Painting Steel

It is important to prepare the steel surface correctly before the application of an anticorrosion paint system. This can be in the form of an Epoxy coating system, or a one –component anticorrosion system. In either type of paint systems, good surface preparation will realise the full anticorrosive protection and prolong the life of a coating system.

There are number of common causes that can reduce the life of the coating which include, surface contamination, weld cracks & splatter, sharp edges, presence of mill scale and many more. Before the application of a paint system, it is recommended that the substrate is inspected, and any defects cured. When it comes to choosing a protective coating system for your boat, and you are unsure consult with Skipper's Line technical representatives, who will be able to offer advice and recommendation about which coating system to use and about surface preparation. The details below give a basic guide to surface preparation and application.

Surface Preparation - Bare Steel

The steel surface should be free from rust, corrosion and traces of oils, salt, and other contamination. It is recommended that the surface is degreased and cleaned with a suitable product. After the surface has been cleaned, it is recommended to prepare the surface by shot/grit blasting. The surface preparation should be carried out by adequately shot/grit blasting in accordance to SA2.5 standard. If it is not possible to carry out grit blasting, then it will be necessary to prepare the surface by using grinders, wire brushing or mechanical sanding, to remove any traces of rust from the substrate before the application of a protective coating system.

If the substrate has been shot/grit blasted, the recommended coating system for below and above the water line in either a one or two component system should then be applied. It is important to following the products application guide.

Previously Coated Surfaces - Topsides and below the water line

If the existing paint is in good condition and there is no rust, cracking or blistering within current coating system, It is recommended to thoroughly clean, degrease and sand papering the coated surface with a medium-fine abrasive paper (P180-240) All dust and sanding residues should be thoroughly removed from the substrate surface. After suitable preparation has been carried out it will be suitable to apply your preferred coating, protective/epoxy coating, Topcoats, or antifouling.
If the existing coating is in poor condition, with rust showing, paint flaking, cracking, with any loss of adhesion from the substrate it is recommended to remove the old coating by mechanically sanding, shot/grit blasting or with a remover to prepare the substrate as described for bare substrate.

One-Component Indicative Coating Systems

1. Bottom Coating System – Below Waterline

No of Coats	Product Name	Thinner		Coverage (m2/Lt)	Recoating (at 20˚C)
2	**Cromominio AT** Primer	15-25% Brush 107	15-30% Spray 107	7-9	24 hours
2	**Solver Primer**/intermediate coat	10-25% Brush 400	15-30% Spray 400	4-6	Min 6 hours
2	**Standard Plus** Antifouling	Max 5% Brush 400	10% Spray 400	10-12	18-24 hours

2. Bottom Coating System – Below Waterline

No of Coats	Product Name	Thinner		Coverage (m2/Lt)	Recoating (at 20˚C)
2-4	**Solver Primer**	10-25% Brush 400	15-30% Spray 400	4-6	Min 6 hours
2	**Standard Plus** Antifouling	Max 5% Brush 400	10% Spray 400	10-12	18-24 hours

3. Topside Coating System – Above Waterline

No of Coats	Product Name	Thinner		Coverage (m2/Lt)	Recoating (at 20˚C)
2	**Cromominio AT Primer**	15-25% Brush 107	15-30% Spray 107	7-9	24 hours
2	**Solver Primer**/intermediate coat	10-25% Brush 400	15-30% Spray 400	4-6	Min 6 hours
1-2	**Sottofondo** Undercoat	10-20% Brush 107	20-30% Spray 900	9-10	18-24 hours
2	**Topkapi Finish** Yacht Paint or **Topkapi Satin** Yacht Paint	10-20% Brush 107/109 10-20% Brush 107/109	10-25% Spray 900 10-25% Spray 900	11-13 11-13	18-24 hours 18-24 hours

Two-Component Indicative Coating Systems

1. Bottom Coating System – Below Waterline					
No of Coats	**Product Name**	**Thinner**		**Coverage (m2/Lt)**	**Recoating (at 20˚C)**
2-6	**Epofond AM/9** Epoxy Primer	10-15% Brush 765	15-25% Spray 765	8-9	12-24 hours
2	**Solver Primer**/intermediate coat	10-25% Brush 400	15-30% Spray 400	4-6	Min 6 hours
2	**Standard Plus** Antifouling	Max 5% Brush 400	10% Spray 400	10-12	18-24 hours

2. Topside Coating System – Above Waterline					
No of Coats	**Product Name**	**Thinner**		**Coverage (m2/Lt)**	**Recoating (at 20˚C)**
2-3	**Epofond AM/9** Epoxy Primer	10-15% Brush 765	15-25% Spray 765	8-9	12-24 hours
2-3	**Polifond** Undercoat	15-30% Brush 205	25-35% Spray 203	14-15	12-24 hours
2	**Acriglass Finish** Yacht Paint	15-25% Brush 205	20-35% Spray 203	10	24 hours
	or				
	Space Top Pro Finish Yacht Paint	20-30% Brush 205/201	20-35% Spray 205/201	13-14	18-24 hours
	or				
	Whitext Bucciato Textured Finish	5-10% Brush 205	5-10% Spray 203	5-6	24 hours

Note: *The product information is a general overview to help when deciding which product to use. Please see the product's technical data sheet for specific information.*