINT SYSTEM: Not less than the following as measured in accordance with SSPC-PA 2, "Measurement of Dry Coating Thickness with Magnetic Gages": primer 50 micrometers (2.0 mils); intermediate coat 38 micrometers (1.5 mils); finish coat 25 micrometers (1.0 mil); for the three-coat painting system 114 micrometers (4.5 mils). If an alternative finish coat is used as indicated in Section 5.5, see that section for dry film thickness requirements.

7. Inspection

7.1 All work and materials supplied under this specification are subject to timely inspection by the purchaser or his authorized representative. The contractor shall correct such work or replace such material as is found defective under this specification. (See Note 9.1.) In case of dispute, unless otherwise specified, the arbitration or settlement procedure established in the procurement documents shall be followed. If no arbitration procedure is established, the procedure specified by the American Arbitration Associa-

tion shall be used.

7.2 Samples of paints under this painting system may be requested by the purchaser and shall be supplied upon request along with the manufacturer's name and identification for the materials. Samples may be requested at the time the purchase order is placed, or may be taken from unopened containers at the job site.

7.3 Unless otherwise specified, the sampling shall be in accordance with ASTM D 3925.

8. Disclaimer

8.1 While every precaution is taken to ensure that all information furnished in SSPC standards and specifications is as accurate, complete, and useful as possible, SSPC cannot assume responsibility nor incur any obligation resulting from the use of any materials, coatings, or methods specified herein, or of the specification or standard itself.

8.2 This specification does not attempt to address problems concerning safety associated with its use. The user of this specification, as well as the user of all products or practices described herein, is responsible for instituting appropriate health and safety practices and for insuring compliance with all governmental regulations.

9. Note

Notes are not a requirement of this specification.

9.1 The procurement documents should establish the responsibility for samples, testing, and any required affidavit certifying full compliance with the specification.

* This paint contains chromate pigments. Users are urged to follow all health, safety, and environmental requirements in applying, handling or disposing of these materials.