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# Standard – Coating and Colour Coding

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## 1 OVERVIEW

This document describes the Coating and Colour Coding Standard for use in Horizon Power.

### 1.1 Purpose

This Coating and Colour Coding Standard provides details of the business processes and activities associated with this Coating and Colour Coding Standard.

### 1.2 Target

This Coating and Colour Coding Standard is intended for all personnel working for or on behalf of Horizon Power.

### 1.3 Scope

This Standard describes the processes relating to Coating and Colour Coding at Horizon Power. It defines the quality and standard of materials and workmanship to be adopted in surface treatment of steelwork and equipment. It does not cover processes outside of Coating and Colour Coding.

It is not a standalone document but should be read in conjunction with the relevant Policies, Procedures, Standards and Work Instructions in the section below.

## 2 NORMATIVE REFERENCES

### 2.1 Standards

#### 2.1.1 Australian Standards

The following standards are available at <http://www.saiglobal.com>.

- [1]. *AS/NZS 1214, Hot-dip galvanised coatings on threaded fasteners*, Standards Australia, 2016
- [2]. *AS 1345, Identification of the contents of piping, conduits and ducts*, Standards Australia, 1995 (R2018)
- [3]. *AS 1397, Steel sheet and strip - Hot-dipped zinc-coated or aluminium/zinc coated*, Standards Australia, 2021
- [4]. *AS 1580, Methods of test for paints and related materials*, Standards Australia, 2006
- [5]. *AS 1627, Part 1, Cleaning using liquid solvents or alkaline solutions*, Standards Australia, 2003 (R2017)
- [6]. *AS 1627, Part 2, Power tool cleaning*, Standards Australia, 2002 (R2017)
- [7]. *AS 1627, Part 4, Abrasive blast cleaning*, Standards Australia, 2005 (R2017)
- [8]. *AS 1627, Part 5, Pickling steel surfaces*, Standards Australia, 2003 (R2017)
- [9]. *AS 1627, Part 6, Phosphate treatment of iron and steel surfaces*, Standards Australia, 2003 (R2017)

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- [10]. *AS 1627, Part 9, Pictorial surface preparation standards for painting steel surfaces*, Standards Australia, 2002 (R2017)
- [11]. *AS 1894, Method 4: Assessment of degree of cure*, Standards Australia, 1997 (R2021)
- [12]. *AS/NZS 2310, Glossary of paint and painting terms*, Standards Australia, 2002 (R2016)
- [13]. *AS/NZS 2311, Guide to the painting of buildings*, Standards Australia, 2017 (Amdt 1:2019)
- [14]. *AS/NZS 2312.1, Guide to the protection of structural steel against atmospheric corrosion by the use of protective coatings – Paint coatings*, Standards Australia, 2014
- [15]. *AS 2700, Colour standards for general purposes*, Standards Australia, 2011 (R2022)
- [16]. *AS/NZS 3750.6, Paints for steel structures – Full gloss polyurethane (two-pack)*, Standards Australia, 2009 (R2020)
- [17]. *AS/NZS 3750.15, Paints for steel structures - Inorganic zinc silicate paint*, Standards Australia, 1998 (R2013)
- [18]. *AS/NZS 3750.17, Paints for steel structures - Etch primers (single pack and two-pack)*, Standards Australia, 1998 (R2013)
- [19]. *AS 3894.0, Site testing of protective coatings – Introduction and list of test methods*, Standards Australia, 2002 (R2013)
- [20]. *AS 3894.10, Site testing of protective coatings – Inspection report – Daily surface and ambient conditions*, Standards Australia, 2002 (R2019)
- [21]. *AS 3894.11, Site testing of protective coatings – Equipment report*, Standards Australia, 2002 (R2019)
- [22]. *AS 3894.12, Site testing of protective coatings – Inspection report – Coating*, Standards Australia, 2002 (R2019)
- [23]. *AS 4100, Steel structures*, Standards Australia, 2020 (Amdt 1:2021)
- [24]. *AS 4352, Tests for coating resistance to cathodic disbonding*, Standards Australia, 2005
- [25]. *AS/NZS 4534, Zinc and zinc/aluminium-alloy coatings on steel wire*, Standards Australia, 2006 (R2017)
- [26]. *AS/NZS 4680, Hot dip galvanised (zinc) coatings on fabricated ferrous articles*, Standards Australia, 2006
- [27]. *AS/NZS 4792, Hot dip galvanised (zinc) coatings on ferrous hollow sections, applied by a continuous or a specialized process*, Standards Australia, 2006

### 2.1.2 International Standards

The following standards are available at <http://www.saiglobal.com>.

- [28]. *BSI 1133.8, Packaging code*, British Standards Institution, 2011
- [29]. *BSI 2451, Chilled iron shot and grit*, British Standards Institution, 1963

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- [30]. *BSI 2569.2, Sprayed metal coatings: Protection of iron and steel against corrosion and oxidation at elevated temperatures*, British Standards Institution, 1965

### 2.1.3 Other Standards

Australian Paint Approval Scheme GPC Coating and System Specifications:

- [31]. *GPC-C-29/2A, Air Drying Coating for Protection of Steel in the Atmosphere*
- [32]. *GPC-C-29/7, Type 1 Product Epoxy Primer*
- [33]. *GPC-C-29/7, Type 2 System - Epoxy Enamel or Low Build Epoxy System to 200 microns*
- [34]. *GPC-C-29/7, Type 3 System - Solvent Borne Epoxy System to 400 microns Maximum*
- [35]. *GPC-C-29/7, Type 4 Product – Solvent less Epoxy to 400 microns Maximum*
- [36]. *GPC-C-29/7, Type 5 Product - Ultra High Build Epoxy Coating Over 400 microns*
- [37]. *GPC-C-29/8A, Inorganic Zinc Coating for Steel Protection in the Atmosphere*
- [38]. *GPC-C-29/11A, Polyurethane Coating for Steel Protection in the Atmosphere*
- [39]. *GPC-C-29/16A, Organic Zinc Rich Coating for Steel Protection in the Atmosphere*
- [40]. *GPC-C-29/18A, Powder Coating for Steel Protection in the Atmosphere*
- [41]. *GPC-C-29/19A, Catalysed Acrylic Coating for Steel Protection in the Atmosphere*
- [42]. *GPC-C-29/A, Long Life Steelwork Protection System for Atmospheric Use*
- [43]. *GPC-C-29/F, Long Life Steelwork Protection System for Freshwater Immersion*
- [44]. *GPC-C-29/P, Long Life Steelwork Protection System for Potable Water*
- [45]. *GPC-C-29/S, Long Life Steelwork Protection System for Seawater Immersion*
- [46]. *GPC-C-29/T, Long Life Steelwork Protection System for Tank Lining*
- [47]. *GPC-D-122, Procedures for the Operation of the Approvals Scheme*
- [48]. *GPC E 15/3, Full Gloss Exterior External in MCR (Buildings)*
- [49]. *GPC-E-33/1, Enamel and Primer, Epoxy Type/Medium Solids, Medium Build enamel*
- [50]. *GPC-E-33/3, Enamel and Primer, Epoxy Type/Medium Solids, Medium Build Primer*
- [51]. *GPC-E-60, Full Gloss Spraying Enamel (Vehicles)*
- [52]. *GPC-E-66/3, Full Gloss Alkyd Stoving Enamel (Equipment)*
- [53]. *GPC-L-28, Gloss Exterior Latex Paint (Buildings)*

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- [54]. *GPC-P-13/4, Latex Primer for Galvanised Steel and Zincolume (Buildings)*
- [55]. *GPC-P-35/2, Etch Primer, Two Pack*
- [56]. *GPC P 35/4, Etch Primer, Two Pack (Chromate Free)*
- [57]. *GPC-P-65, Stoving Metal Primes (Equipment)*
- [58]. *GPC-P-155/1, Interior grade Powder Coating (ferrous substrate)*
- [59]. *GPC-P-155/2, Exterior grade Powder Coating (ferrous substrate)*
- [60]. *GPC-P-162, Zinc Phosphate Metal Primer*
- [61]. *GPC-U-9, Undercoat for Enamel*
- [62]. *GPC-U-59, Undercoat for Enamel*

### 2.2 Definitions and Abbreviations

For the purposes of this standard, definitions shall apply as in the relevant Australian Standards (*AS/NZS 2310 [12]*) with the addition of a few general definitions listed below in alphabetical order.

**BS:** British Standard

**GPC:** Australian Government Paint Committee

## 3 REQUIREMENTS

### 3.1 Coating

#### 3.1.1 Application to Assets

Horizon Power designers and operational staff shall apply appropriate protective coatings to extend the service life of all assets.

Assets above ground and exposed to the atmosphere shall be coated, these include:

- electrical panels
- enclosures
- items of plant
- pipe work
- platework
- steel surfaces
- structural steelwork, unless ultimately to be in contact with concrete

#### 3.1.2 Application Preparation

Coatings shall only be applied after fabrication and before erection unless otherwise specified by Horizon Power representative.

### 3.1.2.1 Cleaning

- a) Compressed air and abrasives for blast cleaning shall be clean and free of oil or contaminants. Air supplies shall be fitted with effective separators and traps. Horizon Power may request that the cleanliness of the compressed air be tested using clean, white blotting paper. The air shall be used only if no visible signs of contamination appear on the blotting paper.
- b) Surfaces at high-strength friction grip joints that will be in contact when erected shall be prepared as for the remainder of the steel and prime coated when an inorganic zinc silicate primer as specified. No other coatings shall be applied to friction grip contact surfaces.
- c) Equipment that cannot be cleaned, when assembled, without damage to itself or other material/equipment shall be abrasively blast cleaned and painted prior to assembly.
- d) Known site weld areas shall be given the specified surface preparation but left uncoated for a distance of 50 mm from the weld lines.
- e) Surfaces not being prepared for painting shall be protected from damage by masking and orifices shall be blocked to prevent entry of grit or liquids, which may damage internal components.
- f) Working parts of equipment shall be protected and open ends of pipe work and equipment suitably blanked to prevent damage and ingress of moisture and foreign matter.
- g) Where site painting is required it shall include, but is not necessarily limited to, cleaning and priming all un-primed areas at welded joints and bolted connections, including bolt heads and nuts, and applying finishing coats as specified. After erection, un-primed areas shall be cleaned thoroughly to the requirements of the original shop surface preparation. Care shall be taken to remove weld spatter and slag by suitable mechanical means. Solvent cleaning shall remove temporary protective material used as a pre-treatment to protect an un-primed surface.

### 3.1.2.2 Steel Surfaces

Prior to abrasive blast cleaning, all visible oil, grease, soil, organic and other contaminants shall be removed in accordance with AS 1627.1 [5].

Solvents or detergents used for cleaning shall not leave any residue on the steel surface.

Preparation of steel surfaces shall be by dry, abrasive blast cleaning to "near white" metal in accordance with AS 1627.4 [7] and shall be Class 2½ minimum.

Abrasive blast cleaning shall not be commenced unless the prime coat can be completed within a period of four hours after surface preparation and before any deterioration of the surface occurs. The prepared steel surfaces shall be kept dry and free from dust until the prime coat is applied. Should rust form or the surface become otherwise contaminated in the interval between cleaning and coating, re-cleaning shall be performed at the Contractor's expense.

Surfaces for powder coating application shall have surface profile between 50 mm and 85 mm measured in accordance with AS 1627.9 [10]. Following abrasive blast cleaning, a chemical pre-treatment may be applied in the form of either silicate/chromate conversion coating or a phosphate wash or both (AS 1627.6 [9]).



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Prior to powder application uniform to a temperature above 220°C, but in no case above 260°C for steel pipes shall be applied. The surface temperature shall be checked using temperature indicating crayons or other suitable means and recorded.

### 3.1.2.3 Galvanised Surfaces

Galvanised surfaces as per AS/NZS 1214 [1], AS 1397 [3], AS/NZS 4534 [25], AS/NZS 4680 [26], AS/NZS 4792 [27], to be painted shall be thoroughly cleaned and degreased in accordance with AS 1627.1 [5]. Alkaline cleaning shall not be used.

The surface shall then be whip blasted or treated with a phosphoric acid based solution, in accordance with the paint manufacturer's instructions.

Any "white rust" or damage to galvanised areas shall be repaired by the Contractor prior to the application of any finish painting materials.

### 3.1.3 Application of Coating

The application of all coating material shall be in strict accordance with the manufacturer's latest instructions, and be free from:

- runs and sags,
- voids, pinholes, bubbles,
- blistering, peeling, pitting,
- mud cracking, inadequate cure,
- rusting of substrate.

Precautions shall be taken to prevent paint from being applied to nameplates, couplings, shafts, valve stems, bearings, instrument glasses and machined surfaces.

For powder coating, the powder shall be applied to the surface by electrostatic spray resulting in a cured film.

All unpainted-machined metal surfaces shall be given two coats of a 'Personal Opaque' or approved equivalent to prevent corrosion prior to delivery to site.

Defects shall be corrected as detected during application of the coating. In any case, they shall be made good prior to applying the next coat.

Wet paint shall be protected against damage from dust, dirt and foreign matter, whilst masking or barriers shall be used to reduce overspray and splattering.

Surfaces that become contaminated between coats with dust, dirt or dry overspray shall be suitably and thoroughly cleaned and dried before continuing with the coating system.

All coatings shall be as per Table 3.

### 3.1.4 Application Checks

Surface preparation and coating application shall be inspected to ensure and demonstrate compliance to this standard. The thickness and pits on all coatings shall be checked and tested against manufactures' recommendations and appropriate Australian Standards AS 1580 [4], AS 3894.0 [19].

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Current calibration certificates for the paint test instruments to be used must be submitted to Horizon Power for approval.

### 3.1.5 Application Defects

Coatings that are damaged or defective shall be either repaired or reapplied.

The method of repair shall be approved by Horizon Power. The final coating of assembled painted items shall be visually uniform in colour. Any painting or touch up not uniform in colour or results in "patchwork" effect shall not be accepted.

Damage to galvanised coatings shall be repaired by the application of two coats of an approved zinc-rich coating.

### 3.1.6 Authorised Applicators

Paintwork shall be performed by qualified painters. It is preferred that the applicator be certified under the Painting Contractor Certification Programme.

### 3.1.7 Handling and Storage

Paint materials shall be handled, stored, and used in accordance with the manufacturers latest published instructions. All paint materials shall have the approval of the Australian Government Paint Committee (GPC).

Paint shall be delivered to the shop where painting is to take place in clearly branded and unbroken containers. Broken or unbranded containers shall be removed from the site and no paint from these containers shall be used.

## 3.2 Colour Coding

The colour of each item of equipment shall conform to Horizon Power's requirements.

The colour system proposed must be comply with the appropriate Australian Standard and as detailed in Horizon Power Standard detailed in Table 1 and 2 below. In where they do not meet this standard then a written request is to be submitted to Horizon Power for approval, prior to application of finish coats.

For identification of pipe work conduits and ducts, a system of colour coding shall be applied in accordance with AS 1345 [2]. Pipe markers shall be as specified in AS 1345 [2].

**Table 1: Standard Colour Schedule by Equipment**

Item	Remarks	Colour
Alternator	>750 rpm	Golden Yellow
Alternator	<750 rpm	Blue Grey
Bases – Equipment Mounting		Galvanised
Bases – Skid, Genset, Diesel		Black
Bases – Switchboard		Galvanised
Bolts, Cast-in Holding Down		Galvanised

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Item	Remarks	Colour
Bolts, Externally Used		Galvanised
Buildings – Offices		Service Dependent (See Table 2)
Buildings – Switch Rooms		Service Dependent (See Table 2)
Cable Supports and Trays		Galvanised
Cages, Safety		Galvanised
Casing, Air Filter		Aqua
Consoles – Control	Engine Fan and Pump	Parchment
Covers	Culvert	Galvanised
Covers	Trench	Galvanised
Doors		White
Ductwork – Air Intake, Externals		Service Dependent (See Table 2)
Ductwork – Charge Air, Externals		Service Dependent (See Table 2)
Electric Motors		Service Dependent (See Table 2)
Engines, Diesel	>750 rpm	Golden Yellow
Engines, Diesel	<750 rpm	Blue Grey
Engines, Service Module Structures		Galvanised
Fans – Bell Mouth		Service Dependent (See Table 2)
Fans – Casings, Transition Piece,		Service Dependent (See Table 2)
Fan – Casings, Transition Piece,	Discharge Duct	Jade
Fans – Guide Vanes		Galvanised
Fans – Motor		Service Dependent (See Table 2)
Fans – Motor, Support Brackets		Galvanised
Fans – Screens		Galvanised
Fasteners - Externally used		Galvanised
Flooring – Plates		Galvanised

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Item	Remarks	Colour
Flooring – Open Grid		Galvanised
Handrails		Galvanised
Ladders – Access		Galvanised
Pipework	Copper	Service Dependent (See Table 2)
Pipework	PVC	Service Dependent (See Table 2)
Pipework	Steel	Service Dependent (See Table 2)
Pipework – Exhaust	Unlagged	Aluminium
Pipework – Exhaust, Mounting Brackets		Galvanised
Pipework – Support Brackets, Clips, etc.		Galvanised Except where in contact with copper or aluminium then Service Dependent (See Table 2)
Platforms		Galvanised
Poles	1. Entire pole/column 2. Base (Anti-corrosion coating)	1. Galvanised 2. Grey or colour closest to galvanisation that supplier offers
Pumps		Service Dependent (See Table 2)
Radiator Headers – external		Jade
Radiator Headers - external	(Charge air only)	Aqua
Radiator Mounting Brackets, Clips, etc.		Galvanised
Radiator Support Structures		Galvanised
Radiator Transition Piece, Fan Casing,		Service Dependent (See Table 2)
Reconditioned Equipment and Pipework		As per original
Silencers		Aluminium
Stairs and treads		Galvanised
Stands - Silencer		Galvanised
Streetlight	1. Entire pole/column 2. Base	1. Galvanised 2. Thermoplast (See Table 6)
Structural Steelwork	External	Galvanised

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Item	Remarks	Colour
Switchboards	External Internal	Parchment White
Tanks – Fuel/Oil, Bulk Storage – Horizontal		White
Tanks – Fuel/Oil, Bulk Storage – Vertical		Aluminium
Tanks – Fuel/Oil, Daily Service – Externals		Deep Stone
Tanks – Lube Oil, Storage		Golden Tan
Tanks – Lube Oil, Sump		Golden Tan
Tanks – Water Make Up		Jade
Transformers		Aluminium
Trench covers		Galvanised
Valves		Service Dependent (See Table 2)
Woodwork		As specified
Workshops		Service Dependent (See Table 2)

**Table 2: Colour by Service**

Service	Colour	Standard
<b>Acids</b>	Lilac	AS 2700 Table 1-(P23)
<b>Alkaline</b>	Lilac	AS 2700 Table 1-(P23)
Ceiling	Surfmist	Colorbond
<b>Charge Air</b>	Aqua	AS 2700 Table 1- (B25)
<i>Compressed Air</i>	Bluebell	AS 2700 Table 1- (B41)
Door Frames	Cream	AS 2700 Table 1- (Y34)
Electrical Conduit	Grey	
<b>Electrical Conduit Buried</b>	Orange	AS 2700 Table 1- (X15)
Engines/Alternators >750 rpm	Golden Yellow	AS 2700 Table 1- (Y14)
Engines/Alternators <750 rpm	Blue Grey	AS 2700 Table 1- (N53)
External Walls	Classic Cream	Colorbond
<b>Fire Service</b>	Signal Red	AS 2700 Table 1- (R13)

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<b>Service</b>	<b>Colour</b>	<b>Standard</b>
Floors	Light Grey	AS 2700 Table 1- (N35)
<i>Fuel Oil</i>	Tan	AS 2700 Table 1- (X51)
Internal Walls	Shale Grey	Colorbond
<b>Lube Oil</b>	Golden Tan	AS 2700 Table 1- (X53)
<i>Natural Gas</i>	Biscuit	AS 2700 Table 1- (X42)
Outside Panels/Boards	Parchment	AS 2700 Table 1- (Y43)
<b>Potable Water (Copper pipe)</b>	Jade with Dark Blue band	AS 2700 Table 1- (G21) AS 2700 Table 1- (B53)
Tanks Horizontal	White	AS 2700 Table 1- (N14)
<b>Waste Products</b>	Black	AS 2700 Table 1- (N61)
<b>Water</b>	Jade	AS 2700 Table 1- (G21)
Window	Cream	AS 2700 Table 1- (Y34)

**Bold indicates** it is a base identifier for the proposed service to AS 1345 [2].

*Italics indicates* it is a supplementary colour to AS 1345 [2].

### 3.3 Coating Systems

The painting system used shall be as tabulated in Table 3.

**Table 3: Schedule of Paint Systems**

<b>Surface Type</b>	<b>Paint Type</b>		
	<b>First Coat</b>	<b>Second Coat</b>	<b>Third Coat</b>
Blast Cleaned Steel			
a) conventional painting	A1	B1	C1
b) powder coating	A5	-	-
Galvanised	B1	C1	-
Precoated Valves etc.	A2	C1	-
Major Repairs	A3	B1	C1
Touch Up/Minor Repairs	A4	-	-

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Table 4 details the paint types which may be used, whilst Table 5 lists specific products which may be used.

**Table 4: Paint Types**

Paint Type	AS 232 PRN	GPC Spec.	Description	DFT (Microns)
A1	1	GPC-C-29-8	Inorganic Zinc Silicate AS 3750.15 Type 4	65 to 100 Average 75
B1	13	GPC-C-29-7	High Build Epoxy (2 pack)	130 to 180 Average 150
C1	26	-	Acrylic modified Polyurethane gloss to AS/NZS 3750.6 or similar approved by Horizon Power	40 to 50 Average 45
A2	-	-	Compatible Barrier/Tie Coat	
A3	2	GPC-C-29-16	Zinc Rich Organic Priming Paint to AS/NZS 3750.6 Type 2	
A4	21	GPC-C-29-1	Water Based Acrylic	
A5	Corro-Coat PE Corro-Coat EP Corro-Coat MX Corro-Coat PE-F	GPC-C-29-18A	Polyester, Epoxy Polyester Epoxy, Fusion Bonded Epoxy	10÷100 Average 35

**Table 5: Approved Products List**

Paint Type	Jotun	Dulux	Taubmans	Vessey	Wattyl
A1	Dimetcote 15	Zincanode 304	Interzinc 2105	Carbozinc 11	Galvit ES 500
B1	Copon EA9	Epoxy Bildcote	Tank Lining HB Epoxy	Vepox CC24	Epinamel HB 404
C1	Unilite 450	Acrathane IF	Interfine 629	Polymet 900	Paracryl IFC
A3	Met-L-Pon 93	Zincanode 202	Durazinc 4	Vepox CC76	Galvit EP 100
A4	Uniflex 604	Weather-shield Gloss	Industrial Gloss Acrylic	Hydraperm	Sigma Acrylic
A5	Corro-Coat PE Corro-Coat EP Corro-Coat MX Corro-Coat PE-F	Alphatec 3000 Alphatec 4000	N/A	N/A	N/A

Table 6 lists the required lengths for the application of the anti-corrosion coating to be applied on poles from the base up.

**Table 6: Coating Length**

Distribution pole (m)	Coating applied from base up (m)
9.5	2.2
11.5	2.35
12	2.5
14	2.65
Streetlight pole (m)	Coating applied from base up (m)
6.5	2.7
10.5	3.3
12.5	3.5

**Notes applicable to Tables 1 to 6:**

1) Colour

The colour of the final coat to all equipment shall be as detailed in Table 1 and 2 of this standard.

2) Paint Type A2

Paint manufacturers should be approached regarding a suitable barrier coating on a case by case basis.

3) Isocyanate

Polyurethane or similar approved systems (C1) shall be free from isocyanate.

4) Paint System

Paint types from different manufacturers shall not be mixed. One product range should be used for a particular job.

5) Insulating Joints and Insulated Gaskets

Zinc-rich conducting paints shall not be used where bridging of insulating media can occur.



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**APPENDIX A REVISION INFORMATION**

(Informative) Horizon Power has endeavoured to provide standards of the highest quality and would appreciate notification of errors or queries.

Each Standard makes use of its own comment sheet which is maintained throughout the life of the standard, which lists all comments made by stakeholders regarding the standard.

A comment sheet found in **DM# 2034311** can be used to record any errors or queries found in or pertaining to this standard. This comment sheet will be referred to each time the standard is updated.

Date	Rev No.	Notes
18/02/2014	0	Initial Document Creation
28/07/2015	1	Correction of Layout and Errors
7/02/2023	2	Formatting correction and table updates