



AP-S2974

## Australian Paint Approval Scheme (APAS)

### Medium build solventless two-pack epoxy coating for the long-term protection of steel

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# 1. Scope

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- a. This specification applies to solventless catalysed epoxy coating systems with total dry film builds up to approximately 400µm, for application to steel structures on which optimum surface preparation can be achieved.

# 2. Background

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- a. To obtain:
  - i. a broad overview of the Australian Paint Approval Scheme (APAS), refer to APAS document AP-D001.
  - ii. an overview of restricted ingredients in APAS certified products, refer to APAS document AP-D123.
  - iii. the current list of APAS participating manufacturers and resellers, refer to APAS document AP-D152.
  - iv. an overview of how to participate in the APAS, refer to APAS document AP-D177.
- b. 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

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## 3.1. General requirements

- a. This specification applies to solventless catalysed epoxy coating systems with total dry film builds up to approximately 400µm, for application to steel structures on which optimum surface preparation can be achieved.
- b. 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.
- c. Systems approved under this specification, while generally approved for atmospheric exposure, may also have the following approvals: fresh water immersion, salt water immersion and potable water immersion.
- d. Where surface preparation is likely to be marginal and surface tolerant coatings may be required, reference should be made to APAS specification AP-S0156 or AP-S2977.

## 3.2. Sub-classes

- a. This specification incorporates the following subclasses:
  - i. **2974:** for atmospheric exposure;
  - ii. **2974F:** for fresh water immersion;
  - iii. **2974P:** for potable water immersion;
  - iv. **2974S:** for salt water immersion.

## 3.3. Basis of this specification

- a. This specification is based on AS/NZS 3750.14, with the following modification:
  - i. Increase in exterior durability requirements from 48 to 72 months, and
  - ii. decrease in hard dry time requirements from 48 hours to less than 18 hours.

## 4. Referenced documents

a. The following standards are referenced in this document:

- i. **AS/NZS 1580** – Paints and related materials: Methods of test
- ii. **AS 2312.1** – Guide to the protection of structural steel against atmospheric corrosion by the use of protective coatings – Part 1: Paint Coatings
- iii. **AS/NZS 3750.14** – Paints for steel structures – Part 14: High-build epoxy (two-pack)
- iv. **AS/NZS 4020** – Testing of products for use in contact with drinking water
- v. **ISO/IEC 17025** – General requirements for the competence of testing and calibration laboratories

These documents may be purchased through the [Reference Standards Australia website](#).

vi. **Therapeutics Goods (Poisons Standard - June 2025) Instrument 2025**

This document is available from the Australian Government Federal Register of Legislation website: [Therapeutic Goods \(Poisons Standard—June 2025\) Instrument 2025 - Federal Register of Legislation](#).

b. The following APAS documents are referenced in this document:

- i. AP-D001 Rules Governing How APAS® Operates
- ii. AP-D123 Restrictions on ingredients in product formulations
- iii. AP-D152 APAS® Participating Manufacturers and Resellers
- iv. AP-D177 Product manufacturers participation in APAS®
- v. AP-D181 Volatile Organic Compounds (VOC) Limits
- vi. AP-D192 APAS® Product Certification
- vii. AP-S0156 Epoxy mastic high build two-pack coating for rusted steel
- viii. AP-S2977 Slow drying / high volume solids two-pack epoxy mastic coating for the long-term protection of steel

All APAS documents are available for download from the [documents section](#) of the APAS website.

All APAS specifications are available for download from the [specification section](#) APAS website.

## 5. Compositional requirements

### 5.1. Binder

a. The binder will be typically, but is not limited to, a catalysed epoxy binder with polyamide, amine adduct or other hardeners.

### 5.2. Volatiles

- a. The volatile portion shall be comprised of typically, but is not limited to, hydrocarbons.
- b. For VOC content restrictions, refer to APAS document AP-D181.

### 5.3. Pigment

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 only 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

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### 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. 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.
- c. 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.
- d. Products intended for sale in Australia shall comply with all the requirements of the **Therapeutics Goods (Poisons Standard - June 2025) Instrument 2025**. Products intended for sale in other countries shall comply with all local WHS and environmental requirements.
- e. The product shall comply with all requirements of clause 5.3 and 5.4 of APAS document AP-D192.

## 7. Performance properties

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- a. Refer to Table 1: Performance properties.

**Table 1:** Performance properties

Test	AS/NZS method	Requirements
General requirements	3750.14	Shall comply with <b>all</b> the requirements of <b>clause 2 Material Requirements</b> , with the exception of clause 2.5.8 where 48 months shall be replaced by <b>72 months</b> as detailed below and clause 2.5.1 where hard-dry time shall be <b>less than 18 hours</b> . <b>All</b> results shall be reported.  <b>NOTE:</b> Other tests listed below are in addition to these requirements.
Non-volatile content by volume	1580.301.2	≥ 98%. Report all results.
Thinning or mixing properties	1580.208.1	Using 10% of manufacturers recommended thinner, there shall be no signs of incompatibility. Report all results.
Viscosity	1580.214.x	State method and report all results..
Application of aged sample	3750.14  Clauses 2.5.1 2.5.2	A sample of the product which has been stored at routine conditions for <b>12 months</b> shall produce a uniform finish typical of the product type when applied by spray. Reporting all results, the sprayed film shall still comply with the requirements of:  Hard dry time: < 18 hours Curing properties: > 1.5 kg
Specular gloss (60°)	1580.602.2	Report all results.
VOC content	APAS AP-D181	Refer to APAS document AP-D181 for method and limits.  If the APAS specification is not listed on AP-D181, a declaration of VOC content <b>is still required</b> . Report all results.
Resistance to natural weathering  <b><u>2974 and 2974S only</u></b>	3750.14 clause 2.5.8; 1580.457.1  1580.481.1.7 1580.481.1.8 1580.481.1.9 1580.481.1.10 1580.481.3	Reporting all results, after <b>72 months</b> exposure at all 3 atmospheric exposure sites (listed in APAS document AP-D192, clause 11), the coating shall show no integrity failure i.e. at the end of 6 years, the ratings shall be:  Checking 0 Cracking 0 Blistering 0 Flaking and Peeling 0 Corrosion 0
Resistance to immersion - salt and fresh water  <b><u>2974F and 2974S only</u></b>	1580.457.1  1580.481.1.7 1580.481.1.8 1580.481.1.9 1580.481.1.10 1580.481.3	Reporting all results, after <b>72 months</b> immersion at the site appropriate to the approval application (listed in APAS document AP-D192, clause 11), the ratings for the coating shall be:  Checking 0 Cracking 0 Blistering 0 Flaking and Peeling 0 Corrosion 1
Resistance to immersion - potable water  <b><u>2974P only</u></b>	4020	For potable water approval, the product shall pass the <b>Resistance to Immersion – Fresh Water</b> requirements detailed above.  In addition, a potable water compliance certificate, as detailed in Appendix A, shall be provided. Report all results.

## Appendix A Guidelines for approval of coating systems for use in potable water

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- a. APAS requires that all products intended for use in contact with potable water shall be approved for such an end use by an appropriate authority.
- b. Such approval is indicated by having a suffix **P** after the specification number e.g. AP-S2974P. The issued certificate of product approval will clearly identify the appropriate exposure condition.
- c. An ISO/IEC 17025 endorsed test report (NATA in Australia) from an approved authority indicating compliance with *AS/NZS 4020 Testing of Products for use in contact with drinking water* – refer below for an approved testing authority. The testing authority shall have under its ISO/IEC 17025 Scope of Accreditation all applicable test methods from AS/NZS 4020.

**NOTE:** Attention shall be given to the ratio of surface area to volume at which products comply. The specified ratio of surface area to volume in the test certificate shall be equal to or greater than the actual structure ratio of surface area to volume applicable in service.

- d. In Australia, the APAS recognised testing laboratory for AS/NZS 4020 is:

**Australian Water Quality Centre (AWQC)** – Business Unit of the South Australian Water Corporation (SA Water)

NATA Accreditation No. 1115

250 Victoria Square

ADELAIDE, South Australia, 5000

Direct Lab Number: (08) 7424 1512

General Enquiries: [producttesting@awqc.com.au](mailto:producttesting@awqc.com.au)

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- e. Following any changes to the ingredients of the formulation or to the source of raw materials, the product shall be retested to confirm continued compliance with the Standard. The new certificate of compliance shall form part of the re-submission to APAS as required by APAS document AP-D192.

## Appendix B Document Review

Version: 10

Issued date: 1/09/25

Authorised by: Arman Namvar, Executive Officer APAS

Document version no:	Issued date:	Change description:
10	01/09/2025	<ul style="list-style-type: none"> <li>• <b>Full technical review</b> by Australasian Corrosion Association (ACA), Surface Coatings Association Australia (SCAA) and APAS. Updates include alignment with AS/NZS 3570.14 with modification of requirement (decrease in hard-dry time requirement from &lt; 48h to &lt; 18h, clause 3.3 a. ii. and clause 7 Table 1); inclusion of NVCV; resistance to natural weathering requirements revised for all sub-classes; addition of NOTE to Appendix A c.; format update and minor editorial changes</li> </ul>
9	02/09/2021	<ul style="list-style-type: none"> <li>• General format changes</li> <li>• Updated background information in clause 2</li> <li>• Updated SUSMP information</li> <li>• Updated APAS website information</li> </ul>
8	23/12/2020	<ul style="list-style-type: none"> <li>• Addition of Appendix B Document History and removal of the Editorial Note previously used in specification versions</li> <li>• Updated document to the current format</li> <li>• Updated internal and external document references (including current AWQC information)</li> <li>• Inclusion of VOC Content requirement to Table 1 Performance Properties</li> <li>• Addition of "People + Product = Protection" to Footer</li> </ul>
7	10/12/2003	<ul style="list-style-type: none"> <li>• Removed reference to GPC and incorporated a general format update</li> </ul>
6	10/04/2001	<ul style="list-style-type: none"> <li>• 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 4)</li> </ul>