

CORROSION PROTECTION OF STRUCTURAL STEEL

**COATING SYSTEMS
FOR ALL APPLICATIONS
ACCORDING TO ISO 12944-5:2019**





CORROSION PROTECTION OF STRUCTURAL STEEL

Insufficient corrosion protection of steel structures can have serious consequences. Lack of protection frequently leads to structural problems behind the structure's visual appearance. Specific protective coatings and sensible maintenance intervals ensure long-term protection of steel structures and can avoid high cost refurbishments or decommissioning.

Sherwin-Williams solutions are efficient protective systems offering high reliability, decades of experience and excellent technical service. Our specialists assist you, whether you are an architect, planner, fabricator, steel constructor, or responsible for creating tendering documents, when you need an individual corrosion protection solution.

Sherwin-Williams accompany your project from first inspection to selecting the appropriate coating system and finalizing the project.

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INCREASED SAFETY THROUGH EFFICIENT PRODUCTS AND EXPERT CONSULTING

Without long-lasting and functional corrosion protection, many steel structures start to look old after only a few years.

It is not only the appearance that is affected, the strength of the structure can also start to suffer. In the worst case, the only choice is between decommissioning the structure or a full refurbishment. That's why you can rely on Sherwin-Williams coating systems to maintain their value, durability and aesthetics right from the start.

Since 1998, the corrosion protection of steel structures has been regulated by the international standard ISO 12944. In 2018, this standard was updated to reflect the latest advancements and increasing requirements related to corrosion protection coatings. In its nine parts, this standard highlights the following aspects in detail:

- Classification of environments and design considerations
- Surface evaluation and preparation
- Planning initial protection and refurbishment
- Laboratory testing of coating systems performance
- Execution and supervision of paint works

Our high-performance products and systems cover the entire range of the defined requirements.



Further information on our full range of corrosion and fire protection coatings can be found on page 22. The selection of the optimal coating system in terms of technical and economic factors takes time and effort. Therefore, we have presented our suggestions, products and systems in easy-to-follow tables.

Our practice-based information will also become a welcome aid for you and make choosing the right corrosion protection system easier. If you have any questions, don't hesitate to get in touch with your Sherwin-Williams representative directly, and we will advise you.

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PERFECT RESULTS FROM INNOVATIVE AND PROVEN COATING SYSTEMS

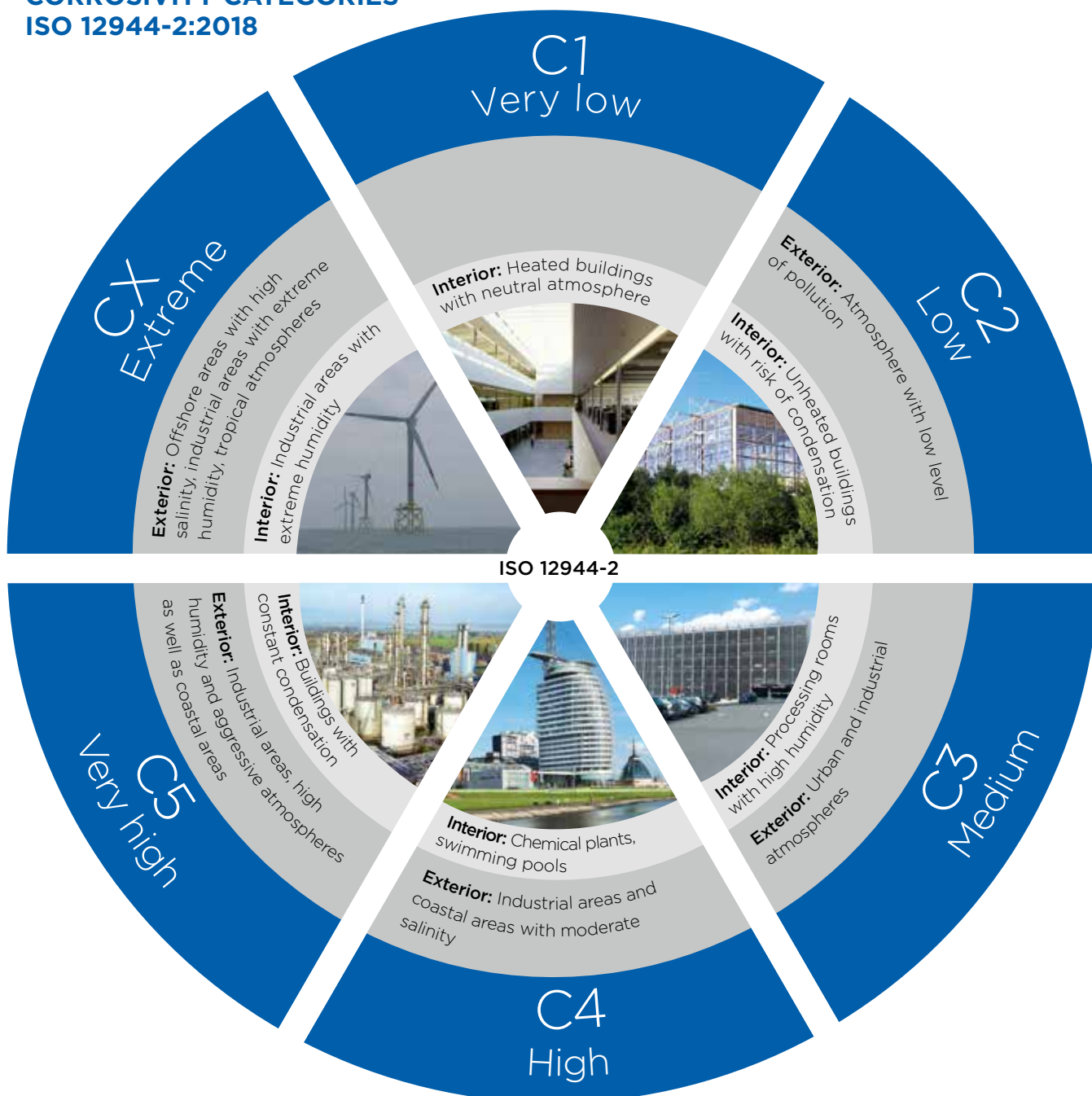
Coatings for the corrosion protection of structural steel are exposed to specific corrosion loads depending on the ambient conditions. These are defined in ISO 12944-1,-2 depending on durability range and corrosivity category.

Based on many years of experience, it is now possible to provide coating systems for steel with more than 25 years of durability in almost all atmospheric load ranges. As a result, increasing the durability range to more than 25 years has now been possible.

Durability range	Abbreviation	Time period
Low	L	Up to 7 years
Medium	M	7 - 15 years
High	H	15 - 25 years
Very High	VH	More than 25 years



CORROSIVITY CATEGORIES ISO 12944-2:2018



The corrosivity categories were restructured in the 2018 revised standard and now range from C1 to CX. Category CX (part 9 of the standard) refers to extremely corrosive environments, particularly offshore and industrial areas with extreme humidity.

PROTECTION OVER DECADES WITH ISO 12944-5:2019

To offer safe protection against corrosion, the diffusion barrier through coatings plays an essential role. Therefore, minimum requirements for coating systems are defined in the ISO standard. The minimum number of layers and the minimum layer thickness are essential requirements to protect the object in accordance with ISO 12944.

COATING SYSTEMS REQUIREMENTS

NUMBER OF LAYERS AND MINIMUM LAYER THICKNESS

- The **M**inimum **N**umber **O**f **C**oats (MNOC) and the total film thickness (NDFT = **N**ominal **D**ry **F**ilm **T**hickness) of the individual systems are compulsory. Higher film thicknesses and more layers are also possible.

SUBSTRATE

- The standard details surface preparation requirements, to Grade Sa 2½, for steel, galvanised steel, and steel with thermally sprayed zinc coatings.
- According to the revised standard, metallic zinc layers are part of the corrosion protection system and no longer part of the substrate.

SYSTEM BUILD-UP*

- The coating system varies according to the desired corrosivity category and durability range.
- From C2 very high durability it is also possible to adopt coating systems from higher or lower categories. Only the durability range varies according to the corrosivity category.
- From C2 low durability to C2 high durability it is possible to use C3 coating systems, but not on reverse. This means that a coating system which is highly suitable for C2 high durability is not necessarily suitable for C3 medium despite identical coating thicknesses. This is due to different corrosion resistance requirements in the two corrosivity categories.

*The requirements based on the revised standard are shown in the table opposite..

MINIMUM REQUIREMENTS FOR COATING SYSTEMS ON BLASTED OR HOT-DIP GALVANIZED STEEL SUBSTRATES IN ACCORDANCE WITH ISO 12944-5:2019

Coating system			Corrosivity categories							
Primer (Binder Type)	Subse- quent Coats (Binder Type)	Durability range	C2		C3		C4		C5	
			No. of coats	Total coating thick- ness (µm)	No. of coats	Total coating thick- ness (µm)	No. of coats	Total coating thick- ness (µm)	No. of coats	Total coating thick- ness (µm)
Blasted steel substrate										
Zinc Rich Primer (ESI, EP, PUR)	EP, PUR, AY	L	-	-	-	-	1	60	2	160
		M	-	-	1	60	2	160	2	200
		H	1	60	2	160	2	200	3	260
		VH	2	160	2	200	3	260	3	320
ESI, EP, PUR	EP, PUR, AY	L	-	-	-	-	1	120	2	180
		M	-	-	1	120	2	180	2	240
		H	1	120	2	180	2	240	2	300
		VH	2	180	2	240	2	300	3	360
AK, AY	AK, AY	L	-	-	1	100	1	160	-	-
		M	1	100	1	160	2	200	-	-
		H	1	160	2	200	2	260	-	-
		VH	2	200	2	260	-	-	-	-
Hot-dip galvanized steel										
EP, PUR	EP, PUR, AY	L	-	-	-	-	1	80	1	120
		M	-	-	1	80	1	120	2	160
		H	1	80	1	120	2	160	2	200
		VH	1	120	2	160	2	200	2	240
AY	AY	L	-	-	-	-	1	80	2	160
		M	-	-	1	80	2	160	2	200
		H	1	80	2	160	2	200	-	-
		VH	2	160	2	200	-	-	-	-

AK: 1-pack alkyd resin coatings **AY:** 1-pack acrylic resin coatings **ESI:** 1-pack or 2-pack ethyl silicate coatings
EP: 2-pack epoxy resin coatings **PUR:** 1-pack or 2-pack polyurethane coatings
L: Low **M:** Medium **H:** High **VH:** Very High

TABLE 1

COATING SYSTEMS FOR STEEL IN VERY HIGH CONDITIONS UP TO C5

COATING SYSTEMS FOR CORROSION PROTECTION OF STEEL STRUCTURES
IN VARIOUS ATMOSPHERIC CONDITIONS ACCORDING TO ISO 12944-5:2019.

Surface Preparation	Primer		Intermediate Coat		Topcoat	
	Product	NDFT [μm]	Product	NDFT [μm]	Product	NDFT [μm]
Sa 2½	Kem-Kromik™ Steel Protect VHS Rapid ¹	100				
Sa 2½	Kem-Kromik™ Steel Protect VHS Rapid ¹	80	Kem-Kromik™ Steel Protect VHS Rapid ¹	80		
Sa 2½	Acrolon® PUR Color Plus ²	120				
Sa 2½	Macropoxy® 646 ³	120				
Sa 2½	Macropoxy® 4600 ³	75	Acrolon® 7700 ⁵	60		
Sa 2½	Kem-Kromik™ Steel Protect VHS Rapid ¹	100	Kem-Kromik™ Steel Protect VHS Rapid ¹	100		
Sa 2½	Macropoxy® 646 ³	180				
Sa 2½	Macropoxy® 4600 ³	120	Acrolon® 7700 ⁵	60		
Sa 2½	Kem-Kromik™ Steel Protect VHS Rapid ¹	100	Kem-Kromik™ Steel Protect VHS Rapid ¹	80	Kem-Kromik™ Steel Protect VHS Rapid ¹	80
Sa 2½	Macropoxy® 4600 ⁴	180	Acrolon® 7700 ⁵	60		
Sa 2½	Zinc Clad® R Plus ⁶	60	Macropoxy® 2600 ⁴	80	Acrolon® 7700 ⁵	60
Sa 2½	Macropoxy® 4600 ⁴	240	Acrolon® 7700 ⁵	60		
Sa 2½	Macropoxy® 4600 ⁴	120	Macropoxy® 2600 ⁴	120	Acrolon® 7700 ⁵	60
Sa 2½	Zinc Clad® R Plus ⁶	60	Macropoxy® 2600 ⁴	140	Acrolon® 7700 ⁵	60
Sa 2½	Macropoxy® 4600 ⁴	150	Macropoxy® 2600 ⁴	150	Acrolon® 7700 ⁵	60
Sa 2½	Zinc Clad® R Plus ⁶	60	Macropoxy® 2600 ⁴	200	Acrolon® 7700 ⁵	60

¹ Alternative: Kem-Kromik™ 155

² Alternative: Acrolon® EG-120

³ Alternative: Macropoxy® 646, Macropoxy® 4600, Macropoxy® EP Color, Macropoxy® EG Phosphate Rapid, Macropoxy® EG-1 Plus, Macropoxy® 400

⁴ Alternative: Macropoxy® 646, Macropoxy® 4600, Macropoxy® EG Phosphate Rapid, Macropoxy® EG-1 Plus, Macropoxy® 400

⁵ Alternative: Acrolon® 7300, Acrolon® 2330, Acrolon® EG-5, Acrolon® 1850

⁶ Alternative: Zinc Clad® R Rapid Plus, Zinc Clad® IV EU

Total System			Corrosivity Category															
No. of coats	Binder Type	NDFT [µm]	C2				C3				C4				C5			
			L	M	H	VH	L	M	H	VH	L	M	H	VH	L	M	H	VH
1	AK	100																
2	AK	160																
1	PUR	120																
1	EP	120																
2	EP/PUR	135																
2	AK	200																
1	EP	180																
2	EP/PUR	180																
3	AK	260																
2	EP/PUR	240																
3	ZR/EP/PUR	200																
2	EP	300																
3	EP/PUR	300																
3	ZR/EP/PUR	260																
3	EP/PUR	360																
3	ZR/EP/PUR	320																

AK: 1-pack alkyd resin coatings **AY:** 1-pack acrylic resin coatings **ESI:** 1-pack or 2-pack ethyl silicate coatings
EP: 2-pack epoxy resin coatings **PUR:** 1-pack or 2-pack polyurethane coatings
L: Low **M:** Medium **H:** High **VH:** Very High

TABLE 2

COATING SYSTEMS FOR HOT-DIPPED GALVANIZED STEEL

DUPLEX SYSTEMS FOR CORROSION PROTECTION OF STEEL STRUCTURES IN VARIOUS ATMOSPHERIC CONDITIONS ACCORDING TO ISO 12944-5:2019. HOT-DIPPED GALVANIZED STEEL ACCORDING TO ISO 1461.

Surface Preparation	Primer		Topcoat		Total System		
	Product	NDFT [μm]	Product	NDFT [μm]	No. of coats	Binder Type	NDFT [μm]
Cleaner Wash	Acrolon® EG-120	80			1	PUR	80
Mordant Wash L703	Macropoxy® L574	25	Acrolon® 7700 ³	60	2	EP/PUR	85
Sweep-blasting	Acrolon® EG-120 ¹	80			1	PUR	80
Sweep-blasting	Macropoxy® 646 ²	80			1	EP	80
Cleaner Wash	Acrolon® EG-120	120			1	PUR	120
Cleaner Wash	Macropoxy® EG-1 Plus	75	Acrolon® 7700 ³	60	2	EP/PUR	135
Mordant Wash L703	Macropoxy® K267	75	Acrolon® 7700 ³	60	2	EP/PUR	135
Sweep-blasting	Acrolon® EG-120 ¹	120			1	PUR	120
Sweep-blasting	Macropoxy® 646 ²	120			1	EP	120
Cleaner Wash	Macropoxy® EG-1 Plus	100	Acrolon® 7700 ³	60	2	EP/PUR	160
Mordant Wash L703	Macropoxy® K267	100	Acrolon® 7700 ³	60	2	EP/PUR	160
Sweep-blasting	Macropoxy® 646 ²	160			1	EP	160
Sweep-blasting	Macropoxy® 4600 ²	100	Acrolon® 7700 ³	60	2	EP	160
Mordant Wash L703	Macropoxy® K267	140	Acrolon® 7700 ³	60	2	EP/PUR	200
Sweep-blasting	Macropoxy® 646 ²	100	Macropoxy® 646 ²	100	2	EP	200
Sweep-blasting	Macropoxy® 4600 ²	140	Acrolon® 7700 ³	60	2	EP	200
Sweep-blasting	Macropoxy® 646 ²	120	Macropoxy® 646 ²	120	2	EP	240
Sweep-blasting	Macropoxy® 4600 ²	180	Acrolon® 7700 ³	60	2	EP	240

¹ Alternative: Acrolon® PUR Color Plus

² Alternative: Macropoxy® 646, Macropoxy® 4600, Macropoxy® EG-1 Plus, Macropoxy® 400, Macropoxy® K267

³ Alternative: Acrolon® 7300, Acrolon® 2330, Acrolon® EG-5, Acrolon® 1850

AK: 1-pack alkyd resin coatings **AY:** 1-pack acrylic resin coatings **ESI:** 1-pack or 2-pack ethyl silicate coatings
EP: 2-pack epoxy resin coatings **PUR:** 1-pack or 2-pack polyurethane coatings
L: Low **M:** Medium **H:** High **VH:** Very High

TABLE 3

COATING SYSTEMS FOR ALUMINIUM AND STAINLESS STEEL

SYSTEMS FOR ALUMINUM AND STAINLESS STEEL

Coating systems for aluminum and stainless steel are not regulated in ISO 12944.

The coating systems and tests are based on ISO 12944-5 and 12944-6.

The durability is based on ISO 12944-1 and ISO 12944-2.

Other typical tests for these substrates were not carried out.

Surface Preparation	Primer		Topcoat		Total System		
	Product	NDFT [µm]	Product	NDFT [µm]	No. of coats	Binder Type	NDFT [µm]
Cleaner Wash	Acrolon® EG-120 ¹	80			1	PUR	80
Abrading	Macropoxy® L574	25	Acrolon® 7700 ²	60	1	EP/PUR	85
Sweep-blasting	Macropoxy® 646 ¹	80			2	EP	80
Sweep-blasting	Macropoxy® L574	25	Acrolon® 7700 ²	60	1	EP/PUR	85
Cleaner Wash	Acrolon® EG-120 ¹	120			2	PUR	120
Abrading	Macropoxy® 646	120			1	EP	120
Abrading	Macropoxy® EG-1 Plus ¹	75	Acrolon® 7700 ²	60	2	EP/PUR	135
Sweep-blasting	Macropoxy® 646 ¹	120			1	EP	120
Sweep-blasting	Macropoxy® EG-1 Plus ¹	75	Acrolon® 7700 ²	60	2	EP/PUR	135
Cleaner Wash	Macropoxy® EG-1 Plus	160			1	EP	160
Cleaner Wash	Macropoxy® EG-1 Plus	100	Acrolon® 7700 ²	60	2	EP/PUR	160
Abrading	Macropoxy® 646	160			2	EP	160
Abrading	Macropoxy® EG-1 Plus ¹	100	Acrolon® 7700 ²	60	2	EP/PUR	160
Sweep-blasting	Macropoxy® 646 ¹	160			2	EP	160
Sweep-blasting	Macropoxy® EG-1 Plus ¹	100	Acrolon® 7700 ²	60	2	EP/PUR	160
Abrading	Macropoxy® 646	100	Macropoxy® 646 ¹	100	2	EP	200
Abrading	Macropoxy® EG-1 Plus ¹	140	Acrolon® 7700 ²	60	2	EP/PUR	200
Sweep-blasting	Macropoxy® 646 ¹	100	Macropoxy® 646 ¹	100	2	EP	200
Sweep-blasting	Macropoxy® EG-1 Plus ¹	140	Acrolon® 7700 ²	60	2	EP/PUR	200
Sweep-blasting	Macropoxy® 646 ¹	120	Macropoxy® 646 ¹	120	2	EP	240
Sweep-blasting	Macropoxy® EG-1 Plus ¹	180	Acrolon® 7700 ²	60	2	EP/PUR	240

¹ Alternative: Macropoxy® 646, Macropoxy® EG-1 Plus, Macropoxy® L425

² Alternative: Acrolon® 7300, Acrolon® 2330, Acrolon® EG-5, Acrolon® 1850

[illegible]

AK: 1-pack alkyd resin coatings **AY:** 1-pack acrylic resin coatings **ES:** 1-pack or 2-pack ethyl silicate coatings
EP: 2-pack epoxy resin coatings **PUR:** 1-pack or 2-pack polyurethane coatings
L: Low **M:** Medium **H:** High **VH:** Very High

TABLE 4

COATING SYSTEMS FOR THERMAL-SPRAYED ZINC COATINGS

SYSTEMS ON THERMAL-SPRAYED ZINC COATINGS
ACCORDING ISO 12944-5:2019 AND ISO 2063: 2019

Surface Preparation	Sealer		Intermediate coat		Topcoat	
	Product	NDFT [µm]	Product	NDFT [µm]	Product	NDFT [µm]
N/A	Macropoxy® 646 ¹ (Thinned appropriately)	~	Macropoxy® 646 ²	100	Macropoxy® 646 ²	100
N/A	Macropoxy® EG-1 Plus ¹ (Thinned appropriately)	~	Macropoxy® EG-1 Plus ²	140	Acrolon® 7700 ³	60
N/A	Macropoxy® L574	~	Macropoxy® 646 ²	100	Macropoxy® 646 ²	100
N/A	Macropoxy® L574	~	Macropoxy® EG-1 Plus ²	140	Acrolon® 7700 ³	60
N/A	Macropoxy® 646 ¹ (Thinned appropriately)	~	Macropoxy® 646 ²	120	Macropoxy® 646 ²	120
N/A	Macropoxy® EG-1 Plus ¹ (Thinned appropriately)	~	Macropoxy® EG-1 Plus ²	180	Acrolon® 7700 ³	60
N/A	Macropoxy® L574	~	Macropoxy® 646 ²	120	Macropoxy® 646 ²	120
N/A	Macropoxy® L574	~	Macropoxy® EG-1 Plus ²	180	Acrolon® 7700 ³	60

~ The sealer shall fill the metal pores. It shall be applied until absorption is complete.
There **should be a measurable overlay of sealer of ~ 20 µm** on the metallic coating after application.

¹ Alternative: Macropoxy® 646, Macropoxy® EG-1 Plus

² Alternative: Macropoxy® 646, Macropoxy® 4600, Macropoxy® 2600, Macropoxy® EG-1 Plus

³ Alternative: Acrolon® 7300, Acrolon® 2330, Acrolon® EG-5, Acrolon® 1850

Total System			Corrosivity Category															
No. of coats	Binder Type	NDFT [µm]	C2				C3				C4				C5			
			L	M	H	VH	L	M	H	VH	L	M	H	VH	L	M	H	VH
2	EP	200																
2	EP/PUR	200																
2	EP	200																
2	EP/PUR	200																
2	EP	240																
2	EP/PUR	240																
2	EP	240																
2	EP/PUR	240																

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TABLE 5

COATING SYSTEMS FOR REFURBISHMENT OF OLD COATINGS

COATING SYSTEMS FOR MAINTENANCE OF STEEL CONSTRUCTIONS IN ATMOSPHERIC CONDITIONS

Surface Preparation	Primer		Intermediate coat		Topcoat	
	Product	NDFT [µm]	Product	NDFT [µm]	Product	NDFT [µm]
P St 3	Macropoxy® 646 ¹	120				
Wa 2, Flash Rust 'M'	Dura-Plate® 301W	120				
P St 3	Macropoxy® 646 ¹	160				
P St 3	Macropoxy® 646 ¹	100	Acrolon® 7700 ²	60		
Wa 2, Flash Rust 'M'	Dura-Plate® 301W	100	Acrolon® 7700 ²	60		
P St 3	Macropoxy® 646 ¹	110	Macropoxy® 646 ¹	110		
P St 3	Macropoxy® 646 ¹	160	Acrolon® 7700 ²	60		
Wa 2, Flash Rust 'M'	Dura-Plate® 301W	160	Acrolon® 7700 ²	60		
P St 3	Macropoxy® 646 ¹	130	Macropoxy® 646 ¹	130		
P St 3	Macropoxy® 646 ¹	100	Macropoxy® 646 ¹	100	Acrolon® 7700 ²	60
Wa 2, Flash Rust 'M'	Dura-Plate® 301W	200	Acrolon® 7700 ²	60		

¹ Alternative: Dura-Plate® 301W, Macropoxy® Primer HE N, Macropoxy® M902

² Alternative: Acrolon® 7300, Acrolon® 2330, Acrolon® EG-5, Acrolon® 1850

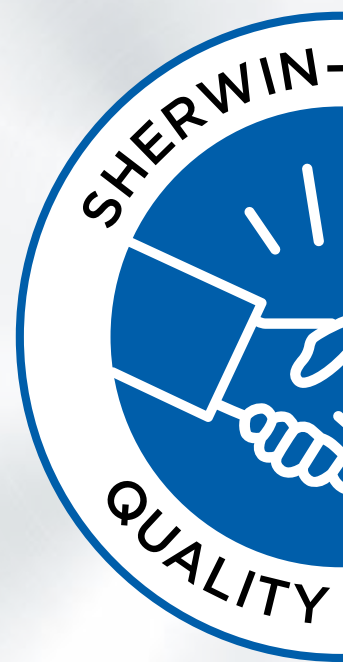
Total System			Corrosivity Category			
No. of coats	Binder Type	NDFT [µm]	C2	C3	C4	C5
			> 10 years	> 10 years	> 10 years	> 10 years
1	EP	120				
1	EP	120				
1	EP	160				
2	EP/PUR	160				
2	EP/PUR	160				
2	EP	220				
2	EP/PUR	220				
2	EP/PUR	220				
2	EP	260				
3	EP/PUR	260				
2	EP/PUR	260				

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OUR QUALITY PROMISE

Thanks to [advanced technologies](#), exceptional service, and decades of experience, Sherwin-Williams Protective & Marine Coatings is a reliable partner for corrosion protection coatings in steel construction.

Our dedicated sales team, specialised application technology, experienced product management experts, innovative development department, and skilled production team all contribute to our quality promise.



INSTRUCTION ON-SITE

during the coating works available on request

SURFACE CHECKS

carried out within the framework of control areas

Consultation and sale by our experts,
certified and tested as

**NACE AND FROSIO
INSPECTORS**

INDIVIDUAL CONSULTATION

in the choice of the optimal
coating system



PROVEN ASSET PROTECTION ACROSS THE GLOBE

After 150 years of being in the paint and coatings business, Sherwin-Williams Protective & Marine understands the challenges that assets undergo during their life span. By working closely with asset owners and applicators, we develop the solutions to help combat those problems.

Our high-performance coatings and systems are engineered to defend assets against corrosion, fire, chemical attack, wear, or high temperatures – helping our customers achieve smarter, time-tested protection. We support the entire value chain of the project – from the idea, to the specification, to the execution. Combined with thousands of years of cumulative expertise among our coating professionals who know your business inside and out, we are fully aligned with your business.

Our global coating solutions help protect assets in many industries, including:

- **Infrastructure** – Civil and Commercial
- **Energy** – from Oil and Gas industries to Wind, Solar and Biofuels
- **Manufacturing and Processing** – Production facilities including Food and Beverage, Pharmaceutical, Heavy Manufacturing, EV Battery, Semiconductor and Data Centres

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COATING SYSTEMS
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THE SHERWIN-WILLIAMS DIFFERENCE

Sherwin-Williams Protective & Marine delivers world-class industry subject matter expertise, unparalleled technical and specification service, and unmatched regional commercial team support to our customers around the globe. Our broad portfolio of high-performance coatings and systems - including protective liquid and powder, fire protection and resinous flooring - excel at combating corrosion and help customers achieve smarter, time-tested asset protection. We serve a wide array of markets across our rapidly growing international distribution footprint, including Bridge & Highway, Energy, High Value Infrastructure, Manufacturing & Processing, Marine, Rail, Power and Water & Wastewater.

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