Painting Steel

Correct surface preparation of steel substrates is essential to achieve effective corrosion protection and to maximise the service life of any marine coating system. Whether applying a **two-component epoxy coating system** or a **one-component anticorrosive system**, the durability and performance of the coating are directly dependent on the quality of surface preparation.

Common factors that can significantly reduce coating life include surface contamination, residual salts, weld defects, sharp edges, mill scale, rust, and inadequate surface profiling. Prior to coating application, the steel substrate should be carefully inspected and all defects rectified.

Where there is uncertainty regarding coating selection or preparation methods, it is recommended to consult **Skipper's Line** technical representatives for guidance on suitable coating systems and preparation standards. The following information provides general guidance for steel surface preparation and coating application.

Surface Preparation – Bare Steel

Steel surfaces must be completely free from rust, mill scale, corrosion products, oil, grease, salt, and other contaminants prior to coating.

1. Thoroughly clean and degrease the surface using a suitable solvent or alkaline cleaner.
2. The preferred method of preparation is **shot or grit blasting to SA 2.5** standard, producing a clean surface with an appropriate profile for coating adhesion.
3. Where abrasive blasting is not possible, mechanical preparation using grinders, wire brushing, or power sanding must be carried out to remove all visible rust and corrosion.
4. Ensure all dust and residues are fully removed prior to coating application.

Once prepared, apply the specified **one- or two-component anticorrosive coating system** suitable for above- or below-waterline service, strictly following the relevant product application guidelines.

Previously Coated Surfaces – Topsides & Below the Waterline

Coating in Good Condition

If the existing coating system is sound, with no visible rust, blistering, cracking, or loss of adhesion:

1. Thoroughly clean and degrease the surface.
2. Abrade the coating using medium-fine abrasive paper (P180–P240) to provide a mechanical key.
3. Remove all sanding dust and residues completely.
4. Apply the selected protective coating, epoxy system, topcoat, or antifouling as required.

Coating in Poor Condition

If the existing coating shows rust breakthrough, flaking, cracking, blistering, or loss of adhesion:

- Remove all coatings and corrosion products by mechanical sanding, shot or grit blasting, or the use of a suitable paint remover.
- Prepare the substrate in accordance with the **Bare Steel** preparation guidelines prior to applying the new coating system.

One-Component Indicative Coating Systems

1. Bottom Coating System – Below Waterline					
No of Coats	**Product Name**	**Thinner**		**Coverage (m2/Lt)**	**Recoating (at 20˚C)**
1-2	**Sottofondo Arancio AT Primer**	15-25% Brush 107	15-30% Spray 107	7-9	24 hours
	or				
1-2	**Eviox Grigio "R"**	15-25% Brush 107	15-30% Spray 107	10	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)**
1-2	**Sottofondo Arancio AT Primer**	15-25% Brush 107	15-30% Spray 107	7-9	24 hours
	or				
1-2	**Eviox Grigio "R"**	10-25% Brush 107	15-30% Spray 107	10	12-24 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	10-20% Brush 107/109	10-25% Spray 900	11-13	18-24 hours
	or				
	Topkapi Satin Yacht Paint	10-20% Brush 107/109	10-25% Spray 900	11-13	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.*