

CORROSION PROTECTIVE COATINGS FOR STEEL STRUCTURES

PRACTICAL COATING SYSTEMS FOR ALL IMPORTANT APPLICATIONS
ACCORDING TO ISO 12944:2018

BUILDING TRUST





Insufficient corrosion protection of steel structures can have serious consequences. Lack of protection frequently leads to structural problems quite apart from the visual appearance of the structure. Appropriate protective coatings and sensible maintenance intervals ensure long-term protection of steel structures and can avoid cost-intensive total refurbishment or even decommissioning. Sika convinces with efficient product systems, high reliability, decades of experience and excellent technical service. Our specialists assist you - whether you are an architect, a planner, a fabricator, steel constructor or responsible for creating tendering documents - when you need an individual corrosion protection solution. We accompany your project from object analysis to the selection of the right coating system up to the final project conclusion.

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THE SIKA QUALITY PROMISE

THANKS TO **ADVANCED** technologies, special service and many years of experiences, Sika Industrial Coatings is a reliable partner for corrosion protective coatings in steel constructions for many decades. Thanks to the most advanced technologies, special service and many years of experience. From the competent sales team to the specialists in product management and the development department to the production team, our experts contribute to Sika Industrial Coatings' promise of quality.

OUR SERVICE - YOUR BENEFIT

PROFESSIONAL CONSULTING

for the choice of the optimal Sika coating system

ON SITE INSTRUCTIONS

during coating work on request

SURFACE INSPECTION TEST

Execution of
within the monitoring of reference areas

Consulting and sale by our experts, certified as
**FROSIO COATING INSPECTORS
LEVEL III**

THE SIKA QUALITY PROMISE





MORE SAFETY THROUGH EFFICIENT PRODUCTS AND PROFESSIONAL CONSULTING

WITHOUT LONG-LASTING AND FUNCTIONAL corrosion protection, many steel structures start to "look quite old" after only a few years. But 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 our 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.

Further information on Sika's competence in the field of corrosion and fire protection coatings can be found on page 27.

In 2018, the entire standard was adapted to the state of the art with constantly increasing requirements and findings with regard to corrosion protection coatings. In its nine parts, this standard illuminates the following aspects in detail:

The selection of the optimal coating system in terms of technical and economic aspects is not easy. For this reason, we have presented our suggestions and products in clear tables.

- Basics and environmental influences
- Surface evaluation and preparation
- Conception of initial protection and refurbishment
- Laboratory testing of coating systems
- Execution and supervision of works

We hope that our practice-oriented information will also become a welcome aid for you and make it easier for you to choose the right corrosion protection system. If you have any questions, we will be happy to advise you personally.

Our high-performance products and systems cover the entire spectrum of the defined requirements. This brochure is focussed on steel structures with the most important passages of the revised standard. In particular, we present the coating systems acc. part 5 of the revised standard.

TABLE	
1	Coating systems on steel surfaces
2	Coatings on hot-dip galvanised steel
3	Refurbishment of old coating
4	Product features of our primers
5	Product features of our intermediate coats
6	Product features of our top coats

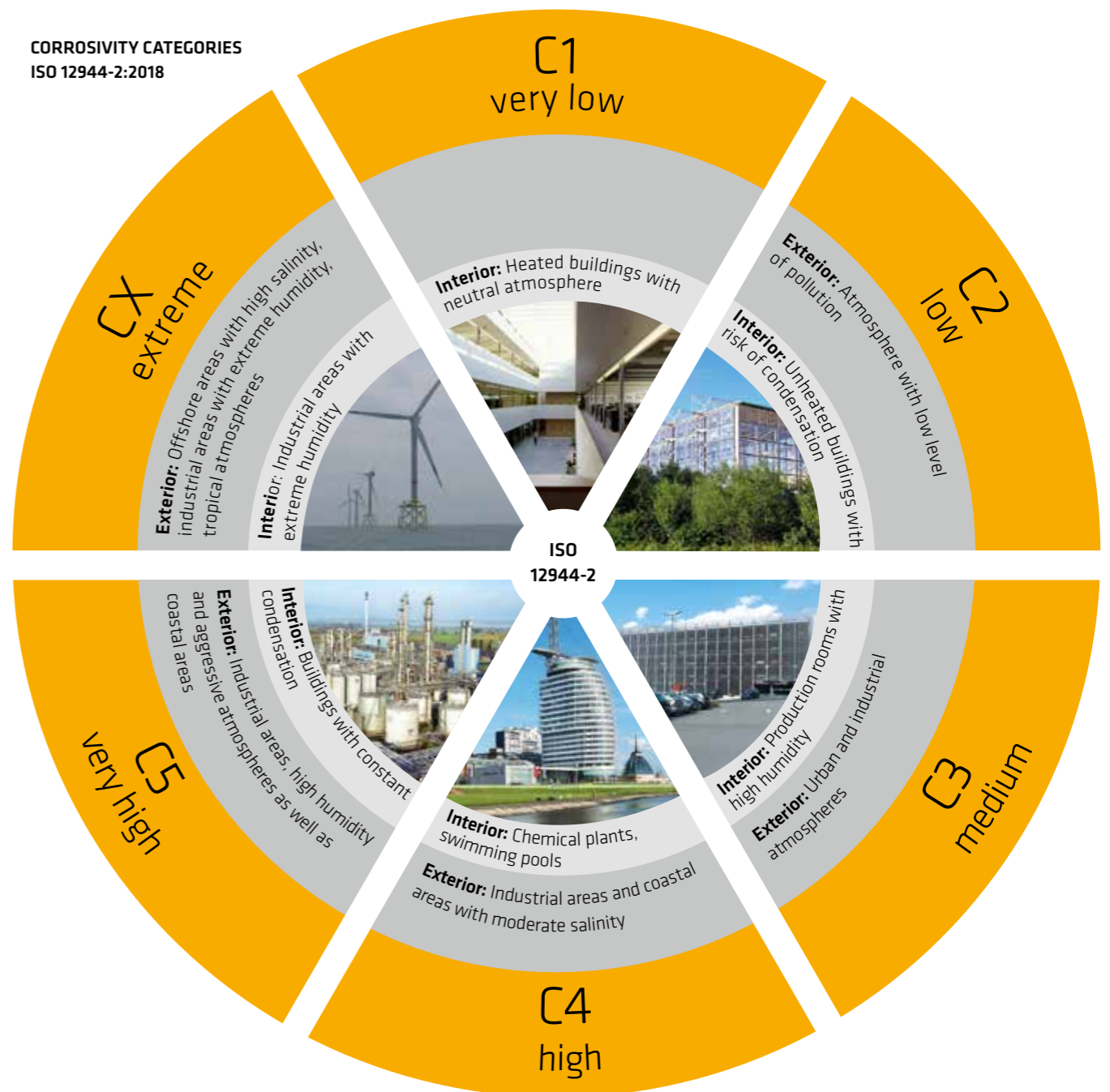
PERFECT RESULTS DUE TO INNOVATIVE AND PROVED COATING SYSTEMS

CORROSION PROTECTIVE COATINGS of steel structures are exposed to specific corrosion loads depending on the ambient conditions. These are defined in ISO 12944-1,-2:2018 depending on durability range and corrosivity category.

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

PROTECTIVE PERIODS - ISO 12944-1:2018

Durability range	Abbreviation (s)	Period of time
low	L	up to 7 years
medium	M	7 - 15 years
high	H	15 - 25 years
very high	VH	more than 25 years



In the 2018 revised standard, the corrosivity categories were restructured and now range from C1 to CX. CX describes extreme conditions related to marine climate or tropical atmosphere and is treated within the new part 9 of the standard.

PROTECTION OVER DECADES - FUNDAMENTAL IMPLEMENTATIONS OF ISO 12944-5:2018

IN ORDER TO OFFER a safe protection against corrosion, the diffusion barrier through coatings plays an essential role. For this reason, the previously freely selectable system dimension was redefined during the revision of the standard. With the revised standard, the proposed coating systems are no longer informative, now they are normative.

WHAT HAS CHANGED REGARDING TO...

...THE NUMBER OF COATS?

- The minimum number of coats (MNOC) and the total film thickness (NDFT = **N**ominal **d**ry **f**ilm **t**hickness) of the individual systems are obligatory. Higher film thicknesses and more working steps are possible.

...THE STEEL SUBSTRATE?

- The new requirements for coating systems differ in applications on steel (Sa 2 1/2) and on hot-dip galvanized steel.
- According to the revised standard, metallic zinc layers are a part of the corrosion protection system and no longer part of the substrate.

...THE SYSTEM BUILDUP?*

- The coating system varies according to the desired corrosivity category and durability range.
- From C2 very high 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 to C2 high it is possible to use C3 coating systems, but not on reverse. This means that a coating system which is highly suitable for C2 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 on page 11.

MINIMUM REQUIREMENTS FOR COATING SYSTEMS ON BLASTED OR HOT-DIP GALVANIZED STEEL SUBSTRATES IN ACCORDANCE WITH ISO 12944-5:2018

Coating system			Corrosivity categories							
Type of primer	Type of the following layer	Durability range	C2		C3		C4		C5	
			Number of coats	Total coating thickness [µm]	Number of coats	Total coating thickness [µm]	Number of coats	Total coating thickness [µm]	Number of coats	Total coating thickness [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	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
AY	AY	L	-	-	-	-	1	160	-	-
		M	-	-	1	160	2	200	-	-
		H	1	160	2	200	2	260	-	-
		VH	2	200	2	260	-	-	-	-

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

TABLE 1a SELECTION OF COATING SYSTEMS ON STEEL FOR ATMOSPHERIC CONDITIONS UP TO C3

COATING SYSTEMS FOR CORROSION PROTECTION OF STEEL STRUCTURES IN VARIOUS ATMOSPHERIC CONDITIONS
ACCORDING TO ISO 12944-5:2018. SURFACE PREPARATION: SA 2½ (ISO 12944-4:2018)

Primer		Top coat		Total system		Corrosivity category								
Product name	NDFT [µm]	Product name	NDFT [µm]	Number of coats	NDFT [µm]	C2				C3				
						low	medium	high	very high	low	medium	high	very high	
		SikaCor® PUR Color NEW*3	120	1	120									
Sika® CorroTop NEW	80	Sika® CorroTop NEW	80	2	160									
SikaCor® Steel Protect VHS Rapid	80	Sika® CorroTop NEW	80	2	160									
SikaCor® Aktivprimer Rapid	80	Sika® CorroTop NEW	80	2	160									
		SikaCor® EP Color	100	1	100									
		SikaCor® Steel Protect VHS Rapid	120	1	120									
SikaCor® Steel Protect VHS Rapid	120	SikaCor® Steel Protect VHS Rapid	80	2	200									
		SikaCor® PUR Color NEW*3	180	1	180									
SikaCor® ZP Primer	100	SikaCor® PUR Color NEW*3	80	2	180									
SikaCor® Steel Protect VHS Rapid	80	SikaCor®-6630 High Solid*6	120	2	200									
SikaCor®-6630 High Solid*6	100	SikaCor®-6630 High Solid*6	100	2	200									
SikaCor® EP Color	100	SikaCor® EP Color	80	2	180									
SikaCor® EP Color	100	SikaCor® PUR Color NEW*3	80	2	180									
Sika Poxicolor® Primer HE NEW	100	SikaCor® EG-5*5	80	2	180									

*1alternatively SikaCor® EG Phosphat Rapid/Plus **2alternatively SikaCor® EG-1 Rapid/Plus *3alternatively SikaCor® PUR Color Plus **alternatively SikaCor® Zinc R Rapid
*5alternatively SikaCor® EG-4, Sika® Permacor®-2330 oder Sika® Permacor®-2230 VHS *6alternatively SikaCor®-6630 Plus *7alternatively SikaCor®-6630 Primer Plus

TABLE 1b
SELECTION OF COATING SYSTEMS ON STEEL FOR
ATMOSPHERIC CONDITIONS UP TO C5

COATING SYSTEMS FOR CORROSION PROTECTION OF STEEL STRUCTURES IN VARIOUS ATMOSPHERIC CONDITIONS
ACCORDING TO ISO 12944-5:2018. SURFACE PREPARATION: SA 2½ (ISO 12944-4:2018)

Primer		Intermediate coat		Top coat		Total system		Corrosivity category															
Product name	NDFT [µm]	Product name	NDFT [µm]	Product name	NDFT [µm]	Number of coats	NDFT [µm]	C2				C3				C4				C5			
								low	medium	high	very high	low	medium	high	very high	low	medium	high	very high	low	medium	high	very high
SikaCor®-6630 High Solid*6	80	SikaCor®-6630 High Solid*6	100	SikaCor®-6630 High Solid*6	100		280																
Sika® Permacor®-2204 VHS	160			SikaCor® EG-5*5	80	2	240																
Sika Poxicolor® Rapid	120			SikaCor® EG-120	120	2	240																
SikaCor®-2440 MF	190			SikaCor® EG-5*5	50	2	240																
Sika® Permacor®-2204 VHS	220			SikaCor® EG-5*5	80	2	300																
SikaCor® EG Phosphat*1	100	SikaCor® EG-1*2	120	SikaCor® EG-5*5	80	3	300																
SikaCor® ZP Primer	100	SikaCor® ZP-1	120	SikaCor® EG-5*5	80	3	300																
SikaCor® Zinc R*4	80	SikaCor® EG-1*2	100	SikaCor® EG-5*5	80	3	260																
SikaCor® Zinc R*4	80	SikaCor® ZP-1	100	SikaCor® EG-5*5	80	3	260																
Sika Poxicolor® Primer HE NEW	100	SikaCor® EG-1 VHS	120	SikaCor® EG-5*5	80	3	300																
SikaCor® Zinc R*4	80	SikaCor® EG-1 VHS	100	SikaCor® EG-5*5	80	3	260																
SikaCor® Zinc R*4	60	SikaCor®-2440 MF	120	SikaCor® EG-5*5	80	3	260																
SikaCor® Zinc R*4	80	Sika Poxicolor®	120	Sika Poxicolor®	120	3	320																
Sika® Permacor®-2311 Rapid	80	Sika® Permacor®-2215 EG VHS	160	Sika® Permacor®-2230 VHS	80	3	320																
SikaCor® Zinc R*4	80	SikaCor® EG-1 VHS	160	SikaCor® EG-5*5	80	3	320																
SikaCor® Zinc R*4	80	SikaCor® EG-1*2	2 x 80	SikaCor® EG-5*5	80	4	320																
Sika® Permacor®-2204 VHS	140	Sika® Permacor®-2204 VHS	140	SikaCor® EG-5*5	80	3	360																

*1alternatively SikaCor® EG Phosphat Rapid/Plus **2alternatively SikaCor® EG-1 Rapid/Plus *3alternatively SikaCor® PUR Color Plus **alternatively SikaCor®Zinc R Rapid
*5alternatively SikaCor® EG-4, Sika® Permacor®-2330 oder Sika® Permacor®-2230 VHS **6alternatively SikaCor®-6630 Plus *7alternatively SikaCor®-6630 Primer Plus

TABLE 2
SELECTION OF COATING SYSTEMS ON HOT-DIP
GALVANIZED STEEL

DUPLIX SYSTEMS FOR CORROSION PROTECTION OF STEEL STRUCTURES IN VARIOUS ATMOSPHERIC CONDITIONS
ACCORDING TO ISO 12944-5:2018. SURFACE PREPARATION: HOT-DIP GALVANIZED ACCORDING TO ISO 1461 / ISO 14713

Primer		Intermediate coat		Top coat		Total system		Corrosivity category															
Product name	NDFT [µm]	Product name	NDFT [µm]	Product name	NDFT [µm]	Number of coats	NDFT [µm]	C2				C3				C4				C5			
								low	medium	high	very high	low	medium	high	very high	low	medium	high	very high	low	medium	high	very high
SikaCor® EG-1*2	80					1	80																
SikaCor®-6630 High Solid*6	80			SikaCor®-6630 High Solid*6	80	2	160																
SikaCor® EG-1 VHS	120					1	120																
				SikaCor® EG-120	120	1	120																
SikaCor®-6630 High Solid*6	100			SikaCor®-6630 High Solid*6	100	2	200																
SikaCor® EG-1*2	80			SikaCor® EG-5*5	80	2	160																
Sika Poxicolor® Rapid	100			SikaCor® EG-120	100	2	200																
SikaCor® EG-1*2	120			SikaCor® EG-5*5	80	2	200																
SikaCor® EG-1 VHS	140			SikaCor® EG-5*5	60	2	200																
Sika Poxicolor®	120			Sika Poxicolor®	120	2	240																
Sika Poxicolor® Rapid	120			SikaCor® EG-120	120	2	240																
SikaCor® EG-1 VHS	160			SikaCor® EG-5*5	80	2	240																
SikaCor® EG-1*2	80	SikaCor® EG-1*2	80	SikaCor® EG-5*5	80	3	240																

*1alternatively SikaCor® EG Phospat Rapid/Plus **2alternatively SikaCor® EG-1 Rapid/Plus **3alternatively SikaCor® PUR Color Plus **4alternatively SikaCor® Zinc R Rapid
*5alternatively SikaCor® EG-4, Sika® Permacor®-2330 oder Sika® Permacor®-2230 VHS **6alternatively SikaCor®-6630 Plus **7alternatively SikaCor®-6630 Primer Plus

TABLE 3 SELECTION OF COATING SYSTEMS FOR REFURBISHMENT OF OLD COATINGS

COATING SYSTEMS FOR CORROSION PROTECTION OF STEEL STRUCTURES IN VARIOUS ATMOSPHERIC CONDITIONS
ACCORDING TO ISO 12944-5:2018.

Partial surface preparation	Primer		Intermediate coat		Top coat		Total system		Corrosivity category															
	Product name	NDFT [µm]	Product name	NDFT [µm]	Product name	NDFT [µm]	Number of coats	NDFT [µm]	C2				C3				C4				C5			
									low	medium	high	very high	low	medium	high	very high	low	medium	high	very high	low	medium	high	very high
P St 2/P St 3	SikaCor® Aktivprimer Rapid	80	SikaCor®-6630 High Solid**6	80	SikaCor®-6630 High Solid**6	80	3	240																
P St 2/P St 3	SikaCor®-6630 Primer**7	80	SikaCor®-6630 High Solid**6	80	SikaCor®-6630 High Solid**6	80	3	240																
P St 2/P St 3	Sika Poxicolor® Primer HE NEW	120			SikaCor® EG-120	120	2	240																
P St 2/P St 3	Sika Poxicolor® Primer HE NEW	80	SikaCor® EG-1 VHS	80	SikaCor® EG-4 oder EG-5	80	3	240																
P Ma	Sika Poxicolor® Primer HE NEW	120			Sika Poxicolor®	120	2	240																
P Ma	Sika Poxicolor® Primer HE NEW	100	SikaCor® EG-1 VHS	100			2	200																
P Ma	Sika Poxicolor® Primer HE NEW	100			SikaCor® EG-4 oder EG-5	80	2	180																
P Sa 2½	SikaCor® EG Phosphat**1	100	SikaCor® EG-1**2	120			2	220																
P Sa 2½	SikaCor® EG Phosphat**1	100			SikaCor® EG-4 oder EG-5	80	2	180																

**1alternatively SikaCor® EG Phosphat Rapid/Plus **2alternatively SikaCor® EG-1 Rapid/Plus **3alternatively SikaCor® PUR Color Plus **4alternatively SikaCor® Zinc R Rapid
**5alternatively SikaCor® EG-4, Sika® Permacor®-2330 oder Sika® Permacor®-2230 VHS **6alternatively SikaCor®-6630 Plus **7alternatively SikaCor®-6630 Primer Plus

TABLE 5
PRODUCT FEATURES OF OUR INTERMEDIATE
COATS

Intermediate coat	Density [kg/l]	Volume solids		Dry film thick-ness [µm]	Theor. mat. con-sumption [kg/m ²]	Min. application tempera-ture	Waiting time until over-coating ¹⁾		Suitable coatings systems									
		Vol. [%]	Wt [%]				at 10°C	at 20°C	SikaCor® EG System / Plus	SikaCor® EG-120	SikaCor® EG-1 VHS	SikaCor® EG-System Rapid	SikaCor® EG-1 / Plus / Rapid	SikaCor® EG-4 / EG-5	Sika® Permacor®-2230 VHS	Sika® Permacor®-2215 EG VHS	Sika® Permacor®-2330	Sika® Permacor®-2707
SikaCor® EG-1 2-pack low-solvent, micaceous iron oxide epoxy intermediate coat for primed steel or directly on galvanised steel, acc. to TL/TP-KOR-Stahlbauten, Blatt 87	1.6	60	77	80-120	0.215 - 0.320	+ 5°C	10 h	6 h	●	●		●	●	●	●		●	
SikaCor® EG-1 Plus 2-pack low-solvent, micaceous iron oxide epoxy intermediate coat for primed steel or directly on galvanised steel, acc. to TL/TP-KOR-Stahlbauten, Blatt 87	1.5	70	83	80-120	0.170 - 0.250	+ 5°C	8 h	4 h	●	●			●	●	●		●	
SikaCor® EG-1 Rapid 2-pack low-solvent, micaceous iron oxide epoxy intermediate coat for primed steel or directly on galvanised steel, acc. to TL/TP-KOR-Stahlbauten, Blatt 97	1.6	56	77	80-120	0.230 - 0.350	- 10°C	5 h	3 h		●		●	●	●	●		●	
SikaCor® EG-1 VHS 2-pack very high solid, micaceous iron oxide epoxy intermediate coat for primed steel or directly on galvanised steel, acc. to TL/TP-KOR-Stahlbauten, Blatt 94	1.8	78	90	80-160	0.185 - 0.370	+ 5°C	13 h	5 h		●			●	●	●		●	
Sika® Permacor®-2215 EG VHS 2-pack very high solid, micaceous iron oxide epoxy intermediate coat	1.9	72	87	80-160	0.211 - 0.422	+ 5°C	11 h	5 h						●	●	●	●	
Sika® Permacor®-2706 EG 2-pack micaceous iron oxide epoxy intermediate coat for primed steel or directly on galvanised steel	1.4	45	66	40	0.125	+ 10°C	24 h	16 h			●		●	●	●		●	●
SikaCor® ZP-1 2-pack polyurethane micaceous iron oxide intermediate coat for primed steel according to TL/TP-KOR-Stahlbauten, Blatt 87/97	1.6 1.5 ²⁾	60 63 ²⁾	77 79 ²⁾	80-120	0.215 - 0.320 0.190 - 0.290 ²⁾	0°C ³⁾	2 h	1,5 h						●	●		●	

¹⁾ The drying times depend on the film thickness and refer to 80 - 100 µm dry film thickness ²⁾ Data based on micaceous iron oxide colours
³⁾ Accelerated with SikaCor® PUR Accelerator

TABLE 6
PRODUCT FEATURES OF OUR TOP COATS

Top coats	Density [kg/l]	Volume solids		Dry film thickness [µm]	Theor. mat. consumption [kg/m ²]	Min. application temperature	Waiting time between overcoating ¹⁾		Suitable primer in terms of refurbishment					
		Vol. [%]	Wt [%]				at 10°C	at 20°C	SikaCor® Aktivprimer Rapid	SikaCor®-6630 High Solid / Plus	SikaCor®-6630 Primer / Plus	Sika® CorroTop NEW / EG	Sika Poxicolor® Primer HE NEW (Sa 2½)	SikaCor® EG Phosphat
SikaCor®-6630 High Solid 1-pack oxidative drying high-build coating in RAL or DB colour shades ⁴⁾	1.4 1.5 ²⁾	62 61 ²⁾	77 77 ²⁾	80 - 160	0.180 - 0.360 0.195 - 0.390 ²⁾	+ 5°C	36 h	24 h	●	●	●		●	
SikaCor®-6630 Plus 1-pack oxidative drying high-build coating in RAL or DB colour shades ⁴⁾ , acc. to TL/TP-KOR-Stahlbauten, Blatt 93	1.3 1.4 ²⁾	64 63 ²⁾	77 77 ²⁾	80 - 160	0.165 - 0.340 0.180 - 0.360 ²⁾	+ 5°C	36 h	24 h	●	●	●		●	
SikaCor® EG-4 2-pack acrylic polyurethane top coat containing micaceous iron oxide pigments (MIO) in DB colour shades ⁴⁾ , acc. to TL/TP-KOR-Stahlbauten, Blatt 87	1.4	55	70	60 - 100	0.153 - 0.256	+ 5°C	16 h 12 h ³⁾	12 h 4 h ³⁾					●	●
SikaCor® EG-5 2-pack acrylic polyurethane top coat in RAL colour shades, acc. to TL/TP-KOR-Stahlbauten, Blatt 87	1.3	61	74	60 - 100	0.130 - 0.217	+ 5°C	18 h 13 h ³⁾	14 h 5 h ³⁾					●	●
SikaCor® EG-120 2-pack very high solid polyurethane top coat in RAL and DB colour shades ⁴⁾ ; for the application on primers or direct to metal (steel, galvanized steel or aluminium)	1.3 1.6 ²⁾	70 70 ²⁾	80 83 ²⁾	60 - 120	0.149 - 0.223 0.183 - 0.274 ²⁾	+ 5°C	20 h	11 h					●	●
SikaCor® EP Color 2-pack primer and top coat based on epoxy resin with anti-corrosion pigments in RAL colour shades	1.6	62	80	80	0.205	+ 5°C	7 h	3,5					●	●
SikaCor® PUR Color NEW 2-pack primer and top coat based on polyurethane with anti-corrosion pigments, in silk-matt RAL colour shades	1.4	56	73	80 - 180	0.200 - 0.450	+ 5°C	6 h - 9 h 3 h - 4 h	4 h - 6 h 2 h - 3 h					●	●
SikaCor® PUR Color Plus 2-pack primer and top coat based on polyurethane with anti-corrosion pigments, in silk-att RAL colour shades	1.2	66	74	80 - 180	0.144 - 0.324	+ 5°C	6 h - 9 h	4 h - 6 h					●	●
SikaCor® Steel Protect VHS Rapid 1-pack synthetic resin-based primer and top coat	1.55	65	81	60 - 160	0.143 - 0.380	+ 5°C	12 h	5 h					●	
Sika® CorroTop NEW/EG 1-pack alkyd resin top coat with smooth, glossy surface in RAL and DB colour shades ⁴⁾	1.3	56	73	60 - 120	0.140 - 0.280 0.150 - 0.300 ²⁾	+ 5°C	24 h	12 h	●	●	●	●	●	
Sika® Permacor®-2230 VHS 2-pack very high solid, acrylic polyurethane top coat in RAL colour shades with high weather and colour stability	1.4	70	82	60 - 100	0.120 - 0.200	+ 5°C	14 h	5 h					●	
Sika® Permacor®-2330 2-pack acrylic polyurethane top coat in RAL colour shades with increased weathering and colour stability	1.3	56	69	50 - 80	0.115 - 0.185	+ 5°C	18 h	8 h					●	●
Sika Poxicolor® Very low-solvent, micaceous iron oxide free, 2-pack primer, intermediate and top coat based on epoxy resin combination binders, acc. to TL/TP-KOR-Stahlbauten, Blatt 81	1.6	76	87	80 - 120	0.196 - 0.250	+ 5°C	12 h	6 h					●	

¹⁾ The drying times depend on the film thickness and refer to 80 - 100 µm dry film thickness ²⁾ Data based on micaceous iron oxide colours
³⁾ Accelerated with SikaCor® PUR Accelerator ⁴⁾ Metallic MIO colour shades acc. DB standard

OUR COMPETENCE

THE BUSINESS UNIT INDUSTRIAL COATINGS of Sika Deutschland GmbH develops, produces and sells high-quality coatings for corrosion and fire protection. We can look back on a long and successful story with numerous innovations.

APPLICATION AREAS

CORROSION PROTECTION

TRAFFIC CONSTRUCTION



- motorway bridge / road bridge
- railway bridge
- suspension bridge
- walkway

STEEL STRUCTURES



- port facilities
- centers for culture and events
- airports
- railway stations

HYDRAULIC STEEL STRUCTURES



- waterways
- port facilities
- flood protection
- steel sheet piles

FIRE PROTECTION

FOR STEEL



- solvent-free systems
- water-based systems
- solvent-based systems

TANK PROTECTION



- tanks
- silos and vessels
- pipeworks
- secondary containment

CHEMISTRY AND INDUSTRY



- mineral oil industry
- plants in atmospheric conditions
- refineries

POWER SUPPLY



- power stations
- pipelines
- wind energy
- mast coatings

FOR WOOD AND CONCRETE



- timber construction elements
- concrete

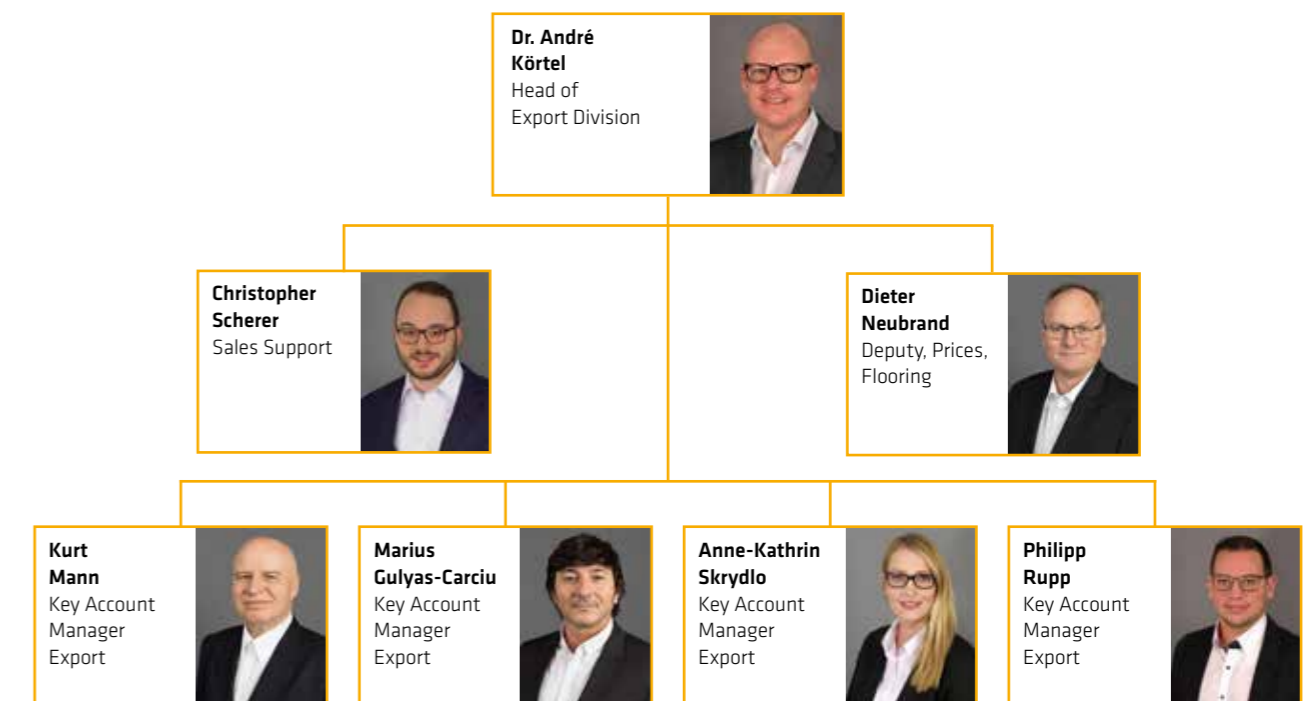
Innovative products combined with high economic efficiency are the contribution to social responsibility as well as ecological and social awareness. The use of modern, high-quality coating materials with a low VOC content, optimum processing properties and a long durability is the claim that Sika Deutschland GmbH fulfills in a wide variety of applications areas.

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 - are promoting products and systems solutions of industrial coatings to architects, specifiers and governmental authorities.
 - support and train other local Sika subsidiaries.



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