

System 2

Areas with operating temperatures above 120°C/248°F and/or areas under insulation etc.

System 2A: Consists of 200 µm thermally sprayed aluminium or alloys of aluminium top coated with the following systems.

Pre-qualification is not required

Product	DFT (µm)
Hempadur 15570 (diluted) ¹	25
Total	25

Product	DFT (µm)
Hempadur Sealer 05990 ¹	25
Total	25

Product	DFT (µm)
Hempel's Silicone Aluminium 56914/3 ¹ (diluted)	25
Total	25

Product	DFT (µm)
Hempadur 85671 ²	150
Hempadur 85671	150
Total	300

Note 1: Sealer for thermally sprayed aluminium. Service temperature below 120°C/248°F.

Note 2: Alternative to thermally sprayed aluminium for insulated surfaces at service temperatures below 120°C/248°F.

System 2B: Consists of 100 µm thermally sprayed zinc or alloys of zinc top coated with the following systems.

Pre-qualification is required (for intermediate and topcoat as per System 1, see Note 2)

Product	DFT (µm)
Optional tie-coat	25 ¹
Hempaprime Multi 500 ³	125
Hempathane HS 55610	75
Total	225

Product	DFT (µm)
Optional tie-coat	25 ¹
Hempaprime Multi 500 ³	125
Hempel's Pro Acrylic 55883	75
Total	225

Product	DFT (µm)
Optional tie-coat	25 ¹
Hempadur 4774D	125
Hempathane HS 55610	75
Total	225

Note 1: An optional tie-coat (mist coat) may be specified to avoid popping. Typically, 25 µm Hempadur 15590 (diluted) or 25 µm of the specified epoxy (diluted, mist coat technique) can be used. Contact your Hempel representative for further details. This note applies to all of the above systems.

Note 2: Topcoats which have been pre-qualified in System 1 may also be used for System 2B. Commonly used topcoats, which may be substituted for those listed, include:

- Hempaxane Light 55030
- Hempathane 55210
- Hempathane Speed-Dry Topcoat 250

This note applies to all of the above systems.

Note 3: Both summer and winter versions of Hempaprime Multi 500 are pre-qualified

For advice on regional product availability and additional schemes, please contact your local Hempel representative or email protective@hempel.com

Hempel A/S

Lundtoftegaardsvej 91, 2800 Kgs. Lyngby, Denmark

Tel: +45 4593 3800 Email: norsok@hempel.com

norsok.hempel.com