

HEAVY-DUTY COATINGS

ISO 12944 : 2018 Coating selection guide



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ABOUT KCC

A Precision chemical corporation growing rapidly based on customer's confidence

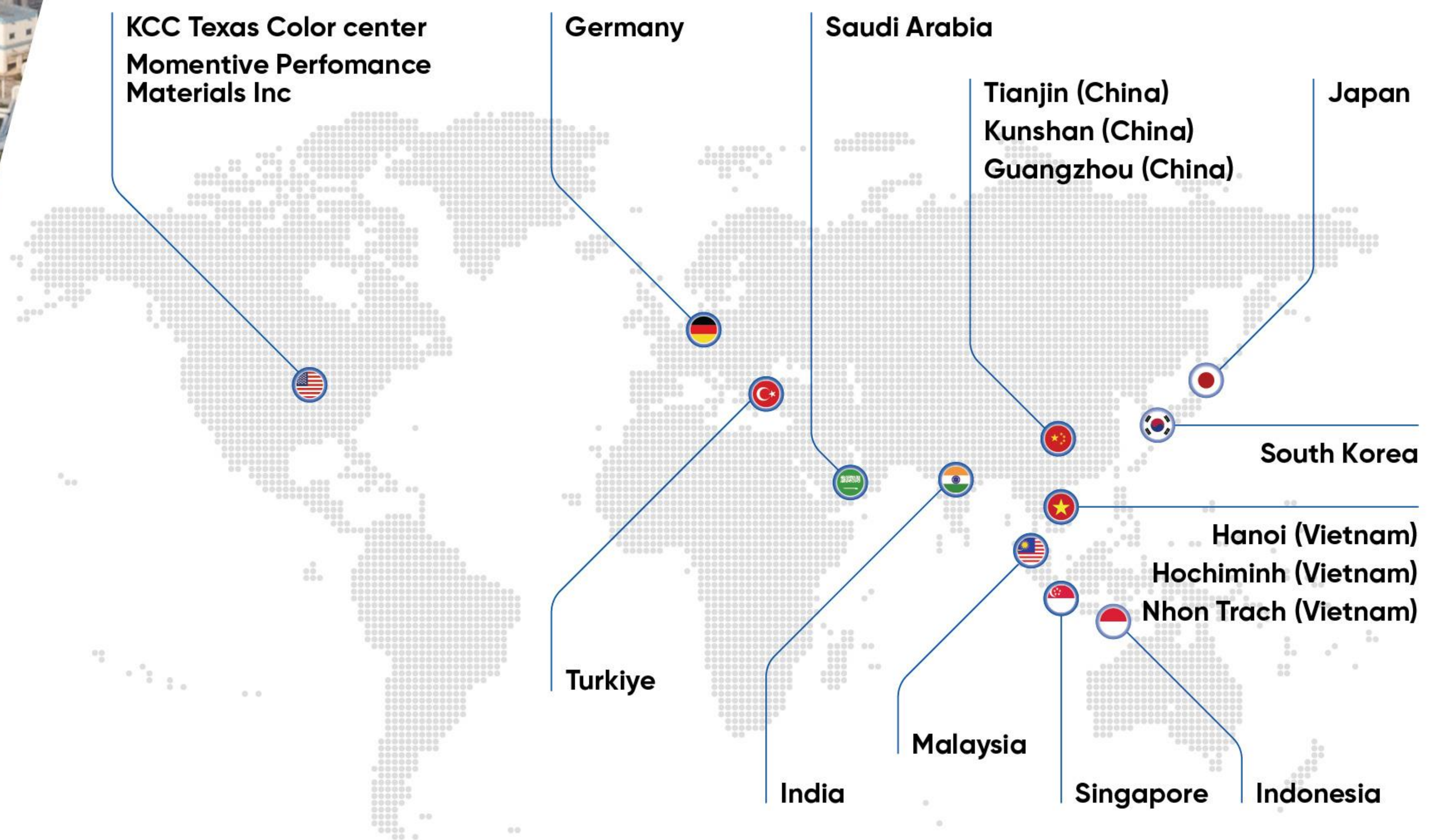
With state-of-the-art technology and ultra-modern production facilities, KCC seeks perfection in the quality of products and customer service.

Every product introduced to customers in the marketplace results from creative and intensive R&D activities satisfying diversified customer needs.

KCC always remains deeply committed to upgrading the living environment by leading the building and industrial materials industry through continued research and development, reflecting market trends and user wishes.



KCC Domestic and Global network



KCC TECHNOLOGY FOR TOMORROW

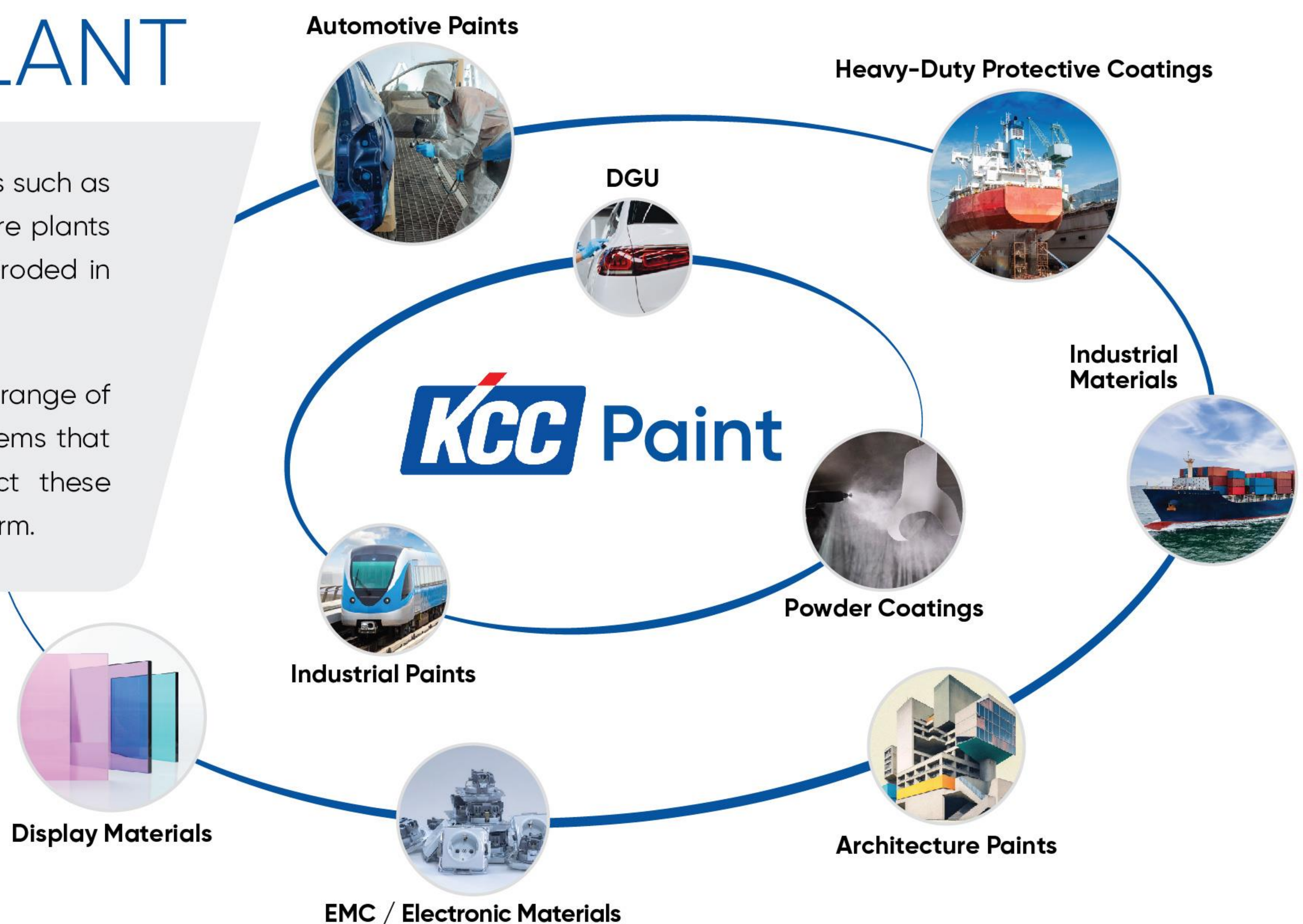
KCC Paints

- KCC is one of the world's leading manufacturers and suppliers of paints.
- KCC products protect all kinds of plants, ships, buildings and steel structures from the worst attacks that nature or man can inflict, including wind, rain, extreme heat and cold, pollution, chemicals and abrasion.
- KCC products also add beauty to the surfaces they protect, providing color, texture and even practicality.
- KCC is active in every aspect of coating technology
- KCC's goal is to provide customers with the best solution for their individual needs.
- Access to responsible and effective technical services around the world.
- KCC has built a reputation for quality, reliability and friendliness in over 40 countries.

KCC Heavy-Duty Coatings FOR PLANT

Ideal for use in facilities such as all onshore and offshore plants that can be easily corroded in severe environments.

KCC has developed a range of outstanding plant systems that can effectively protect these facilities for the long term.



KCC HEAVY DUTY COATINGS

- Protective Coatings for On/Offshore Plant Used Globally
- Global Market pioneer with New High - Functional & Eco-Friendly Product
- Designed to meet EN ISO 12944 & NORSOK M-501



Chemical Plant



Power Plant



Industrial Plant



Fireproof Paint



Steel Bridge



ISO 12944

Selection guideline for the right paint system To protect structural steel according to standard

Unprotected steel in the atmosphere, in water and in soil is subjected to corrosion that can lead to damage. Therefore, to avoid corrosion damage, steel structures are normally protected to withstand the corrosion stresses to which they will be subjected during the service life required of the structure.

ISO 12944-1 defines the overall scope of ISO 12944. It gives some basic terms and definitions and a general introduction to the other parts of ISO 12944. Furthermore, it includes a general statement on health, safety and environmental protection, and guidelines for using ISO 12944 (all parts) for a given project.

This document describes the environmental impact of steel structures. It covers structures exposed to the atmosphere as well as those immersed in water or buried in soil. For different atmospheric environments, a classification system based on corrosivity categories is also presented. Different corrosivity environments for immersed and buried structures are also described. All these environments are relevant to the choice of protective paint systems.

KCC has many years experienced on protecting properties from corrosion factors in different industrial environment. The right paint system will be built on the standard guidelines to meet project requirements and purposes.

*Selecting a right paint
system that complies with*
ISO 12944
obtain the steps:

1

Select
ENVIRONMENT

2

Select
DURABILITY

3

Select
COATING SYSTEM

1 Select

THE CORROSIVE ENVIRONMENT MOST CHALLENGING TO YOUR PROJECT

Corrosion category	Exterior	Interior
C1 Very Low		Heated buildings with clean atmosphere, e.g. offices, shops, schools, hotels
C2 Low	Atmosphere with low level of productions, mostly rural areas.	Unheated buildings where condensation can occur, e.g. depots, sports halls.
C3 Medium	Urban and industrial atmosphere, moderate sulfur dioxide pollution; coastal areas with low salinity.	Production rooms with high humidity and some air pollution, e.g. food-processing plants, laundries, breweries, dairies.
C4 High	Industrial areas and coastal areas with moderate salinity.	Chemical plants, swimming pools, coastal ship and boatyards.
C5 Very High	Industrial areas with high humidity and aggressive atmosphere and coastal areas with high salinity.	Buildings or areas with almost permanent condensation and with high pollution.
CX Extreme	Offshore areas with high salinity and industrial areas with extreme humidity and aggressive atmosphere and subtropical and tropical atmosphere.	Industrial areas with extreme humidity and aggressive atmosphere.

Categories for water and soil

Category	Environment	Examples of environments and structures
IM1	Fresh water	River installations, hydro-electric power plants.
IM2	Sea or brackish water	Immersed structures without cathodic protection (e.g. harbour areas with structures like sluice gates, locks or jetties)
IM3	Soil	Buried tanks, steel piles, steel pipes.
IM4	Sea or brackish water	Immersed structures with cathodic protection (e.g. offshore structures)





2 Select THE REQUIRED LIFETIME OF THE COATING SYSTEM



Durability

Years to first major maintenance

Low (L)

Up to 7 years

Medium (M)

7 years to 15 years

High (H)

15 years to 25 years

Very high (VH)

More than 25 years

Common durability considerations:



TABLE C.2

CARBON STEEL'S PAINT SYSTEMS FOR THE CORROSIVITY CATEGORY C2-ISO 12944

SYSTEM NO.	PRIMING COAT				INTERMEDIATE COAT			SUBSEQUENT COAT(s)			PAINT SYSTEM		DURABILITY			
	BINDER TYPE	TYPE OF PRIMER	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	NO. OF COAT	NDFT in μm	LOW	MEDIUM	HIGH	VERY HIGH
C2.01	QD Anticorrosion Primer	Misc.	1-2	40 to 100	-	-	-	LT313	1	40	2	80	X			
C2.02	QD Anticorrosion Primer	Misc.	1-2	40 to 100	-	-	-	LT313	2	60	1-2	100	X	X		
C2.03	QD Anticorrosion Primer	Misc.	2-4	60 to 160	-	-	-	LT313	2	60-100	4	160	X	X	X	
C2.04	QD Anticorrosion Primer	Misc.	2	60 to 80	-	-	-	LT313	2	60-100	4	200	X	X	X	X
C2.05	EP170 EP1760 EH2350	Misc.	1-2	60 to 120	-	-	-	UT6581 ET5740	1-2	60 to 120	1-3	120	X	X	X	
C2.06	EP170 EP1760 EH2350	Misc.	1-2	80 to 100	-	-	-	UT6581 ET5740	1-2	80 to 100	2-3	180	X	X	X	X
C2.07	EZ175 IZ180(N)	Zn (R)	1	60	-	-	-	-	-	-	1	60	X	X	X	
C2.08	EZ175 IZ180(N)	Zn (R)	1	60 to 80	-	-	-	UT6581 ET5740	1-2	80 to 100	2-3	160	X	X	X	X

Please contact to KCC local to receive the appropriate instruction.
Application guideline and product data sheet should be comprehended before applying.

TABLE C.3

CARBON STEEL' S PAINT SYSTEMS FOR THE CORROSIVITY CATEGORY C3-ISO 12944

SYSTEM NO.	PRIMING COAT				INTERMEDIATE COAT			SUBSEQUENT COAT(s)			PAINT SYSTEM		DURABILITY			
	BINDER TYPE	TYPE OF PRIMER	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	NO. OF COAT	NDFT in μm	LOW	MEDIUM	HIGH	VERY HIGH
C3.01	QD Anticorrosion Primer	Misc.	1-2	40 - to 100	-	-	-	LT313	2	60	1-2	100	X			
C3.02	QD Anticorrosion Primer	Misc.	2-4	60 to 160	-	-	-	LT313	2	60-100	4	160	X	X		
C3.03	QD Anticorrosion Primer	Misc.	2	60 to 80	-	-	-	LT313	2	60-100	4	200	X	X	X	
C3.04	QD Anticorrosion Primer	Misc.	2	60 to 80	-	-	-	LT313	2	60-100	4	260	X	X	X	X
C3.05	EP170 EP1760 EH2350	Misc.	1-2	80 to 120	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	120	X	X		
C3.06	EP170 EP1760 EH2350	Misc.	1-2	80 to 160	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	180	X	X	X	
C3.07	EP170 EP1760 EH2350	Misc.	1-2	80 to 160	EH2350 EH6280	1	80 to 160	UT6581 ET5740	1-2	80 to 160	2-3	240	X	X	X	X
C3.08	EZ175 IZ180(N)	Zn (R)	1	60	-	-	-	-	-	-	1	60	X	X		
C3.09	EZ175 IZ180(N)	Zn (R)	1	60 to 80	-	-	-	UT6581 ET5740	2	60 to 80	2-3	160	X	X	X	
C3.10	EZ175 IZ180(N)	Zn (R)	1	60 to 80	EH2350 EH6280	1	100	UT6581 ET5740	1	40	2-3	200	X	X	X	X

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TABLE C.4

CARBON STEEL' S PAINT SYSTEMS FOR THE CORROSIVITY CATEGORY C4-ISO 12944

SYSTEM NO.	PRIMING COAT				INTERMEDIATE COAT			SUBSEQUENT COAT(s)			PAINT SYSTEM		DURABILITY			
	BINDER TYPE	TYPE OF PRIMER	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	NO. OF COAT	NDFT in μm	LOW	MEDIUM	HIGH	VERY HIGH
C4.01	QD Anticorrosion Primer	Misc.	2-4	60 to 160	-	-	-	LT313	1	60-100	4	160	X			
C4.02	QD Anticorrosion Primer	Misc.	2	60 to 80	-	-	-	LT313	2	60-100	4	200	X	X		
C4.03	QD Anticorrosion Primer	Misc.	2	60 to 80	-	-	-	LT313	2	60-100	4	260	X	X	X	
C4.04	EP170 EP1760 EH2350	Misc.	1-2	80 to 120	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	120	X			
C4.05	EP170 EP1760 EH2350	Misc.	1-2	80 to 160	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	180	X	X		
C4.06	EP170 EP1760 EH2350	Misc.	1-2	80 to 160	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	240	X	X	X	
C4.07	EP170 EP1760 EH2350	Misc.	1	80 to 240	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	300	X	X	X	X
C4.08	EZ175 IZ180(N)	Zn (R)	1	60	-	-	-	-	-	-	1	60	X			
C4.09	EZ175 IZ180(N)	Zn (R)	1	60 to 80	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	160	X	X		
C4.10	EZ175 IZ180(N)	Zn (R)	1	60 to 80	EH2350 EH6280	1	80 to 160	UT6581 ET5740	1-2	40 to 120	2-3	200	X	X	X	
C4.11	EZ175 IZ180(N)	Zn (R)	1	60 to 80	EH2350 EH6280	1	80 to 160	UT6581 ET5740	1-2	40 to 120	3-4	260	X	X	X	X

Please contact to KCC local to receive the appropriate instruction.
Application guideline and product data sheet should be comprehended before applying.

TABLE C.5

CARBON STEEL' S PAINT SYSTEMS FOR THE CORROSIVITY CATEGORY C5-ISO 12944

SYSTEM NO.	PRIMING COAT				INTERMEDIATE COAT			SUBSEQUENT COAT(s)			PAINT SYSTEM		DURABILITY			
	BINDER TYPE	TYPE OF PRIMER	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	NO. OF COAT	NDFT in μm	LOW	MEDIUM	HIGH	VERY HIGH
C5.01	EP170 EP1760 EH2350	Misc.	1	80 to 160	-	-	-	UT6581 ET5740	1-2	40 to 120	2-8	180	X			
C5.02	EP170 EP1760 EH2350	Misc.	1	80 to 160	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	240	X	X		
C5.03	EP170 EP1760 EH2350	Misc.	1	80 to 240	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	300	X	X	X	
C5.04	EP1760 EH2350 EH4158	Misc.	1	80 to 200	-	-	-	UT6581 ET5740	1-2	40 to 120	3-4	360	X	X	X	X
C5.05	EP175 IZ180(N)	Zn (R)	1	60 to 80	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	160	X			
C5.06	EP175 IZ180(N)	Zn (R)	1	60 to 80	EH2350 EH6280	1	80 to 160	UT6581 ET5740	1-2	40 to 120	2-3	200	X	X		
C5.07	EZ175 IZ180(N)	Zn (R)	1	60 to 80	EH2350 EH6280	1	80 to 160	UT6581 ET5740	1-2	40 to 120	3-4	260	X	X	X	
C5.08	EZ175 IZ180(N)	Zn (R)	1	60 to 80	EH2350 EH6280	1	80 to 160	UT6581 ET5740	1-2	40 to 120	3-4	320	X	X	X	X

Please contact to KCC local to receive the appropriate instruction.
Application guideline and product data sheet should be comprehended before applying.

TABLE C.6

CARBON STEEL' S PAINT SYSTEMS FOR THE CORROSIVITY CATEGORY IM1, IM2 AND IM3

SYSTEM NO.	PRIMING COAT				INTERMEDIATE COAT			SUBSEQUENT COAT(s)			PAINT SYSTEM		DURABILITY			
	BINDER TYPE	TYPE OF PRIMER	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	NO. OF COAT	NDFT in μm	LOW	MEDIUM	HIGH	VERY HIGH
I.03	EH2350 EH4158	Misc.	1	80	-	-	-	EH2350 EH2351	2	150 to 300	2-4	380	X	X	X	
I.04	EH2350 EH4158	Misc.	1	80	-	-	-	EH2350 EH2351	2-4	115 to 230	2-4	540	X	X	X	X
I.05	-	-	-	-	-	-	-	EH2350 EH3200(GF)	1-3	200 to 400	1-3	400	X	X	X	
I.06	-	-	-	-	-	-	-	EH2350 EH3200(GF)	1-3	200 to 600	1-3	600	X	X	X	X

Please contact to KCC local to receive the appropriate instruction.
Application guideline and product data sheet should be comprehended before applying.

TABLE D.1

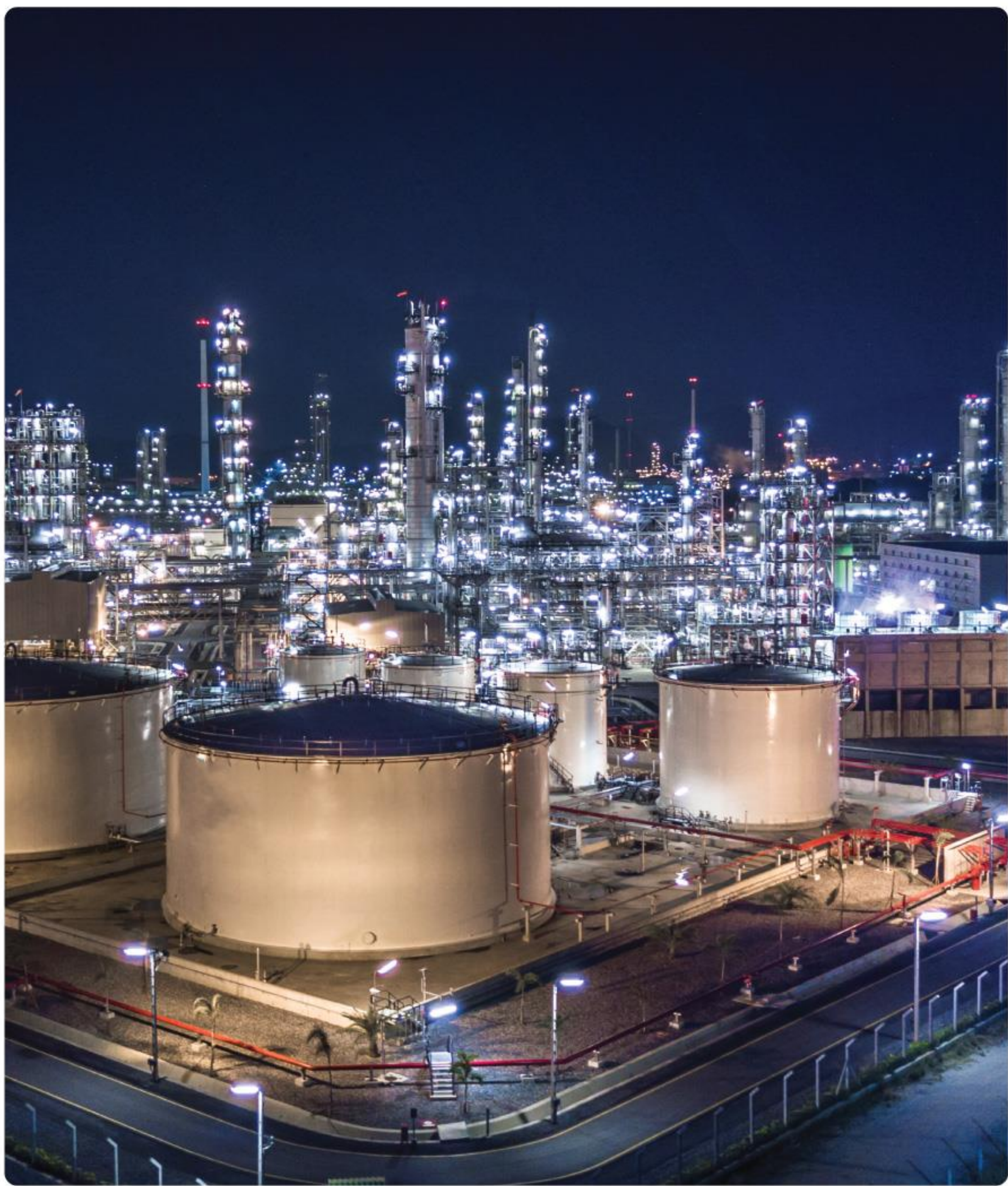
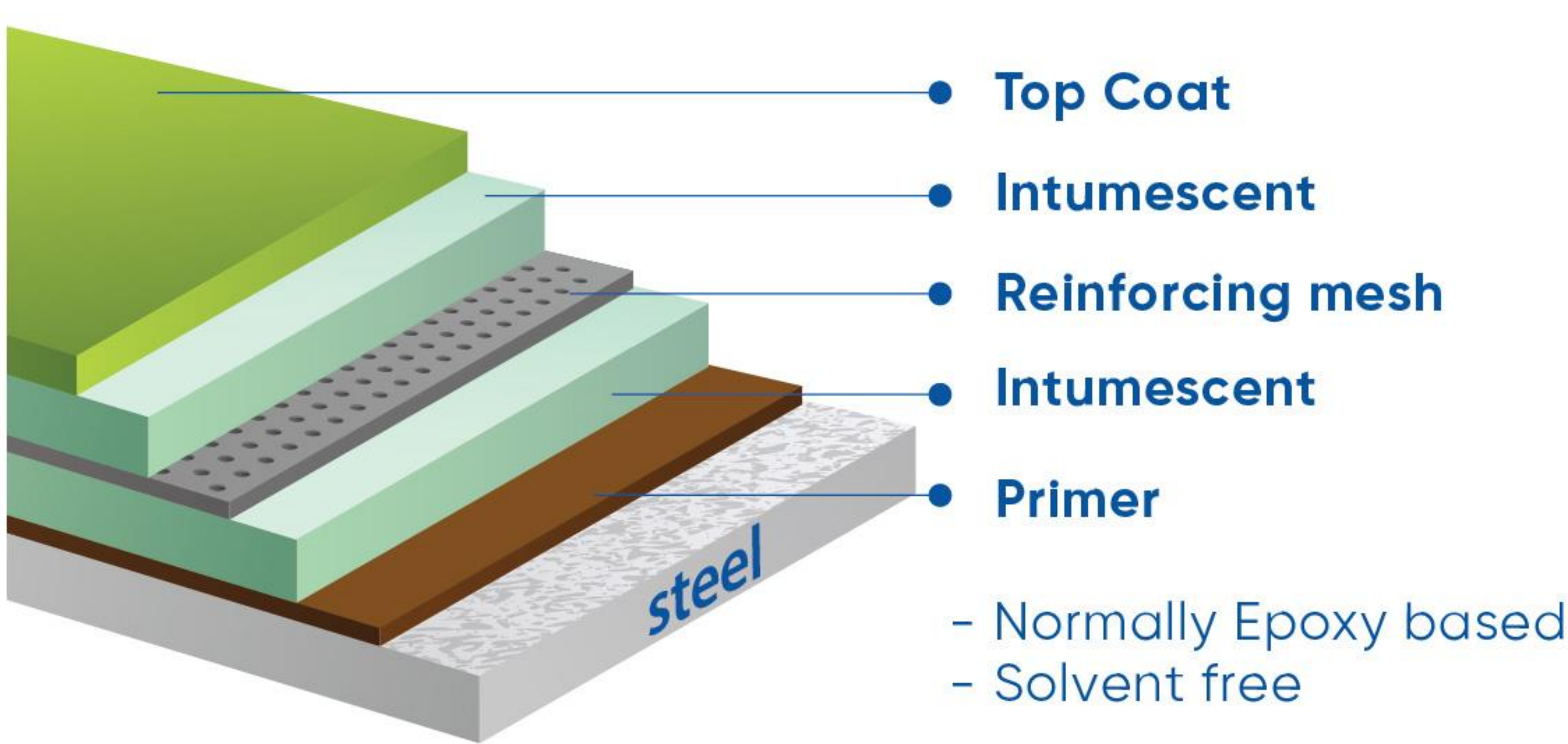
PAINT SYSTEMS ON HOT DIP GALVANIZED STEEL FOR CORROSIVITY CATEGORIES C2 TO C5

SYSTEM NO.	CORROSIVITY CATEGORY	PRIMING COAT			INTERMEDIATE COAT			SUBSEQUENT COAT(s)			PAINT SYSTEM		DURABILITY			
		TYPE OF PRIMER	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	BINDER TYPE	NO. OF COAT	NDFT in μm	NO. OF COAT	NDFT in μm	LOW	MEDIUM	HIGH	VERY HIGH
G2.01	C2	EP1760 ALLROUND MASTIC	1	80	-	-	-	-	-	-	1	80	X	X	X	
G2.03	C2	EP1760 ALLROUND MASTIC	1	80 to 120	-	-	-	UT6581 ET5740	1	40 to 80	1-2	120	X	X	X	X
G3.01	C3	EP1760 ALLROUND MASTIC	1	80	-	-	-	-	-	-	1	80	X	X		
G3.02	C3	EP1760 ALLROUND MASTIC	1	80 to 120	-	-	-	UT6581 ET5740	1	40 to 80	1-2	120	X	X	X	
G3.04	C3	EP1760 ALLROUND MASTIC	1	80	-	-	-	UT6581 ET5740	1	40 to 80	1-2	160	X	X	X	X
G4.01	C4	EP1760 ALLROUND MASTIC	1	80	-	-	-	-	-	-	1	80	X			
G4.02	C4	EP1760 ALLROUND MASTIC	1	80 to 120	-	-	-	UT6581 ET5740	1	40 to 80	1-2	120	X	X		
G4.04	C4	EP1760 ALLROUND MASTIC	1	80	-	-	-	UT6581 ET5740	1-2	40 to 80	1-2	160	X	X	X	
G4.06	C4	EP1760 ALLROUND MASTIC	1	80	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	200	X	X	X	X
G5.01	C5	EP1760 ALLROUND MASTIC	1	80 to 120	-	-	-	UT6581 ET5740	1	40 to 80	1-2	120	X			
G5.03	C5	EP1760 ALLROUND MASTIC	1	80	-	-	-	UT6581 ET5740	1-2	40 to 80	1-2	160	X	X		
G5.05	C5	EP1760 ALLROUND MASTIC	1	80	-	-	-	UT6581 ET5740	1-2	40 to 120	2-3	200	X	X	X	
G5.06	C5	EP1760 ALLROUND MASTIC	1	80	EH2350 EH2351	1	80 to 120	UT6581 ET5740	1-2	40 to 120	3-4	240	X	X	X	X

Please contact to KCC local to receive the appropriate instruction.
Application guideline and product data sheet should be comprehended before applying.

FIREMASK 3500

FPP Coating System for Hydrocarbon Fire



Painting Specification

NO. of coat	Product Name	D.F.T	Method of application	Color	Thinner
1st	EP170	50µm	B, R, S	Brown, Grey	024
2nd	FIREMASK 3500 Mesh: Nexweb	Varies by fire resistant time	S	Grey	No dilution
3rd	UT6581	50µm	B, S	ALL colors	0624

About painting menthods: B>Brush, R>Rollers, S>Spray



KCC's FIREMASK 3500: Certified by UL 1709

Full-scale Fire Endurance Test Program

Rating	DFT	Pass/Fail	Conditions of Acceptance	Reinforcement
1 hr	4.9mm	Passed	Avr. Temp.: below 538°C	Ceramic/ Glass fiber Mesh (NEXWEB)
1.5 hr	7.9mm			
2 hr	10.8mm		Max. Temp.: below 649°C	
2.5 hr	13.8mm			

Hydrocarbon Fires

- Rapidly heat to 1100 degrees Celsius in 5 minutes (UL 1709)

Product Features

- Epoxy-based fireproofing paint for rapidly heated oil fires for steel structure in oil, gas, chemical plants and power plants in onshore environments.

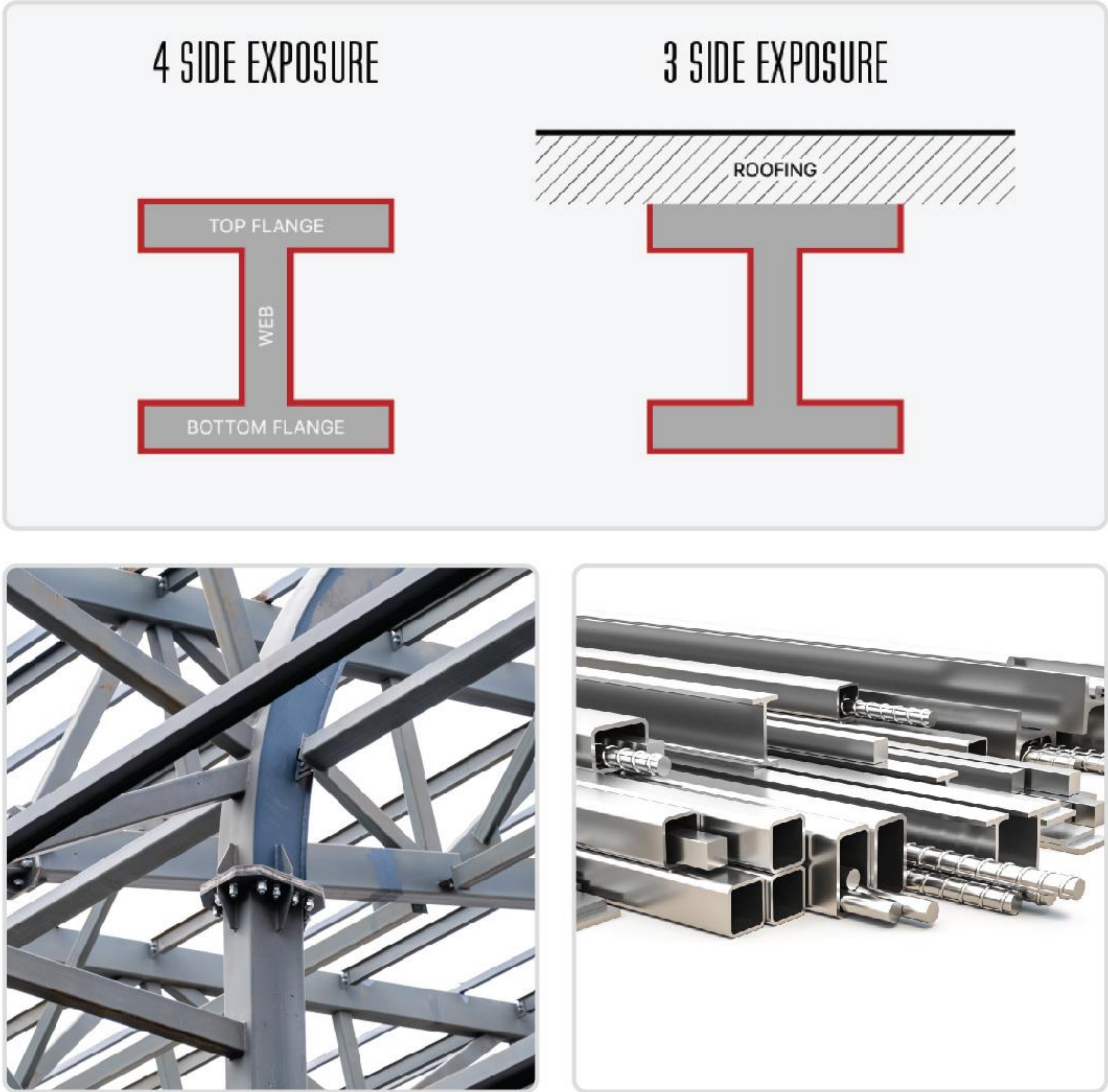


FIREMASK SQ476

FPP Coating System for Cellulose Fire

Factors influencing the specification

- Type of section (open / closed / cellular profile)
- Massivity of the steel (section factor, H_p/A)
- Exposure (i.e 3 sided, 4 sided exposure)
- Fire rating (30 / 60 / 90 / 120 min)
- Critical temperature (CT, °C)



Coating System

Item	Product Name	Coating thickness (DFT)	Recoating interval (25°C)
Surface	Sand blasting (SSPC-SP6 or Sa2½)	-	-
Primer	Korepox Primer EP170	50µm	-
Intumescent Coating	FIREMASK SQ-476	650µm *-per coat	Min. 24 hours
	• A typical wet film thickness 1,000µm per coat is highly recommended • Applying too thick (1,300µm ↑) per coat may cause crack, poor adhesion and delay of drying speed		
Top coat*	Korethan Topcoat UT6581	50µm	-

KCC's FIREMASK SQ476 : BS 476 Part 20,21 Full-scale Fire Endurance Test Program

One component solventborne intumescent coating
Tested and certified by CERTIFIRE(BS476)

Fire ratings (mins):
15 / 30 / 45 / 60 / 75 / 90 / 105 / 120 / 150
Excellent fire performance

Cellulosic Fire

Occur when burning combustibles such as wood, paper, textiles, etc. Civil construction



THERMALMASK

1502

High Functional Solvent-free Epoxy

Excellent corrosion protection and chemical resistance in immersion condition of high temperature and pressure

Recommended Use: Oil, separation plant, heat exchanges, interior of valves and pipes under high temperature and pressure



GOSP (Gas & Oil Separation Plant)

Required properties

Eco-friendly

- Solvent Free Epoxy

Good Workability

- Easy application by conventional airless spray

Excellent Property

- Long-term durability by high cross-linking
- Excellent properties at immersion of high temperature of 150°C and high pressure of 1,000psi

Characteristics Summarize

Items		Properties	Test conditions
Solvent content		None (Trace)	Solvent free
Typical thickness		600μm-1000μm	Standard 1 coat
Anti-sagging		60 mils	Draw down by applicator
Drying time	Set to touch	2 Hours	at 20°C / 68°F
	Dry through	8 Hours	
Pot life		1 Hour	at 20°C / 68°F
Curing method		Room Temperature	
Chemical resistance (Autoclave)		No blister & crack	150°C / 1,000psi for 7days
Immersion		No blister & rust	150°C for 6months
Cathodic disbondment		No disbondment (0mm)	1.55V / 90°C for 30days



CHEMMASK

1100



Overview

- Solvent-free Epoxy Paint with excellent chemical resistance

Usage

- Designed for Trench and Sump / Other Facilities where strong chemical resistance is required.

Features

- Long-term durability by high cross-linking
- Excellent resistance against chemicals;
- Strong acid and alkalis etc.
- Easy application by conventional airless spray
- Solvent-free Epoxy

Required properties

Eco-friendly

- Solvent Free Epoxy

Good Workability

- Easy application by conventional airless spray

Excellent Property

- Long-term durability by high cross-linking
- Excellent resistance against chemicals:
Acids, Alkalis, Solvents, Salts, Water

System

- Unipoxy Primer 50µm / EH3200(GF) 850µm / Unipoxy Chemical Resistance 300µm
- Unipoxy Primer 50µm / EH3200(GF) 850µm / EH2630(P) 300µm
- ChemMask 1100 600µm / ChemMask 1100 600µm (Sulfuric acid and Caustic soda)

Test period: 5 days (except for 98% Sulfuric acid, 3days)

Chemical Type	Unipoxy Chemical Resistance	EH2630(P)	ChemMask 1100
35% HCl	Applicable	Applicable	Applicable
45% NaOH			
12% Sodium hypochlorite			
15% Carbohydrazide			
8% Ammonia water	Defect	Defect	
98% Sulfuric acid			



KCC PRODUCTS

Shopprimer

- EP177
- IZ182
- IZ1990
- IZ1995
- VP184

Urethane Topcoat

- UT6581
- UT6581 (K1)
- UT6582

Inorganic Zinc Primer

- IZ180(N)
- IZ180(N)(H)
- IZ180(N)(HS)
- IZ180(N)(P)

Epoxy Topcoat

- ET574HS
- ET5745
- ET5740

Epoxy Zinc Primer

- EZ175
- EZ175(S)
- EZ175(HS)
- EZ175(WM)
- EZ176(HS)

Flurine Topcoat

- YJ558
- YJ5520
- YJ5521

Universal Primer

- ALLROUND MASTIC
- EP1730
- EP1760

Siloxane Topcoat

- ST1020

Epoxy Protective Paint

- EH3200(GF)
- EH4158HM / EH4158
- EH6280(HS)(MIO)
- EP170 / EP170(QD)
- EP1700
- ET5775
- EH2350 / EH2351
- EH3400
- EH2030

Nuclear Power Plant Certified Paint

- PE1290
- EP139
- ET5290
- EU2290
- IZ197

Passive Fire Protection

- FIREMASK AQ1000
- FIREMASK AQ2000
- FIREMASK 3500
- FIREMASK SQ476
- FIREMASK SQ476(V)

Epoxy Chemical Protective Paint

- EH2350
- EH2630(P)
- EH174(T)

Heat Resistant Paint

- QP160
- QT5065
- QT6000(L)
- QT604
- QT606
- QT6612

High Function Paint

- ChemMask 1100
- ThermalMask
- ThermalMask 1200
- ThermalMask 1502

Alkyd & Oil Paint

- MP120
- LT313
- QD ANTICORROSION



HEAVY-DUTY COATINGS

Chemical Plant / Power Plant / Industrial Plant



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