



LOW BUILD TWO-PACK EPOXY COATING FOR THE LONG-TERM PROTECTION OF STEEL

1 SCOPE

This specification applies to catalysed epoxy coating systems with total dry film builds up to approximately 200µm, for application to steel structures on which optimum surface preparation can be achieved.

2 BACKGROUND

- To obtain a broad overview of the Australian Paint Approval Scheme (APAS), refer to APAS document AP-D001.
- To obtain an overview of restricted ingredients in APAS certified products, refer to APAS document AP-D123.
- To obtain the current list of APAS participating manufacturers (and suppliers) and resellers, refer to APAS document AP-D152.
- To obtain an overview of how to participate in the APAS, refer to APAS document AP-D177.
- APAS approval to this specification may be gained by compliance with the requirements detailed in this specification and those in APAS document AP-D192.

3 DESCRIPTION AND GUIDE FOR USERS

3.1 General Requirements

- This specification applies to catalysed epoxy coating systems with total dry film builds up to approximately 200µm, for application to steel structures on which optimum surface preparation can be achieved.
- The systems are intended to provide a service life in excess of 10 years under Category C3 (Medium) atmospheric corrosivity conditions (refer AS 2312.1) or in situations where frequent maintenance is impractical.
- Systems approved under this specification, while generally approved for atmospheric exposure, may also have the following approvals: Fresh Water and Salt Water immersion.
- Where surface preparation is likely to be marginal and surface tolerant coatings are required, reference should be made to APAS specification AP-S0156.

3.2 Sub-Classes

- This specification incorporates the following subclasses:
 - 2972:** For atmospheric exposure
 - 2972F:** For fresh water immersion
 - 2972S:** For salt water immersion

3.3 Basis of this Specification

- This specification is based on AS/NZS 3750.10, with the following modifications:
 - Increase in exterior durability requirements from 48 to 72 months
- Paints approved under this specification are referenced as Paint Reference Number (PRN) C24 of AS 2312.1.

4 REFERENCED DOCUMENTS

- The following standards are referenced in this document:
 - AS/NZS 1580** – Paints and related materials: Methods of test
 - AS 2312.1** – Guide to the protection of structural steel against atmospheric corrosion by the use of protective coatings – Part 1: Paint Coatings
 - AS/NZS 3750.10** – Paints for steel structures – Part 10: Full gloss epoxy (two-pack)

These documents may be purchased through the Reference Standards Australia website:

<https://www.standards.org.au/>

- The Poisons Standard June 2021:** Standard for the Uniform Scheduling of Medicines and Poisons (SUSMP) No. 33, Part 2: Control on Medicines and Poisons, Section Seven / Appendix I Paint or Tinters

This document is available from the Australian Government Federal Register of Legislation website at:
<https://www.legislation.gov.au/Details/F2021L00650>

- The following APAS documents are referenced in this document:
 - AP-D001 Rules Governing How APAS® Operates
 - AP-D123 Restrictions on Ingredients in Product Formulations
 - AP-D152 APAS® Participating Manufacturers and Resellers
 - AP-D177 Rules Governing How Product Manufacturers participate in APAS®
 - AP-D181 Volatile Organic Compounds (VOC) Limits
 - AP-D192 Rules Governing APAS® Product Certification Scheme
 - AP-S0156 Epoxy Mastic High Build Two-Pack Coating for Rusted Steel

All APAS documents are available for download from the APAS website: <https://vs.csiro.au/apas/documents/>

All APAS specifications are available for download from the APAS website: <https://vs.csiro.au/apas/specifications/>

5 COMPOSITIONAL REQUIREMENTS

5.1 Binder

- Typically, the binder will be a catalysed epoxy binder, polyamide, amine adduct or other hardeners.

5.2 Volatiles

- The volatile portion shall be typically comprised of hydrocarbons.
- For VOC content restrictions, refer to APAS document AP-D181.



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5.3 Pigmentation

- a) The pigmentation shall be chosen to impart the properties detailed in clause 7, Table 1 below.

5.4 Colour

- a) Products approved under this specification are normally available in a limited range of colours.
- b) The early chalking and loss of gloss characteristic of epoxies on exterior exposure may detract from the decorative properties but not from the protective properties of the product.

6 PRODUCT APPROVAL REQUIREMENTS

6.1 General Requirements

- a) The product and its application for approval shall comply with the relevant requirements of APAS document AP-D192 during the life of the approval.

6.2 Technical Requirements

- a) The product shall comply with **all** the requirements of clause 7, Table 1 below.

6.3 Health and Safety Requirements

- a) The manufacturer's Safety Data Sheet (SDS) must be studied closely prior to using the product and complied with during use of the product.
- b) As products covered by this specification principally contain solvents, the paint is considered flammable and should be stored away from all sources of heat or ignition.
- c) Containers should be resealed immediately after use and good ventilation provided during use to minimise the risk of fire or explosion and the long-term toxic effects of absorption of the vapour into the lungs.
- d) Care should be taken to avoid contact with the skin using protective clothing and barrier cream. All pumping equipment should be adequately earthed. It is anticipated that most of these products would be applied by operators in well ventilated spray booths or in the field by operators with adequate safety equipment.
- e) Products intended for sale in Australia shall comply with all the requirements of the SUSMP. Products intended for sale in other countries shall comply with all local WHS and environmental requirements.
- f) The product shall comply with all requirements of clause 6.3 and 6.4 of APAS document AP-D192.



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7 TABLE 1: PERFORMANCE PROPERTIES

TEST	AS/NZS 1580 METHOD	REQUIREMENTS										
General Requirements	AS/NZS 3750.10	<p>Shall comply with all the requirements of clause 2 Materials Requirements, with the exception of clause 2.5.10 where 48 months shall be replaced by 72 months as detailed below.</p> <p>All results shall be reported.</p> <p>NOTE: Other tests listed below are in addition to these requirements.</p>										
Non-volatile Content by Volume	301.2	Minimum 50%.										
Thinning or Mixing Properties	208.1	Using 10% of manufacturers recommended thinner, there shall be no signs of incompatibility.										
Viscosity	214.x	State method and record results.										
Application of Aged Sample	AS/NZS 3750.10 2.5.1 2.5.2 2.5.3	<p>A sample of the product which has been stored at routine conditions for 12 months shall produce a uniform finish typical of the product type when applied by spray. The sprayed film shall still comply with the requirements of:</p> <p>Surface Dry Time: < 3 hours Hard Dry Time: < 18 hours Curing Properties: > 1.5 kg</p>										
VOC Content	APAS AP-D181	<p>Refer to APAS document AP-D181 for method and limits.</p> <p>If the APAS specification is not listed on AP-D181, a declaration of VOC content is still required.</p>										
Resistance to Natural Weathering	AS/NZS 3750.10 clause 2.5.10 457.1 (Cat 1) 481.1.7 481.1.8 481.1.9 481.1.10 481.3	<p>After 72 months exposure at all 3 exterior atmospheric exposure sites (listed in APAS document AP-D192, clause 12), the coating shall show no integrity failure i.e. at the end of 6 years, the ratings shall be:</p> <table border="0"> <tr> <td>Checking</td> <td>0</td> </tr> <tr> <td>Cracking</td> <td>0</td> </tr> <tr> <td>Blistering</td> <td>0</td> </tr> <tr> <td>Flaking and Peeling</td> <td>0</td> </tr> <tr> <td>Corrosion</td> <td>0</td> </tr> </table>	Checking	0	Cracking	0	Blistering	0	Flaking and Peeling	0	Corrosion	0
Checking	0											
Cracking	0											
Blistering	0											
Flaking and Peeling	0											
Corrosion	0											
Resistance to Immersion 2972F and 2972S only	481.1.7 481.1.8 481.1.9 481.1.10 481.3	<p>After 72 months immersion at the site appropriate to the approval application (listed in APAS document AP-D192, clause 12), the ratings for the coating shall be:</p> <table border="0"> <tr> <td>Checking</td> <td>0</td> </tr> <tr> <td>Cracking</td> <td>0</td> </tr> <tr> <td>Blistering</td> <td>0</td> </tr> <tr> <td>Flaking and Peeling</td> <td>0</td> </tr> <tr> <td>Corrosion</td> <td>1</td> </tr> </table>	Checking	0	Cracking	0	Blistering	0	Flaking and Peeling	0	Corrosion	1
Checking	0											
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8 APPENDIX A

Document History

Status: Current
Version: 11
Date Published: 02-09-2021

Document Version No.:	Date Published:	Summary of Changes:
11	02-09-2021	<ul style="list-style-type: none">• General format changes• Updated background information in clause 2• Updated SUSMP information• Updated APAS website information
10	23-12-2020	<ul style="list-style-type: none">• Addition of Appendix A Document History and removal of the Editorial Note previously used in specification versions• Updated document to the current format• Updated internal and external document references• Inclusion of VOC Content requirement to Table 1 Performance Properties• Addition of "People + Product = Protection" to Footer
9	10-12-2003	<ul style="list-style-type: none">• Removed reference to GPC and incorporated a general format update
8	13-09-2001	<ul style="list-style-type: none">• Aligned naming conventions with Australian Standards
7	10-04-2001	<ul style="list-style-type: none">• Initiated the second stage of the move to new specification numbering with prominence given to the new number (Old specification number: GPC-C-29/7 Type 2).