

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 types of paint systems, good surface preparation will realise the full anticorrosive protection from the system 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 application of Skipper’s Line Epozinc (zinc-rich, cold galvanising primers) is recommended, giving a high quality anticorrosive barrier. The recommended coating system for below and above the water line in either one or two component 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 such as Skipper’s Line Svernigraf, proceeding to prepare the substrate as described for bare substrate.

One-Component Indicative Coating Systems

1. Bottom Coating System – Below Waterline

| No Coats | Product Name | Thinner | | Coverage (m ² /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 Coats | Product Name | Thinner | | Coverage (m ² /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 Coats | Product Name | Thinner | | Coverage (m ² /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 or Sintolin Yacht Paint | 10-20% Brush 107/109 | 10-25% Spray 900 | 11-13 | 18-24 hours |
| | | 10-20% Brush 107/109 | 10-25% Spray 900 | 11-13 | 18-24 hours |
| | | 5-15% Brush 107 | 15-20% Spray 900 | 8-10 | 18-24 hours |

Two-Component Indicative Coating Systems

1. Bottom Coating System – Below Waterline

| No Coats | Product Name | Thinner | | Coverage (m ² /Lt) | Recoating (at 20°C) |
|----------|---------------------------------|------------------|------------------|-------------------------------|---------------------|
| 1* | Epozinc 2C Zinc Rich Primer | 10-15% Brush 765 | 25-30% Spray 765 | 13 | 12 hours |
| 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 |

* if sandblasting takes place you can use Epozinc 2C primer for high anticorrosive protection

2. Topside Coating System – Above Waterline

| No Coats | Product Name | Thinner | | Coverage (m ² /Lt) | Recoating (at 20°C) |
|----------|--|----------------------|----------------------|-------------------------------|---------------------|
| 1* | Epozinc 2C Zinc Rich Primer | 10-15% Brush 765 | 25-30% Spray 765 | 13 | 12 hours |
| 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 or Space Top Pro Finish Yacht Paint or Whitext Bucciato Textured Finish | 15-25% Brush 205 | 20-35% Spray 203 | 10 | 24 hours |
| | | 20-30% Brush 205/201 | 20-35% Spray 205/201 | 13-14 | 18-24 hours |
| | | 5-10% Brush 205 | 5-10% Spray 203 | 5-6 | 24 hours |

* if sandblasting takes place you can use Epozinc 2C primer for high anticorrosive protection

Note: The information is given to the best of our knowledge, and not intended to be exhaustive. But since the conditions of use of our products are beyond our control, no warranty is given or to be implied in respect of such information. We are, at all times, willing to study customer specific requirements involving our products in order to enable their most effective use. Dilution rates and drying times are to be considered only indicative, based on a temperature of 20°C (68°F), and may be subject to changes according to prevailing temperature, in presence of particular weather conditions or due to application procedures that may be effective at time of application. This information is liable to modification from time to time.