

Annex 4 : Exterior Coating Systems with Powder Coating

Coating System codification	REFERENCE base material +	Surface Preparation	Base material	Pretreatment	Organic layer					Corrosivity Class				
					primer		Intermediate	Topcoat	Total coating		C2	C3	C4	C5
					Type	µm			µm	µm				
EP-ST1-21	ST1		ST	Mechanical (SA 2 1/2)				60	1	60	✓	✗	✗	✗
EP-ST1-11	ST1		ST	Chemical (*)				60	1	60	✓	✗	✗	✗
EP-ST2-11	ST2		ST	Chemical (*)	Z/ZF	60		80	2	140	✓	✓	✓	✗
EP-ST2-21	ST2		ST	Mechanical (SA 2 1/2)	Z/ZF	60		80	2	140	✓	✓	✓	✗
EP-ST2-31	ST2		ST	Mechanical (SA 2 1/2) + Chemical (*)	Z/ZF	60		80	2	140	✓	✓	✓	✗
EP-ST3-11	ST3		ST	Chemical (*)	Z/ZF	60	60	80	3	200	✓	✓	✓	✗
EP-ST3-21	ST3		ST	Mechanical (SA 2 1/2)	Z/ZF	60	60	80	3	200	✓	✓	✓	✗
EP-SZ1-11	SZ1		Z 225	Chemical (*)				80	1	80	✓	✓	✗	✗
EP-SZ1-41	SZ1		Z 225	Mechanical (sweeping)				80	1	80	✓	✓	✗	✗
EP-SZ1-12	SZ1		Z 275	Chemical (*)				80	1	80	✓	✓	✗	✗
EP-SZ1-42	SZ1		Z 275	Mechanical (sweeping)				80	1	80	✓	✓	✗	✗
EP-SZ2-11	SZ2		Z 275	Chemical (*)	ZF	60		80	2	140	✓	✓	✓	✗
EP-SZ2-41	SZ2		Z 275	Mechanical (sweeping)	ZF	60		80	2	140	✓	✓	✓	✗
EP-HD1-11	HD1		HDG	Chemical (*)				80	1	80	✓	✓	✓	✗
EP-HD1-41	HD1		HDG	Mechanical (sweeping)				80	1	80	✓	✓	✓	✗
EP-HD1-51	HD1		HDG	Mechanical (sweeping) + Chemical (*)				80	1	80	✓	✓	✓	✗
EP-HD2-11	HD2		HDG	Chemical (*)	ZF	60		80	2	140	✓	✓	✓	✓
EP-HD2-41	HD2		HDG	Mechanical (sweeping)	ZF	60		80	2	140	✓	✓	✓	✓
EP-HD2-51	HD2		HDG	Mechanical (sweeping) + Chemical (*)	ZF	60		80	2	140	✓	✓	✓	✓
EP-HD3-11	HD3		HDG	Chemical (*)	ZF	60	60	80	3	200	✓	✓	✓	✓
EP-HD3-41	HD3		HDG	Mechanical (sweeping)	ZF	60	60	80	3	200	✓	✓	✓	✓
EP-MS1-71	MS1	Sa 3	MS 50 µm	none				80	1	80	✓	✓	✓	✗
EP-MS1-72	MS1	Sa 3	MS 100 µm	none				80	1	80	✓	✓	✓	✗
EP-MS2-71	MS2	Sa 3	MS 50 µm	none		60		80	2	140	✓	✓	✓	✓
EP-MS2-72	MS2	Sa 3	MS 100 µm	none		60		80	2	140	✓	✓	✓	✓
EP-STEC2-61	STEC2		EC	EC-pretreatment (#)				60	1	60	✓	✓	✓	✗
EP-STEC2-62	STEC2		EC	EC-pretreatment (#)				80	1	80	✓	✓	✓	✓
EP-STEC3-61	STEC3		EC	EC-pretreatment (#)			60	60	2	120	✓	✓	✓	✓
EP-HDEC2-61	HDEC2		EC	EC-pretreatment (#)				60	1	60	✓	✓	✓	✓

Codification:

ST	Steel
Z225	Continuous hot dip galvanized steel (coil) with 225 g/m ² zinc
Z275	Continuous hot dip galvanized steel (coil) with 275 g/m ² zinc
HDG	Hot Dip Galvanized Steel
MS	Metal Spray
EC	Electrophoretic primer (e-coat) 15 µm
Z	zinc flakes containing powder primer
ZF	zinc free powder primer
(*)	Conversion de surface EN 13438 (annex B). Following the procedure and supplier recommendations.
✓	Recommended
✓	This Coating System requires agreement between interested parties (ISO 2063)
✗	Not possible to
EC-pretreatment (#)	Only degreasing except for integrated electrophoretic lines.
@	Number of organic layers and total layer thickness EC EXCLUDED