



# **QENOS P/L**

**Botany Industrial Park**

**Corrosion Protection  
Systems**

**New Work  
&  
Maintenance**

**May 2006 V1.0**

**Prepared By:**

**Ian Clark Dulux Protective Coatings.**

# QENOS P/L

## CORROSION PROTECTION SYSTEMS SUMMARY

### MAINTENANCE

ENVIRONMENT	SUBSTRATE	SYSTEM	COLOUR
Interior & Exterior steel all areas	Mild steel, aged coatings & galvanised.	Schedule A	Full colour range
Immersion: Acids, Alkali or Solvents	<b>Refer to Dulux</b>	Schedule B	
Tank linings fresh, salt de-ionised water	Mild steel	Schedule C	Limited colour range
Piping: Buried or immersed	Mild Steel or Galvanising	Schedule D	Limited colour range
Bund areas, drains, splash & spillage areas	Concrete	Schedule E	Grey
High Temp 200° to 600° C Lagged	Existing coated mild steel	Schedule F	Grey
High Temp 200° to 600° C Unlagged	Existing coated mild steel	Schedule G	Silver
Interior & Exterior steel up to 200° C Lagged or Unlagged	Existing coated mild steel	Schedule H	Grey
Interior & Exterior where the surface is permanently below the dewpoint	Concrete and Steel	Schedule I	Clear



**CORROSION PROTECTION SYSTEMS**  
**QENOS P/L**

**COATING SPECIFICATION**  
**PCN/0506/1059 Version 1.**  
**2-Jun-06**

**PREPARED FOR:-**

**Ken Hickey**  
**Qenos P/L**

# DULUX PROTECTIVE COATINGS

## COATING SPECIFICATION

Specification No: **PCN/0506/1059**

**Version 1.**

**Schedule A**

<b>PROJECT:</b>	<b>CORROSION PROTECTION SYSTEMS</b> <b>QENOS P/L</b>
<b>SITE:</b>	<b>Botany NSW</b>
<b>SCOPE:</b>	The preparation and maintenance painting of existing coated steel structures and items to improve corrosion protection. Interior and exterior all areas.
<b>SUBSTRATE:</b>	Mild Steel
<b>SURFACE PREPARATION</b>	<p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by washing with an alkali based detergent and fresh potable water prior to any further surface preparation being carried out. Refer to AS1627.1 Part 1.4.4 - 1.4.6.</p> <p>Round off all rough welds and remove all weld spatter or slag. Sharp steel edges, including bolt holes, shall be rounded to a 2mm (min) radius.</p> <p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by cleaning to AS 1627 part 1. Round off all rough welds, sharp steel edges to a 2 mm radius and remove weld spatter or slag. All surfaces to be treated are to be cleaned down by hand or power tool cleaning methods to achieve a clean surface that is free of loose, flaking rust, mill scale etc. (As per AS1627.2 Class 2) Any foreign matter such as residual dusts from cleaning must be removed before painting commences. Avoid handling cleaned steel with bare hands. Apply initial coating within a four (4) hour period after preparation completed or before any surface deterioration occurs.</p> <p>Remove all spent abrasive, foreign matter and residual dust by using dry compressed air, sweeping with a clean brush or vacuum cleaning prior to application of the coating. The coating should initially be applied by brush to all welds, edges, bolt holes and cleats to ensure complete coverage is achieved.</p>

# COATING SPECIFICATION

Specification No: **PCN/0506/1059**      **Version 1.**      **Schedule A**

SURFACE PROFILE		N/A					
	FIRST COAT		SECOND COAT		THIRD COAT		
<b>MATERIAL</b>	DUREBILD STE GLASS FLAKE Spot / Stripe Coat		DUREBILD STE GLASS FLAKE		WEATHERMAX HBR		
<b>PRODUCT CODE</b>	775-LINE		775-LINE		770-Line		
<b>HARDENER CODE</b>	976-84539		976-84539		976-84593		
<b>DATA SHEET</b>	PC239		PC239		PC 405		
<b>THINNER</b>	EPOXY THINNER		EPOXY THINNER		DUTHIN 040		
<b>THINNER CODE</b>	920-08925		920-08925		965 42166		
<b>COLOUR</b>	AS SELECTED		AS SELECTED		AS SELECTED		
<b>APPLICATION</b>	B, R, CS or AS		B, R, CS or AS		B, R, CS or AS		
<b>% VOL. SOLIDS</b>	84.0%		84.0%		70.0%		
<b>THEO. COVERAGE</b>	3.4 sqm/l (@ 250 microns)		3.4 sqm/l (@ 250 microns)		7.0 sqm/l (@ 100 microns)		
<b>FILM THICKNESS</b>	<b>WFT**</b>	<b>DFT</b>	<b>WFT**</b>	<b>DFT</b>	<b>WFT**</b>	<b>DFT</b>	
<b>MINIMUM</b>	240 Microns	200 Microns	240 Microns	200 Microns	110 Microns	75 Microns	
<b>MAXIMUM</b>	600 Microns	500 Microns	600 Microns	500 Microns	180 Microns	125 Microns	
<b>RECOAT TIME</b>	<b>MIN. 14 HOURS</b>		<b>MIN. 14 HOURS</b>		<b>MIN. 10 HOURS</b>		
<b>@ 25 C &amp; 50% RH</b>	<b>MAX. 4 WEEKS</b>		<b>MAX. 4 WEEKS</b>		<b>MAX. INDEFINITE</b>		
<b>ABR.</b>	B = Brush, R = Roller, TR = Texture Roller CS = Conventional Spray, AS = Airless Spray, T = Trowel.						

\* Theoretical Coverage is the area which one litre of the material will cover at the specified Dry Film Thickness assuming it is applied to a perfectly smooth surface and absolutely no losses.

\*\* WFT is the thickness of wet paint required to be applied to the surface to achieve the specified Dry Film Thickness' assuming there is no thinner added.

### Specific Recommendations & Comments:

All work shall conform to AS 3894 parts 10, 11, 12, 13, 14. The minimum dry film thickness of this coating system shall be 300 microns comprising 200 microns of Durebild STE Glass Flake and 100 microns of Weathermax HBR. PLEASE NOTE: film thickness readings shall be taken at the completion of the surface preparation to facilitate the quality control of the new work. Where the existing coatings are removed, a spot / stripe coat of Durebild STE Glass flake shall be included. Where this coat is used, the overall film thickness shall be 450 microns.

If the coatings are to be applied by brush or roller additional coats may be required to achieved total specified DFT.

Work should be carried out by a competent coating applicator experienced in using these types of industrial coatings.

# COATING SPECIFICATION

Specification No: **PCN/0506/1059**

Version **1.**

Schedule **A**

## Explanatory Notes:

1. DULUX is a Quality Endorsed Company - International Standards ISO9001, ISO9002 & Australian Standards AS3901, AS3902.
2. Refer to DULUX personnel listed below for additional information.
3. This is an abridged specification and must be read in conjunction with appropriate technical data sheet(s).
4. The use of a thinner other than that nominated herein may impair performance of the coating.
5. The coating should be protected from the elements and contamination during coating cure to achieve maximum life.
6. System life is dependent upon service conditions.
7. Pay particular attention to achieving adequate DFT at edges to ensure long service life.
8. The appropriate abrasives are to be selected to provide the specific surface profile. This is vital to ensure the appropriate coating adhesion.
9. Practical spreading rates will vary from quoted theoretical figures depending on substrate porosity, surface roughness over spray losses, application methods and environmental conditions (e.g. wind).
10. Application techniques should be adjusted to achieve the recommended Dry Film Thickness. Thus if application is by brush or roller additional coats may be required to achieve the specified Dry Film thickness.
11. Dry times apply to a single coat at 25 deg C and 50% Relative Humidity
12. Do not apply paint if Relative Humidity is above 85% or surface temperature is within 3 deg C of Dew Point or the surface temperature exceeds 45 deg C.
13. Galvanised surfaces present unique problems for applied coatings such as white rusting of the galvanising layer and subsequent coating delamination, particularly in locations up to several kilometres from the coast. Therefore, Dulux claims no responsibility for the performance of Dulux coatings applied to galvanised surfaces.
14. The specification(s) issued by Dulux Australia in this document have been selected as being suitable for the exposure environment(s) based upon the information given to Dulux by the customer or customer's authorised agent at the time of issue. Changes to the exposure environment and conditions or changes to liquid stored cargoes in contact with the coating(s) may also change the expected performance outcomes for the materials specified.

## DULUX Contacts:

**REQUESTED BY:** **Peter Vilcek 0411 024 118**

**PREPARED BY:** **Ian Clark 02 9794 9423**

**REVIEWED BY:**

**DATE:** **2-Jun-06**

## PREPARED FOR:

**NAME:** **Ken Hickey**

**PHONE No.:**

**COMPANY:** **Qenos P/L**

**FAX No.:**

A Division of ORICA Australia Pty Ltd A.B.N.99 004 117 828

## Disclaimer:

Any advise, recommendation, information, assistance or service provided by ORICA Australia (Dulux) in relation to goods manufactured by it or their use and application is given in good faith and is believed by ORICA to be appropriate and reliable. However, any advise, recommendation, information, assistance or service provided by ORICA is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the rights, entitlements and remedies conferred upon any person or the liabilities impaired upon ORICA by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance rendering void or prohibiting such exclusion, limitation, restriction or modification.

# DULUX PROTECTIVE COATINGS

## COATING SPECIFICATION

Specification No: **PCN/0506/1059** **Version 1.**

**Schedule B**

<b>PROJECT:</b>	<b>CORROSION PROTECTION SYSTEMS</b> QENOS P/L
<b>SITE:</b>	Botany NSW
<b>SCOPE:</b>	<b>IMMERSION IN ACID,ALKALI OR SOLVENT</b>
<b>SUBSTRATE:</b>	Mild Steel
<b>SURFACE PREPARATION</b>	<b>Refer to Dulux for specific recommendations. See contacts below.</b>

# DULUX PROTECTIVE COATINGS

## COATING SPECIFICATION

Specification No: **PCN/0506/1059**

**Version 1.**

**Schedule C**

<b>PROJECT:</b>	<b>CORROSION PROTECTION SYSTEMS</b> <b>QENOS P/L</b>
<b>SITE:</b>	<b>Botany NSW</b>
<b>SCOPE:</b>	The preparation and coating of existing coated steel for the interior lining of tanks storing fresh, de-ironised and salt water with an operating temperature below 95 degrees C
<b>SUBSTRATE:</b>	Existing coated steel
<b>SURFACE PREPARATION</b>	<p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by washing with an alkali based detergent and fresh potable water prior to any further surface preparation being carried out. Refer to AS1627.1 Part 1.4.4 - 1.4.6.</p> <p>Round off all rough welds and remove all weld spatter or slag. Sharp steel edges, including bolt holes, shall be rounded to a 2mm (min) radius.</p> <p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by cleaning to AS1627.1. Round off all rough welds, sharp steel edges to a 2 mm radius and remove all weld spatter or slag. All surfaces to be treated are to be dry abrasive blast cleaned to AS1627.9 Class 3, White Metal. Remove all spent abrasive and residual dust by using dry compressed air, sweeping with a clean brush or vacuum cleaning prior to application of the coating. Avoid handling blasted steel with bare hands. The surface should be inspected prior to coating to ensure no contamination is present and no surface defects exist. If so, rectification is required before any coating is applied. Apply initial coating within a four (4) hour period after blasting or before any surface deterioration occurs.</p> <p>Remove all spent abrasive, foreign matter and residual dust by using dry compressed air, sweeping with a clean brush or vacuum cleaning prior to application of the coating. The coating should initially be applied by brush to all welds, edges, bolt holes and cleats to ensure complete coverage is achieved.</p>

# COATING SPECIFICATION

Specification No: **PCN/0506/1059** **Version 1.**

**Schedule C**

**SURFACE PROFILE** Minimum 30 microns; Maximum 50 microns

	FIRST COAT	SECOND COAT	THIRD COAT
<b>MATERIAL</b>	DUREBILD TLE	DUREBILD TLE	None
<b>PRODUCT CODE</b>	781-LINE	781-LINE	
<b>HARDENER CODE</b>	976-84397	976-84397	
<b>DATA SHEET</b>	PC221	PC221	
<b>THINNER</b>	EPOXY THINER	EPOXY THINER	
<b>THINNER CODE</b>	920-08925	920-08925	
<b>COLOUR</b>	AS SELECTED	AS SELECTED	
<b>APPLICATION</b>	CS or AS	CS or AS	
<b>% VOL. SOLIDS</b>	52.0%	52.0%	
<b>THEO. COVERAGE</b>	4.5 sqm/l (@ 125 microns)	4.5 sqm/l (@ 125 microns)	
<b>FILM THICKNESS</b>	<b>WFT**</b>	<b>DFT</b>	<b>WFT**</b> <b>DFT</b>
<b>MINIMUM</b>	200 Microns	100 Microns	200 Microns    100 Microns
<b>MAXIMUM</b>	400 Microns	200 Microns	400 Microns    200 Microns
<b>RECOAT TIME</b>	<b>MIN. 10 HOURS</b>	<b>MIN. 10 HOURS</b>	
<b>@ 25 C &amp; 50% RH</b>	<b>MAX. 2 WEEKS</b>	<b>MAX. 2 WEEKS</b>	
<b>ABR.</b>	B = Brush, R = Roller, TR = Texture Roller CS = Conventional Spray, AS = Airless Spray, T = Trowel.		

\* Theoretical Coverage is the area which one litre of the material will cover at the specified Dry Film Thickness assuming it is applied to a perfectly smooth surface and absolutely no losses.

\*\* WFT is the thickness of wet paint required to be applied to the surface to achieve the specified Dry Film Thickness' assuming there is no thinner added.

### Specific Recommendations & Comments:

All work shall conform to AS 3894 parts 10, 11, 12, 13, 14. The minimum dry film thickness of this coating system shall be 250 microns comprising 2 coats of 125 microns each of Durebild TLE. At no time shall either single coat exceed 200 microns.

For coatings subjected to immersion conditions Holiday testing, as per AS3894.1.2, is to be conducted for the identification of pinholes or voids (holidays) within the coating film. The coating **MUST** be fully cured prior to holiday testing.

If the coatings are to be applied by brush or roller additional coats may be required to achieved total specified DFT.

Work should be carried out by a competent coating applicator experienced in using these types of industrial coatings.

# COATING SPECIFICATION

Specification No: **PCN/0506/1059**

Version **1.**

Schedule **C**

## Explanatory Notes:

1. DULUX is a Quality Endorsed Company - International Standards ISO9001, ISO9002 & Australian Standards AS3901, AS3902.
2. Refer to DULUX personnel listed below for additional information.
3. This is an abridged specification and must be read in conjunction with appropriate technical data sheet(s).
4. The use of a thinner other than that nominated herein may impair performance of the coating.
5. The coating should be protected from the elements and contamination during coating cure to achieve maximum life.
6. System life is dependent upon service conditions.
7. Pay particular attention to achieving adequate DFT at edges to ensure long service life.
8. The appropriate abrasives are to be selected to provide the specific surface profile. This is vital to ensure the appropriate coating adhesion.
9. Practical spreading rates will vary from quoted theoretical figures depending on substrate porosity, surface roughness over spray losses, application methods and environmental conditions (e.g. wind).
10. Application techniques should be adjusted to achieve the recommended Dry Film Thickness. Thus if application is by brush or roller additional coats may be required to achieve the specified Dry Film thickness.
11. Dry times apply to a single coat at 25 deg C and 50% Relative Humidity
12. Do not apply paint if Relative Humidity is above 85% or surface temperature is within 3 deg C of Dew Point or the surface temperature exceeds 45 deg C.
13. Galvanised surfaces present unique problems for applied coatings such as white rusting of the galvanising layer and subsequent coating delamination, particularly in locations up to several kilometres from the coast. Therefore, Dulux claims no responsibility for the performance of Dulux coatings applied to galvanised surfaces.
14. The specification(s) issued by Dulux Australia in this document have been selected as being suitable for the exposure environment(s) based upon the information given to Dulux by the customer or customer's authorised agent at the time of issue. Changes to the exposure environment and conditions or changes to liquid stored cargoes in contact with the coating(s) may also change the expected performance outcomes for the materials specified.

## DULUX Contacts:

**REQUESTED BY:** **Peter Vilcek 0411 024 118**

**PREPARED BY:** **Ian Clark 02 9794 9423**

**REVIEWED BY:**

**DATE:** **2-Jun-06**

## PREPARED FOR:

**NAME:** **Ken Hickey**

**PHONE No.:**

**COMPANY:** **Qenos P/L**

**FAX No.:**

A Division of ORICA Australia Pty Ltd A.B.N.99 004 117 828

## Disclaimer:

Any advise, recommendation, information, assistance or service provided by ORICA Australia (Dulux) in relation to goods manufactured by it or their use and application is given in good faith and is believed by ORICA to be appropriate and reliable. However, any advise, recommendation, information, assistance or service provided by ORICA is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the rights, entitlements and remedies conferred upon any person or the liabilities impaired upon ORICA by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance rendering void or prohibiting such exclusion, limitation, restriction or modification.

# DULUX PROTECTIVE COATINGS

## COATING SPECIFICATION

Specification No: **PCN/0506/1059**

**Version 1.**

**Schedule D**

<b>PROJECT:</b>	<b>CORROSION PROTECTION SYSTEMS</b> <b>QENOS P/L</b>
<b>SITE:</b>	<b>Botany NSW</b>
<b>SCOPE:</b>	The preparation and maintenance painting of existing coated steel pipe at various locations in buried or submersed conditions.
<b>SUBSTRATE:</b>	Mild Steel
<b>SURFACE PREPARATION</b>	<p>Excavation of the pipe may be required. Consult the site superintendent to establish pipe location, condition and arrange excavation and shoring.</p> <p>All surfaces to be painted shall be washed down with fresh potable water by high pressure water blasting at a suitable pressure to remove all surface contamination.</p> <p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by cleaning to AS1627.1. Round off all rough welds, sharp steel edges to a 2 mm radius and remove all weld spatter or slag. All surfaces to be treated are to be dry abrasive blast cleaned to AS1627.9 Class 3, White Metal. Remove all spent abrasive and residual dust by using dry compressed air, sweeping with a clean brush or vacuum cleaning prior to application of the coating. Avoid handling blasted steel with bare hands. The surface should be inspected prior to coating to ensure no contamination is present and no surface defects exist. If so, rectification is required before any coating is applied. Apply initial coating within a four (4) hour period after blasting or before any surface deterioration occurs.</p> <p>Remove all spent abrasive, foreign matter and residual dust by using dry compressed air, sweeping with a clean brush or vacuum cleaning prior to application of the coating. The coating should initially be applied by brush to all welds, edges, bolt holes and cleats to ensure complete coverage is achieved.</p>

# COATING SPECIFICATION

Specification No: **PCN/0506/1059**

Version **1.**

Schedule **D**

SURFACE PROFILE		N/A					
	FIRST COAT	SECOND COAT		THIRD COAT			
<b>MATERIAL</b>	LUXEPOXY UHB	None		None			
<b>PRODUCT CODE</b>	742-50688						
<b>HARDENER CODE</b>	976-50689						
<b>DATA SHEET</b>	PC240						
<b>THINNER</b>	DO NOT THIN						
<b>THINNER CODE</b>	N/A						
<b>COLOUR</b>	GREY						
<b>APPLICATION</b>	AS						
<b>% VOL. SOLIDS</b>	100.0%						
<b>THEO. COVERAGE</b>	2.0 lt/sqmt (@ 2000 microns)						
<b>FILM THICKNESS</b>	WFT**	DFT	WFT**	DFT	WFT**	DFT	
<b>MINIMUM</b>	2000 Microns	2000 Microns					
<b>MAXIMUM</b>	5000 Microns	5000 Microns					
<b>RECOAT TIME</b>	<b>MIN. 8 HOURS</b>						
<b>@ 25 C &amp; 50% RH</b>	<b>MAX. 24 HOURS</b>						
<b>ABR.</b>	B = Brush, R = Roller, TR = Texture Roller CS = Conventional Spray, AS = Airless Spray, T = Trowel.						

\* Theoretical Coverage is the area which one litre of the material will cover at the specified Dry Film Thickness assuming it is applied to a perfectly smooth surface and absolutely no losses.

\*\* WFT is the thickness of wet paint required to be applied to the surface to achieve the specified Dry Film Thickness' assuming there is no thinner added.

### Specific Recommendations & Comments:

All work shall conform to AS 3894 parts 10, 11, 12, 13, 14. The minimum dry film thickness of this coating system shall be 3000 microns comprising a single multiple pass coat of Luxepoxy UHB.

For coatings subjected to immersion conditions Holiday testing, as per AS3894.1.2, is to be conducted for the identification of pinholes or voids (holidays) within the coating film. The coating **MUST** be fully cured prior to holiday testing.

If the coatings are to be applied by brush or roller additional coats may be required to achieved total specified DFT.

Work should be carried out by a competent coating applicator experienced in using these types of industrial coatings.

# COATING SPECIFICATION

Specification No: **PCN/0506/1059**

Version **1.**

Schedule **D**

## Explanatory Notes:

1. DULUX is a Quality Endorsed Company - International Standards ISO9001, ISO9002 & Australian Standards AS3901, AS3902.
2. Refer to DULUX personnel listed below for additional information.
3. This is an abridged specification and must be read in conjunction with appropriate technical data sheet(s).
4. The use of a thinner other than that nominated herein may impair performance of the coating.
5. The coating should be protected from the elements and contamination during coating cure to achieve maximum life.
6. System life is dependent upon service conditions.
7. Pay particular attention to achieving adequate DFT at edges to ensure long service life.
8. The appropriate abrasives are to be selected to provide the specific surface profile. This is vital to ensure the appropriate coating adhesion.
9. Practical spreading rates will vary from quoted theoretical figures depending on substrate porosity, surface roughness over spray losses, application methods and environmental conditions (e.g. wind).
10. Application techniques should be adjusted to achieve the recommended Dry Film Thickness. Thus if application is by brush or roller additional coats may be required to achieve the specified Dry Film thickness.
11. Dry times apply to a single coat at 25 deg C and 50% Relative Humidity
12. Do not apply paint if Relative Humidity is above 85% or surface temperature is within 3 deg C of Dew Point or the surface temperature exceeds 45 deg C.
13. Galvanised surfaces present unique problems for applied coatings such as white rusting of the galvanising layer and subsequent coating delamination, particularly in locations up to several kilometres from the coast. Therefore, Dulux claims no responsibility for the performance of Dulux coatings applied to galvanised surfaces.
14. The specification(s) issued by Dulux Australia in this document have been selected as being suitable for the exposure environment(s) based upon the information given to Dulux by the customer or customer's authorised agent at the time of issue. Changes to the exposure environment and conditions or changes to liquid stored cargoes in contact with the coating(s) may also change the expected performance outcomes for the materials specified.

## DULUX Contacts:

**REQUESTED BY:** **Peter Vilcek 0411 024 118**

**PREPARED BY:** **Ian Clark 02 9794 9423**

**REVIEWED BY:**

**DATE:** **2-Jun-06**

## PREPARED FOR:

**NAME:** **Ken Hickey**

**PHONE No.:**

**COMPANY:** **Qenos P/L**

**FAX No.:**

A Division of ORICA Australia Pty Ltd A.B.N.99 004 117 828

## Disclaimer:

Any advise, recommendation, information, assistance or service provided by ORICA Australia (Dulux) in relation to goods manufactured by it or their use and application is given in good faith and is believed by ORICA to be appropriate and reliable. However, any advise, recommendation, information, assistance or service provided by ORICA is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the rights, entitlements and remedies conferred upon any person or the liabilities impaired upon ORICA by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance rendering void or prohibiting such exclusion, limitation, restriction or modification.

# DULUX PROTECTIVE COATINGS

## COATING SPECIFICATION

Specification No: **PCN/0506/1059**

**Version 1.**

**Schedule E**

<b>PROJECT:</b>	<b>CORROSION PROTECTION SYSTEMS</b> <b>QENOS P/L</b>
<b>SITE:</b>	<b>Botany NSW</b>
<b>SCOPE:</b>	The preparation and coating of concrete bunds, drains, splash and spillage areas to provide containment and short term storage.
<b>SUBSTRATE:</b>	Concrete
<b>SURFACE PREPARATION</b>	<p>All surfaces to be painted shall be washed down with fresh potable water by high pressure water blasting at a suitable pressure to remove all surface contamination.</p> <p>All areas where the existing coatings are removed or dislodged must be 'chased back' with the cleaning nozzle to a point where the coating is well adhered and sound.</p> <p>The concrete surface to be coated must be cured to 80% of its final strength before applying any coating (at least 28 days). Remove all surface contamination such as oil, grease or dirt by washing with an alkali based detergent and fresh potable water. Refer to AS1627.1 Part 1.4.4 - 1.4.6. Allow the surface to dry. The surface should be "Brush Blast" cleaned to remove all laitance, surface contamination, existing coating (if present) and provide a suitable concrete surface profile for painting. All abrasive grit and dust left by this process must be removed prior to applying coatings. The surface should be inspected for any concrete imperfection / defects and these rectified prior to applying the specified coatings.</p> <p>The surface shall be inspected at this stage to evaluate the substrate condition and assess it's suitability to be coated. Refer to the site superintendent</p>

# COATING SPECIFICATION

Specification No: **PCN/0506/1059** **Version 1.** **Schedule E**

SURFACE PROFILE		N/A				
	FIRST COAT	SECOND COAT		THIRD COAT		
<b>MATERIAL</b>	LUXEPOXY UHB	None		None		
<b>PRODUCT CODE</b>	742-50688					
<b>HARDENER CODE</b>	976-50689					
<b>DATA SHEET</b>	PC240					
<b>THINNER</b>	DO NOT THIN					
<b>THINNER CODE</b>	N/A					
<b>COLOUR</b>	GREY					
<b>APPLICATION</b>	AS					
<b>% VOL. SOLIDS</b>	100.0%					
<b>THEO. COVERAGE</b>	2.0 lt/sqmt (@ 2000 microns)					
<b>FILM THICKNESS</b>	WFT**	DFT	WFT**	DFT	WFT**	DFT
<b>MINIMUM</b>	2000 Microns	2000 Microns				
<b>MAXIMUM</b>	5000 Microns	5000 Microns				
<b>RECOAT TIME</b>	<b>MIN. 8 HOURS</b>					
<b>@ 25 C &amp; 50% RH</b>	<b>MAX. 24 HOURS</b>					
<b>ABR.</b>	B = Brush, R = Roller, TR = Texture Roller CS = Conventional Spray, AS = Airless Spray, T = Trowel.					

\* Theoretical Coverage is the area which one litre of the material will cover at the specified Dry Film Thickness assuming it is applied to a perfectly smooth surface and absolutely no losses.

\*\* WFT is the thickness of wet paint required to be applied to the surface to achieve the specified Dry Film Thickness' assuming there is no thinner added.

### Specific Recommendations & Comments:

All work shall conform to AS 3894 parts 10, 11, 12, 13, 14. The minimum dry film thickness of this coating system shall be 3000 microns comprising a single multiple pass coat of Luxepoxy UHB.

If the coatings are to be applied by brush or roller additional coats may be required to achieved total specified DFT.

Work should be carried out by a competent coating applicator experienced in using these types of industrial coatings.

# COATING SPECIFICATION

Specification No: **PCN/0506/1059**

Version **1.**

Schedule **E**

## Explanatory Notes:

1. DULUX is a Quality Endorsed Company - International Standards ISO9001, ISO9002 & Australian Standards AS3901, AS3902.
2. Refer to DULUX personnel listed below for additional information.
3. This is an abridged specification and must be read in conjunction with appropriate technical data sheet(s).
4. The use of a thinner other than that nominated herein may impair performance of the coating.
5. The coating should be protected from the elements and contamination during coating cure to achieve maximum life.
6. System life is dependent upon service conditions.
7. Pay particular attention to achieving adequate DFT at edges to ensure long service life.
8. The appropriate abrasives are to be selected to provide the specific surface profile. This is vital to ensure the appropriate coating adhesion.
9. Practical spreading rates will vary from quoted theoretical figures depending on substrate porosity, surface roughness over spray losses, application methods and environmental conditions (e.g. wind).
10. Application techniques should be adjusted to achieve the recommended Dry Film Thickness. Thus if application is by brush or roller additional coats may be required to achieve the specified Dry Film thickness.
11. Dry times apply to a single coat at 25 deg C and 50% Relative Humidity
12. Do not apply paint if Relative Humidity is above 85% or surface temperature is within 3 deg C of Dew Point or the surface temperature exceeds 45 deg C.
13. Galvanised surfaces present unique problems for applied coatings such as white rusting of the galvanising layer and subsequent coating delamination, particularly in locations up to several kilometres from the coast. Therefore, Dulux claims no responsibility for the performance of Dulux coatings applied to galvanised surfaces.
14. The specification(s) issued by Dulux Australia in this document have been selected as being suitable for the exposure environment(s) based upon the information given to Dulux by the customer or customer's authorised agent at the time of issue. Changes to the exposure environment and conditions or changes to liquid stored cargoes in contact with the coating(s) may also change the expected performance outcomes for the materials specified.

## DULUX Contacts:

**REQUESTED BY:** **Peter Vilcek 0411 024 118**

**PREPARED BY:** **Ian Clark 02 9794 9423**

**REVIEWED BY:**

**DATE:** **2-Jun-06**

## PREPARED FOR:

**NAME:** **Ken Hickey**

**PHONE No.:**

**COMPANY:** **Qenos P/L**

**FAX No.:**

A Division of ORICA Australia Pty Ltd A.B.N.99 004 117 828

## Disclaimer:

Any advise, recommendation, information, assistance or service provided by ORICA Australia (Dulux) in relation to goods manufactured by it or their use and application is given in good faith and is believed by ORICA to be appropriate and reliable. However, any advise, recommendation, information, assistance or service provided by ORICA is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the rights, entitlements and remedies conferred upon any person or the liabilities impaired upon ORICA by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance rendering void or prohibiting such exclusion, limitation, restriction or modification.

# DULUX PROTECTIVE COATINGS

## COATING SPECIFICATION

Specification No: **PCN/0506/1059**

**Version 1.**

**Schedule F**

<b>PROJECT:</b>	<b>CORROSION PROTECTION SYSTEMS</b> <b>QENOS P/L</b>
<b>SITE:</b>	<b>Botany NSW</b>
<b>SCOPE:</b>	The preparation and maintenance painting of existing coated steel with an operating temperature between 200 and 600 degrees C. LAGGED
<b>SUBSTRATE:</b>	Mild Steel
<b>SURFACE PREPARATION</b>	<p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by washing with an alkali based detergent and fresh potable water prior to any further surface preparation being carried out. Refer to AS1627.1 Part 1.4.4 - 1.4.6.</p> <p>Round off all rough welds and remove all weld spatter or slag. Sharp steel edges, including bolt holes, shall be rounded to a 2mm (min) radius.</p> <p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by cleaning to AS 1627 part 1. Round off all rough welds, sharp steel edges to a 2 mm radius and remove weld spatter or slag. All surfaces to be treated are to be cleaned down by hand or power tool cleaning methods to achieve a clean surface that is free of loose, flaking rust, mill scale etc. (As per AS1627.2 Class 2) Any foreign matter such as residual dusts from cleaning must be removed before painting commences. Avoid handling cleaned steel with bare hands. Apply initial coating within a four (4) hour period after preparation completed or before any surface deterioration occurs.</p> <p>Remove all spent abrasive, foreign matter and residual dust by using dry compressed air, sweeping with a clean brush or vacuum cleaning prior to application of the coating. The coating should initially be applied by brush to all welds, edges, bolt holes and cleats to ensure complete coverage is achieved.</p>

# COATING SPECIFICATION

Specification No: **PCN/0506/1059** **Version 1.**

**Schedule F**

SURFACE PROFILE		N/A					
	FIRST COAT		SECOND COAT		THIRD COAT		
<b>MATERIAL</b>	HI TEMP UNIPRIME		HI TEMP UNIPRIME		None		
<b>PRODUCT CODE</b>	950-16185		950-16185				
<b>HARDENER CODE</b>	N/A		N/A				
<b>DATA SHEET</b>	PC926		PC926				
<b>THINNER</b>	CR REDUCER		CR REDUCER				
<b>THINNER CODE</b>	965-63020		965-63020				
<b>COLOUR</b>	GREY		GREY				
<b>APPLICATION</b>	B, R, CS or AS		B, R, CS or AS				
<b>% VOL. SOLIDS</b>	40.0%		40.0%				
<b>THEO. COVERAGE</b>	16.0 sqm/l (@ 20 microns)		16.0 sqm/l (@ 20 microns)				
<b>FILM THICKNESS</b>	<b>WFT**</b>	<b>DFT</b>	<b>WFT**</b>	<b>DFT</b>	<b>WFT**</b>	<b>DFT</b>	
<b>MINIMUM</b>	65 Microns	20 Microns	65 Microns	20 Microns			
<b>MAXIMUM</b>	100 Microns	30 Microns	100 Microns	30 Microns			
<b>RECOAT TIME</b>	MIN. 12 HOURS		MIN. 12 HOURS				
<b>@ 25 C &amp; 50% RH</b>	MAX. Until Heat Cured		MAX. Until Heat Cured				
<b>ABR.</b>	B = Brush, R = Roller, TR = Texture Roller CS = Conventional Spray, AS = Airless Spray, T = Trowel.						

\* Theoretical Coverage is the area which one litre of the material will cover at the specified Dry Film Thickness assuming it is applied to a perfectly smooth surface and absolutely no losses.

\*\* WFT is the thickness of wet paint required to be applied to the surface to achieve the specified Dry Film Thickness' assuming there is no thinner added.

### Specific Recommendations & Comments:

All work shall conform to AS 3894 parts 10, 11, 12, 13, 14. The minimum dry film thickness of this coating system shall be 50 microns comprising 2 coats of 25 microns each of Hi Temp Uniprime.

If the coatings are to be applied by brush or roller additional coats may be required to achieved total specified DFT.

Work should be carried out by a competent coating applicator experienced in using these types of industrial coatings.

Please note: the coating does not cure until elevated temperatures are reached.

# COATING SPECIFICATION

Specification No: **PCN/0506/1059**

Version **1.**

Schedule **F**

## Explanatory Notes:

1. DULUX is a Quality Endorsed Company - International Standards ISO9001, ISO9002 & Australian Standards AS3901, AS3902.
2. Refer to DULUX personnel listed below for additional information.
3. This is an abridged specification and must be read in conjunction with appropriate technical data sheet(s).
4. The use of a thinner other than that nominated herein may impair performance of the coating.
5. The coating should be protected from the elements and contamination during coating cure to achieve maximum life.
6. System life is dependent upon service conditions.
7. Pay particular attention to achieving adequate DFT at edges to ensure long service life.
8. The appropriate abrasives are to be selected to provide the specific surface profile. This is vital to ensure the appropriate coating adhesion.
9. Practical spreading rates will vary from quoted theoretical figures depending on substrate porosity, surface roughness over spray losses, application methods and environmental conditions (e.g. wind).
10. Application techniques should be adjusted to achieve the recommended Dry Film Thickness. Thus if application is by brush or roller additional coats may be required to achieve the specified Dry Film thickness.
11. Dry times apply to a single coat at 25 deg C and 50% Relative Humidity
12. Do not apply paint if Relative Humidity is above 85% or surface temperature is within 3 deg C of Dew Point or the surface temperature exceeds 45 deg C.
13. Galvanised surfaces present unique problems for applied coatings such as white rusting of the galvanising layer and subsequent coating delamination, particularly in locations up to several kilometres from the coast. Therefore, Dulux claims no responsibility for the performance of Dulux coatings applied to galvanised surfaces.
14. The specification(s) issued by Dulux Australia in this document have been selected as being suitable for the exposure environment(s) based upon the information given to Dulux by the customer or customer's authorised agent at the time of issue. Changes to the exposure environment and conditions or changes to liquid stored cargoes in contact with the coating(s) may also change the expected performance outcomes for the materials specified.

## DULUX Contacts:

**REQUESTED BY:** **Peter Vilcek 0411 024 118**

**PREPARED BY:** **Ian Clark 02 9794 9423**

**REVIEWED BY:**

**DATE:** **2-Jun-06**

## Client:

**PREPARED FOR:** **Ken Hickey**

**PHONE No.:**

**COMPANY:** **Qenos P/L**

**FAX No.:**

A Division of ORICA Australia Pty Ltd A.B.N.99 004 117 828

## Disclaimer:

Any advise, recommendation, information, assistance or service provided by ORICA Australia (Dulux) in relation to goods manufactured by it or their use and application is given in good faith and is believed by ORICA to be appropriate and reliable. However, any advise, recommendation, information, assistance or service provided by ORICA is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the rights, entitlements and remedies conferred upon any person or the liabilities impaired upon ORICA by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance rendering void or prohibiting such exclusion, limitation, restriction or modification.

# DULUX PROTECTIVE COATINGS

## COATING SPECIFICATION

Specification No: **PCN/0506/1059**

**Version 1.**

**Schedule G**

<b>PROJECT:</b>	<b>CORROSION PROTECTION SYSTEMS</b> <b>QENOS P/L</b>
<b>SITE:</b>	<b>Botany NSW</b>
<b>SCOPE:</b>	The preparation and maintenance painting of existing coated steel with an operating temperature between 200 and 600 degrees C. UNLAGGED
<b>SUBSTRATE:</b>	Mild Steel
<b>SURFACE PREPARATION</b>	<p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by washing with an alkali based detergent and fresh potable water prior to any further surface preparation being carried out. Refer to AS1627.1 Part 1.4.4 - 1.4.6.</p> <p>Round off all rough welds and remove all weld spatter or slag. Sharp steel edges, including bolt holes, shall be rounded to a 2mm (min) radius.</p> <p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by cleaning to AS 1627 part 1. Round off all rough welds, sharp steel edges to a 2 mm radius and remove weld spatter or slag. All surfaces to be treated are to be cleaned down by hand or power tool cleaning methods to achieve a clean surface that is free of loose, flaking rust, mill scale etc. (As per AS1627.2 Class 2) Any foreign matter such as residual dusts from cleaning must be removed before painting commences. Avoid handling cleaned steel with bare hands. Apply initial coating within a four (4) hour period after preparation completed or before any surface deterioration occurs.</p> <p>Remove all spent abrasive, foreign matter and residual dust by using dry compressed air, sweeping with a clean brush or vacuum cleaning prior to application of the coating. The coating should initially be applied by brush to all welds, edges, bolt holes and cleats to ensure complete coverage is achieved.</p>

# COATING SPECIFICATION

Specification No: **PCN/0506/1059** **Version 1.** **Schedule G**

SURFACE PROFILE		N/A					
	FIRST COAT		SECOND COAT		THIRD COAT		
<b>MATERIAL</b>	HI TEMP UNIPRIME		HI TEMP UNIPRIME		HI TEMP 600		
<b>PRODUCT CODE</b>	950-16185		950-16185		950-16188		
<b>HARDENER CODE</b>	N/A		N/A		N/A		
<b>DATA SHEET</b>	PC926		PC926		PC930		
<b>THINNER</b>	CR REDUCER		CR REDUCER		CR REDUCER		
<b>THINNER CODE</b>	965-63020		965-63020		965-63020		
<b>COLOUR</b>	GREY		GREY		ALUMINIUM		
<b>APPLICATION</b>	B, R, CS or AS		B, R, CS or AS		B, R, CS or AS		
<b>% VOL. SOLIDS</b>	40.0%		40.0%		28.0%		
<b>THEO. COVERAGE</b>	16.0 sqm/l (@ 20 microns)		16.0 sqm/l (@ 20 microns)		14.00 sqm/l (@ 20 microns)		
<b>FILM THICKNESS</b>	<b>WFT**</b>	<b>DFT</b>	<b>WFT**</b>	<b>DFT</b>	<b>WFT**</b>	<b>DFT</b>	
<b>MINIMUM</b>	65 Microns	20 Microns	65 Microns	20 Microns	75 Microns	20 Microns	
<b>MAXIMUM</b>	100 Microns	30 Microns	100 Microns	30 Microns	110 Microns	30 Microns	
<b>RECOAT TIME</b>	MIN. 12 HOURS		MIN. 12 HOURS		MIN. 12 HOURS		
<b>@ 25 C &amp; 50% RH</b>	MAX. Until Heat Cured		MAX. Until Heat Cured		MAX. Until Heat Cured		
<b>ABR.</b>	B = Brush, R = Roller, TR = Texture Roller CS = Conventional Spray, AS = Airless Spray, T = Trowel.						

\* Theoretical Coverage is the area which one litre of the material will cover at the specified Dry Film Thickness assuming it is applied to a perfectly smooth surface and absolutely no losses.

\*\* WFT is the thickness of wet paint required to be applied to the surface to achieve the specified Dry Film Thickness' assuming there is no thinner added.

### Specific Recommendations & Comments:

All work shall conform to AS 3894 parts 10, 11, 12, 13, 14. The minimum dry film thickness of this coating system shall be 75 microns comprising 2 coats of 25 microns each of Hi Temp Uniprime and 25 microns of Hi Temp 600.

If the coatings are to be applied by brush or roller additional coats may be required to achieved total specified DFT.

Work should be carried out by a competent coating applicator experienced in using these types of industrial coatings.

Please note: the coating does not cure until elevated temperatures are reached.

# COATING SPECIFICATION

Specification No: **PCN/0506/1059**

Version **1.**

Schedule **G**

## Explanatory Notes:

1. DULUX is a Quality Endorsed Company - International Standards ISO9001, ISO9002 & Australian Standards AS3901, AS3902.
2. Refer to DULUX personnel listed below for additional information.
3. This is an abridged specification and must be read in conjunction with appropriate technical data sheet(s).
4. The use of a thinner other than that nominated herein may impair performance of the coating.
5. The coating should be protected from the elements and contamination during coating cure to achieve maximum life.
6. System life is dependent upon service conditions.
7. Pay particular attention to achieving adequate DFT at edges to ensure long service life.
8. The appropriate abrasives are to be selected to provide the specific surface profile. This is vital to ensure the appropriate coating adhesion.
9. Practical spreading rates will vary from quoted theoretical figures depending on substrate porosity, surface roughness over spray losses, application methods and environmental conditions (e.g. wind).
10. Application techniques should be adjusted to achieve the recommended Dry Film Thickness. Thus if application is by brush or roller additional coats may be required to achieve the specified Dry Film thickness.
11. Dry times apply to a single coat at 25 deg C and 50% Relative Humidity
12. Do not apply paint if Relative Humidity is above 85% or surface temperature is within 3 deg C of Dew Point or the surface temperature exceeds 45 deg C.
13. Galvanised surfaces present unique problems for applied coatings such as white rusting of the galvanising layer and subsequent coating delamination, particularly in locations up to several kilometres from the coast. Therefore, Dulux claims no responsibility for the performance of Dulux coatings applied to galvanised surfaces.
14. The specification(s) issued by Dulux Australia in this document have been selected as being suitable for the exposure environment(s) based upon the information given to Dulux by the customer or customer's authorised agent at the time of issue. Changes to the exposure environment and conditions or changes to liquid stored cargoes in contact with the coating(s) may also change the expected performance outcomes for the materials specified.

## DULUX Contacts:

**REQUESTED BY:** **Peter Vilcek 0411 024 118**

**PREPARED BY:** **Ian Clark 02 9794 9423**

**REVIEWED BY:**

**DATE:** **2-Jun-06**

## PREPARED FOR:

**NAME:** **Ken Hickey**

**PHONE No.:**

**COMPANY:** **Qenos P/L**

**FAX No.:**

A Division of ORICA Australia Pty Ltd A.B.N.99 004 117 828

## Disclaimer:

Any advise, recommendation, information, assistance or service provided by ORICA Australia (Dulux) in relation to goods manufactured by it or their use and application is given in good faith and is believed by ORICA to be appropriate and reliable. However, any advise, recommendation, information, assistance or service provided by ORICA is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the rights, entitlements and remedies conferred upon any person or the liabilities impaired upon ORICA by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance rendering void or prohibiting such exclusion, limitation, restriction or modification.

# DULUX PROTECTIVE COATINGS

## COATING SPECIFICATION

Specification No: **PCN/0506/1059**

**Version 1.**

**Schedule H**

<b>PROJECT:</b>	<b>CORROSION PROTECTION SYSTEMS</b> <b>QENOS P/L</b>
<b>SITE:</b>	<b>Botany NSW</b>
<b>SCOPE:</b>	The preparation and maintenance painting of existing coated steel at operating temperatures up to 200 degrees C. LAGGED or UNLAGGED
<b>SUBSTRATE:</b>	Mild Steel
<b>SURFACE PREPARATION</b>	<p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by washing with an alkali based detergent and fresh potable water prior to any further surface preparation being carried out. Refer to AS1627.1 Part 1.4.4 - 1.4.6.</p> <p>Round off all rough welds and remove all weld spatter or slag. Sharp steel edges, including bolt holes, shall be rounded to a 2mm (min) radius.</p> <p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by cleaning to AS 1627 part 1. Round off all rough welds, sharp steel edges to a 2 mm radius and remove weld spatter or slag. All surfaces to be treated are to be cleaned down by hand or power tool cleaning methods to achieve a clean surface that is free of loose, flaking rust, mill scale etc. (As per AS1627.2 Class 2) Any foreign matter such as residual dusts from cleaning must be removed before painting commences. Avoid handling cleaned steel with bare hands. Apply initial coating within a four (4) hour period after preparation completed or before any surface deterioration occurs.</p> <p>Remove all spent abrasive, foreign matter and residual dust by using dry compressed air, sweeping with a clean brush or vacuum cleaning prior to application of the coating. The coating should initially be applied by brush to all welds, edges, bolt holes and cleats to ensure complete coverage is achieved.</p>

# COATING SPECIFICATION

Specification No: **PCN/0506/1059** **Version 1.** **Schedule H**

SURFACE PROFILE		N/A					
	FIRST COAT		SECOND COAT		THIRD COAT		
<b>MATERIAL</b>	DUREBILD STE		DUREBILD STE		None		
<b>PRODUCT CODE</b>	775-LINE		775-LINE				
<b>HARDENER CODE</b>	976-84539		976-84539				
<b>DATA SHEET</b>	PC237		PC237				
<b>THINNER</b>	EPOXY THINNER		EPOXY THINNER				
<b>THINNER CODE</b>	920-08925		920-08925				
<b>COLOUR</b>	ALUMINIUM		ALUMINIUM				
<b>APPLICATION</b>	B, R, CS or AS		B, R, CS or AS				
<b>% VOL. SOLIDS</b>	84.0%		84.0%				
<b>THEO. COVERAGE</b>	6.70 sqm/l (@ 125 microns)		6.70 sqm/l (@ 125 microns)				
<b>FILM THICKNESS</b>	<b>WFT**</b>	<b>DFT</b>	<b>WFT**</b>	<b>DFT</b>	<b>WFT**</b>	<b>DFT</b>	
<b>MINIMUM</b>	150 Microns	125 Microns	150 Microns	125 Microns			
<b>MAXIMUM</b>	240 Microns	200 Microns	240 Microns	200 Microns			
<b>RECOAT TIME</b>	MIN. 14 HOURS		MIN. 14 HOURS				
<b>@ 25 C &amp; 50% RH</b>	MAX. 4 WEEKS		MAX. 4 WEEKS				
<b>ABR.</b>	B = Brush, R = Roller, TR = Texture Roller CS = Conventional Spray, AS = Airless Spray, T = Trowel.						

\* Theoretical Coverage is the area which one litre of the material will cover at the specified Dry Film Thickness assuming it is applied to a perfectly smooth surface and absolutely no losses.

\*\* WFT is the thickness of wet paint required to be applied to the surface to achieve the specified Dry Film Thickness' assuming there is no thinner added.

### Specific Recommendations & Comments:

All work shall conform to AS 3894 parts 10, 11, 12, 13, 14. The minimum dry film thickness of this coating system shall be 200 microns comprising 2 coats of 100 microns each of Durebild STE Aluminium.

# COATING SPECIFICATION

Specification No: **PCN/0506/1059**

**Version 1.**

**Schedule H**

## Explanatory Notes:

1. DULUX is a Quality Endorsed Company - International Standards ISO9001, ISO9002 & Australian Standards AS3901, AS3902.
2. Refer to DULUX personnel listed below for additional information.
3. This is an abridged specification and must be read in conjunction with appropriate technical data sheet(s).
4. The use of a thinner other than that nominated herein may impair performance of the coating.
5. The coating should be protected from the elements and contamination during coating cure to achieve maximum life.
6. System life is dependent upon service conditions.
7. Pay particular attention to achieving adequate DFT at edges to ensure long service life.
8. The appropriate abrasives are to be selected to provide the specific surface profile. This is vital to ensure the appropriate coating adhesion.
9. Practical spreading rates will vary from quoted theoretical figures depending on substrate porosity, surface roughness over spray losses, application methods and environmental conditions (e.g. wind).
10. Application techniques should be adjusted to achieve the recommended Dry Film Thickness. Thus if application is by brush or roller additional coats may be required to achieve the specified Dry Film thickness.
11. Dry times apply to a single coat at 25 deg C and 50% Relative Humidity
12. Do not apply paint if Relative Humidity is above 85% or surface temperature is within 3 deg C of Dew Point or the surface temperature exceeds 45 deg C.
13. Galvanised surfaces present unique problems for applied coatings such as white rusting of the galvanising layer and subsequent coating delamination, particularly in locations up to several kilometres from the coast. Therefore, Dulux claims no responsibility for the performance of Dulux coatings applied to galvanised surfaces.
14. The specification(s) issued by Dulux Australia in this document have been selected as being suitable for the exposure environment(s) based upon the information given to Dulux by the customer or customer's authorised agent at the time of issue. Changes to the exposure environment and conditions or changes to liquid stored cargoes in contact with the coating(s) may also change the expected performance outcomes for the materials specified.

## DULUX Contacts:

**REQUESTED BY:** **Peter Vilcek 0411 024 118**

**PREPARED BY:** **Ian Clark 02 9794 9423**

**REVIEWED BY:**

**DATE:** **2-Jun-06**

## PREPARED FOR:

**NAME:** **Ken Hickey**

**PHONE No.:**

**COMPANY:** **Qenos P/L**

**FAX No.:**

A Division of ORICA Australia Pty Ltd A.B.N.99 004 117 828

## Disclaimer:

Any advise, recommendation, information, assistance or service provided by ORICA Australia (Dulux) in relation to goods manufactured by it or their use and application is given in good faith and is believed by ORICA to be appropriate and reliable. However, any advise, recommendation, information, assistance or service provided by ORICA is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the rights, entitlements and remedies conferred upon any person or the liabilities impaired upon ORICA by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance rendering void or prohibiting such exclusion, limitation, restriction or modification.

# DULUX PROTECTIVE COATINGS

## COATING SPECIFICATION

Specification No: **PCN/0506/1059**

**Version 1.**

**Schedule I**

<b>PROJECT:</b>	<b>CORROSION PROTECTION SYSTEMS</b> <b>QENOS P/L</b>
<b>SITE:</b>	<b>Botany NSW</b>
<b>SCOPE:</b>	The preparation and painting of existing coated steel or concrete that is permanently below the dewpoint. This is a temporary coating system to increase life until next shutdown.
<b>SUBSTRATE:</b>	Steel or Concrete
<b>SURFACE PREPARATION</b>	<p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by washing with an alkali based detergent and fresh potable water prior to any further surface preparation being carried out. Refer to AS1627.1 Part 1.4.4 - 1.4.6.</p> <p>Remove all surface contamination such as oil, grease, dirt, acid or alkali etc. by cleaning to AS 1627 part 1. Round off all rough welds, sharp steel edges to a 2 mm radius and remove weld spatter or slag. All surfaces to be treated are to be cleaned down by hand or power tool cleaning methods to achieve a clean surface that is free of loose, flaking rust, mill scale etc. (As per AS1627.2 Class 2) Any foreign matter such as residual dusts from cleaning must be removed before painting commences. Avoid handling cleaned steel with bare hands. Apply initial coating within a four (4) hour period after preparation completed or before any surface deterioration occurs.</p> <p>Remove all spent abrasive, foreign matter and residual dust by using dry compressed air, sweeping with a clean brush or vacuum cleaning prior to application of the coating. The coating should initially be applied by brush to all welds, edges, bolt holes and cleats to ensure complete coverage is achieved.</p> <p>Wash the surface with metholated spirits and clean rags and dry as rapidly as possible. Coat immediately as detailed.</p>

# COATING SPECIFICATION

Specification No: **PCN/0506/1059** **Version 1.**

**Schedule I**

SURFACE PROFILE N/A		FIRST COAT		SECOND COAT		THIRD COAT	
MATERIAL	Chemi-Cote PR 520		None		None		
PRODUCT CODE	707G003B						
HARDENER CODE	7076003A						
DATA SHEET	PR 520						
THINNER	Do Not Thin						
THINNER CODE							
COLOUR	CLEAR						
APPLICATION	B, R						
% VOL. SOLIDS	100.0%						
THEO. COVERAGE	10 sqmt/lt(@100 microns)						
FILM THICKNESS	WFT**	DFT	WFT**	DFT	WFT**	DFT	
MINIMUM	100 microns	100 microns					
MAXIMUM	150 microns	150 microns					
RECOAT TIME	N/A						
@ 25 C & 50% RH	N/A						
ABR.	B = Brush, R = Roller, TR = Texture Roller CS = Conventional Spray, AS = Airless Spray, T = Trowel.						

\* Theoretical Coverage is the area which one litre of the material will cover at the specified Dry Film Thickness assuming it is applied to a perfectly smooth surface and absolutely no losses.

\*\* WFT is the thickness of wet paint required to be applied to the surface to achieve the specified Dry Film Thickness' assuming there is no thinner added.

**Specific Recommendations & Comments:**

All work shall conform to AS 3894 parts 10, 11, 12, 13, 14. The minimum dry film thickness of this coating system shall be 100 microns comprising one coat of ChemiCote PR 520.

If the coatings are to be applied by brush or roller additional coats may be required to achieved total specified DFT.

Work should be carried out by a competent coating applicator experienced in using these types of industrial coatings.

# COATING SPECIFICATION

Specification No: **PCN/0506/1059**

Version **1.**

Schedule **I**

## Explanatory Notes:

1. DULUX is a Quality Endorsed Company - International Standards ISO9001, ISO9002 & Australian Standards AS3901, AS3902.
2. Refer to DULUX personnel listed below for additional information.
3. This is an abridged specification and must be read in conjunction with appropriate technical data sheet(s).
4. The use of a thinner other than that nominated herein may impair performance of the coating.
5. The coating should be protected from the elements and contamination during coating cure to achieve maximum life.
6. System life is dependent upon service conditions.
7. Pay particular attention to achieving adequate DFT at edges to ensure long service life.
8. The appropriate abrasives are to be selected to provide the specific surface profile. This is vital to ensure the appropriate coating adhesion.
9. Practical spreading rates will vary from quoted theoretical figures depending on substrate porosity, surface roughness over spray losses, application methods and environmental conditions (e.g. wind).
10. Application techniques should be adjusted to achieve the recommended Dry Film Thickness. Thus if application is by brush or roller additional coats may be required to achieve the specified Dry Film thickness.
11. Dry times apply to a single coat at 25 deg C and 50% Relative Humidity
12. Do not apply paint if Relative Humidity is above 85% or surface temperature is within 3 deg C of Dew Point or the surface temperature exceeds 45 deg C.
13. Galvanised surfaces present unique problems for applied coatings such as white rusting of the galvanising layer and subsequent coating delamination, particularly in locations up to several kilometres from the coast. Therefore, Dulux claims no responsibility for the performance of Dulux coatings applied to galvanised surfaces.
14. The specification(s) issued by Dulux Australia in this document have been selected as being suitable for the exposure environment(s) based upon the information given to Dulux by the customer or customer's authorised agent at the time of issue. Changes to the exposure environment and conditions or changes to liquid stored cargoes in contact with the coating(s) may also change the expected performance outcomes for the materials specified.

## DULUX Contacts:

**REQUESTED BY:** **Peter Vilcek 0411 024 118**

**PREPARED BY:** **Ian Clark 02 9794 9423**

**REVIEWED BY:**

**DATE:** **2-Jun-06**

## PREPARED FOR:

**NAME:** **Ken Hickey**

**PHONE No.:**

**COMPANY:** **Qenos P/L**

**FAX No.:**

A Division of ORICA Australia Pty Ltd A.B.N.99 004 117 828

## Disclaimer:

Any advise, recommendation, information, assistance or service provided by ORICA Australia (Dulux) in relation to goods manufactured by it or their use and application is given in good faith and is believed by ORICA to be appropriate and reliable. However, any advise, recommendation, information, assistance or service provided by ORICA is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the rights, entitlements and remedies conferred upon any person or the liabilities impaired upon ORICA by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance rendering void or prohibiting such exclusion, limitation, restriction or modification.