INDUSTRIAL COATINGS
Corrosion Protection for Steel Structures
Practical coating systems for all important applications
Coating systems are often the most important and frequently the only practical solution for the protection of steel against corrosion. Specialised product matching and decades of experience enable us to offer practical, robust and commercial corrosion protection coatings for a huge range of applications. Insufficient corrosion protection in steel structures can have serious consequences. Lack of protection frequently leads to structural problems quite apart from the visual appearance of the structure. Appropriate protective coatings and sensible maintenance intervals ensure long-term protection of steel structures and can avoid cost-intensive total refurbishment or even decommissioning. Our experts have gained a wide range of experience through many years of involvement in projects within Europe. These experts are ready to assist you – whether you are an architect, a planner, a fabricator or responsible for creating tendering documents – when you need an individual corrosion protection solution Sika can help. A tight network of sales partners guarantees expert promotion in all significant markets around the globe.
WITHOUT LONG-LASTING AND TRULY EFFECTIVE corrosion protection, many steel structures start to look quite old after only a few years. But it’s not just the appearance that deteriorates – the strength of the structure can also start to suffer.

In the worst-case the only choice left is that between abandoning the structure or totally renovating it.

This field has been regulated since 1998 by the European standard ISO 12944, “Corrosion protection of steel structures by protective paint systems”.

Whereas the standard is an 8-part work that goes in great detail into every aspect of corrosion protection (basic principles, environmental influences, assessing and preparing surfaces, schemes of initial protection and maintenance measures, laboratory testing of coating systems, as well as the execution and supervision of the work), we are deliberately restricting ourselves here to part 5 of the standard, “Coating systems”, which was revised in January 2008. Sika products cover the full spectrum of categories of corrosivity that are defined there.

We have adopted the tabular form of ISO 12944 and its important parameters (e.g. classification according to the duration of protection) for the purposes of our coating suggestions:

<table>
<thead>
<tr>
<th>Since January 2008</th>
<th>low (L)</th>
<th>2 - 5 years</th>
</tr>
</thead>
<tbody>
<tr>
<td>medium (M)</td>
<td>5 - 15 years</td>
<td></td>
</tr>
<tr>
<td>high (H)</td>
<td>&gt; 15 years</td>
<td></td>
</tr>
</tbody>
</table>

and we have divided them by topic according to their application fields:

**TABLE 1** Priming and intermediate coating in shop, top-coat on site

**TABLE 2** Full in shop coating application

**TABLE 3** Coating of hot-dip galvanized steel

**TABLE 4** Refurbishment of old coatings

**TABLE 5** Features of our shop primers, priming and intermediate coats

**TABLE 6** Features of our top coats

It is our hope that our practically-oriented information will also turn out to be a useful aid for you, and that it will help you to select the right corrosion protection system.

If you have any questions, we’d be glad to talk to you in person.
## Corrosivity categories for atmospheric environmental conditions and examples of typical environments

<table>
<thead>
<tr>
<th>CORROSIVITY CATEGORY</th>
<th>EXAMPLES OF TYPICAL ENVIRONMENTS IN A TEMPERATE CLIMATE</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Outside</td>
</tr>
<tr>
<td>C1 – insignificant</td>
<td>Heated buildings with neutral atmospheres, such as offices, shops, schools, hotels.</td>
</tr>
<tr>
<td>C2 – slight</td>
<td>Urban and industrial atmospheres, moderate pollution from sulphur dioxide. Coastal areas with low salinity. Production rooms where humidity is high and there is some atmospheric pollution, e.g. food manufacturing plants, laundries, breweries and dairies.</td>
</tr>
<tr>
<td>C3 – moderate</td>
<td>Unheated buildings where condensation can occur, e.g. warehouses, sports halls. Indoor areas with high humidity.</td>
</tr>
<tr>
<td>C4 – heavy</td>
<td>Industrial and coastal areas with moderate salinity. Chemical plants, swimming baths, boat sheds above sea water.</td>
</tr>
<tr>
<td>C5-I – very heavy (industrial)</td>
<td>Industrial areas with high humidity and aggressive atmosphere. Buildings or areas with almost constant condensation and with heavy contamination.</td>
</tr>
<tr>
<td>C5-M – very heavy (sea)</td>
<td>Coastal and offshore areas with high salinity. Buildings or areas with almost constant condensation and with heavy contamination.</td>
</tr>
</tbody>
</table>

### ISO 12944 - TRIED AND TESTED BASIC STANDARD

Coatings for protecting steel structures from corrosion are used in highly varied fields. Depending on the environmental conditions, they are exposed to quite specific corrosive stresses. These are defined in ISO 12944 part 2 as corrosivity categories from C1 to C5-M.

For this reason we have presented our suggestions in clear tables. The systems are designed to offer long-term protection (>15 years). Medium-term protection (3–5 years) is only considered in a few individual cases.

ISO 12944 provides the basis, and shapes the whole field of corrosion protection of steel structures through coatings. Many standards and sets of regulations refer to ISO 12944.
Coating systems for corrosion protection of steel structures subject to various atmospheric conditions, based on ISO 12944 part 5. Surface preparation: Sa 2 ½ (ISO 12944 part 4).

<table>
<thead>
<tr>
<th>SYSTEM NO.</th>
<th>PRIMING AND INTERMEDIATE COATING IN SHOP, TOP COAT ON SITE</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>FACTORY BUILDING SITE TOTAL SYSTEM CORROSIVITY CATEGORY</td>
</tr>
<tr>
<td></td>
<td>Priming coat Nominal coating thickness (µm)</td>
</tr>
<tr>
<td></td>
<td>Intermediate coat Nominal coating thickness (µm)</td>
</tr>
<tr>
<td></td>
<td>Top coat Nominal coating thickness (µm)</td>
</tr>
<tr>
<td></td>
<td>Number of coats Nominal coating thickness (µm)</td>
</tr>
<tr>
<td></td>
<td>C2</td>
</tr>
<tr>
<td>1</td>
<td>SikaCor® Steel Protect VHS Rapid</td>
</tr>
<tr>
<td>2</td>
<td>SikaCor® Steel Protect VHS Rapid</td>
</tr>
<tr>
<td>3</td>
<td>SikaCor® EP Color</td>
</tr>
<tr>
<td>4</td>
<td>SikaCor® PUR Color NEW</td>
</tr>
<tr>
<td>5</td>
<td>Sika Poxicolor® Primer HE NEW</td>
</tr>
<tr>
<td>6</td>
<td>SikaCor® EG Phosphat Rapid</td>
</tr>
<tr>
<td>7</td>
<td>Sika Poxicolor® Rapid</td>
</tr>
<tr>
<td>8</td>
<td>SikaCor® EG Phosphat Rapid</td>
</tr>
<tr>
<td>9</td>
<td>SikaCor® EG Phosphat or SikaCor® EG Phosphat Rapid</td>
</tr>
<tr>
<td>10</td>
<td>SikaCor® Zinc R or SikaCor® Zinc R Rapid</td>
</tr>
<tr>
<td>11</td>
<td>Sika Poxicolor® Primer HE NEW</td>
</tr>
<tr>
<td>12</td>
<td>SikaCor® Zinc R or SikaCor® Zinc R Rapid</td>
</tr>
</tbody>
</table>

1) SikaCor® EG-5® alternatively SikaCor® EG-4, Sika® Permacor®-2230 VHS, Sika® Permacer®-2230
TABLE 2
FULL IN SHOP COATING APPLICATION

Coating systems for corrosion protection of steel structures subject to various atmospheric conditions, based on ISO 12944 part 5. Surface preparation: Sa 2 ½ (ISO 12944 part 4).

<table>
<thead>
<tr>
<th>SYSTEM NO.</th>
<th>Priming coat</th>
<th>Nominal coating thickness (µm)</th>
<th>Intermediate coat</th>
<th>Nominal coating thickness (µm)</th>
<th>Top coat</th>
<th>Nominal coating thickness (µm)</th>
<th>Number of coats</th>
<th>Nominal coating thickness (µm)</th>
<th>Corrosivity Category</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>SikaCor® PUR Color NEW</td>
<td>80</td>
<td></td>
<td></td>
<td></td>
<td>1</td>
<td>80</td>
<td>C2 C3 C4 C5-M C5-I</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>SikaCor® Steel Protect VHS Rapid</td>
<td>120</td>
<td></td>
<td></td>
<td></td>
<td>1</td>
<td>120</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td>SikaCor® EP Color</td>
<td>80</td>
<td></td>
<td></td>
<td></td>
<td>1</td>
<td>80</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td>SikaCor® Zinc R or SikaCor® Zinc R Rapid</td>
<td>80</td>
<td></td>
<td></td>
<td></td>
<td>1</td>
<td>80</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td>SikaCor® EP Color</td>
<td>80</td>
<td></td>
<td></td>
<td></td>
<td>2</td>
<td>160</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>6</td>
<td>SikaCor® PUR Color NEW</td>
<td>160</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>160</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>7</td>
<td>SikaCor® ZP Primer</td>
<td>80</td>
<td></td>
<td></td>
<td></td>
<td>2</td>
<td>160</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>8</td>
<td>Sika Poxicolor® Primer HE NEW</td>
<td>80</td>
<td></td>
<td></td>
<td></td>
<td>2</td>
<td>160</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>9</td>
<td>SikaCor® EG Phosphat Rapid</td>
<td>120</td>
<td></td>
<td></td>
<td></td>
<td>2</td>
<td>180</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>10</td>
<td>Sika Poxicolor® Rapid</td>
<td>120</td>
<td></td>
<td></td>
<td></td>
<td>2</td>
<td>240</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>11</td>
<td>Sika® Permacor®-220 VHS</td>
<td>120</td>
<td></td>
<td></td>
<td></td>
<td>2</td>
<td>200</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>12</td>
<td>SikaCor® EG Phosphat Rapid</td>
<td>100</td>
<td></td>
<td></td>
<td></td>
<td>3</td>
<td>260</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>13</td>
<td>SikaCor® EG Phosphat or SikaCor® EG Phosphat Rapid</td>
<td>80</td>
<td></td>
<td></td>
<td></td>
<td>3</td>
<td>240</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>14</td>
<td>SikaCor® Zinc R or SikaCor® Zinc R Rapid</td>
<td>80</td>
<td></td>
<td></td>
<td></td>
<td>3</td>
<td>240</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>15</td>
<td>Sika® Permacor®-220 VHS</td>
<td>220</td>
<td></td>
<td></td>
<td></td>
<td>2</td>
<td>280</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>16</td>
<td>Sika Poxicolor® Rapid</td>
<td>120</td>
<td></td>
<td></td>
<td></td>
<td>3</td>
<td>320</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
<tr>
<td>17</td>
<td>SikaCor® Zinc R or SikaCor® Zinc R Rapid</td>
<td>80</td>
<td></td>
<td></td>
<td></td>
<td>3</td>
<td>280</td>
<td>low medium high low medium high</td>
<td></td>
</tr>
</tbody>
</table>

1) SikaCor® EG-5 alternatively SikaCor® EG-4, Sika® Permacor®-220 VHS, Sika® Permacor®-2300.
**TABLE 3**
COATING ON HOT-DIP GALVANIZED STEEL

Duplex systems for corrosion protection of steel structures subject to various atmospheric conditions, based on ISO 12944 Part 5. Surface conditions: Hot-dip galvanized according to ISO 1461 / ISO 14713 or metal sprayed according to DIN EN 22863.

<table>
<thead>
<tr>
<th>SYSTEMS</th>
<th>FACTORY</th>
<th>BUILDING SITE</th>
<th>TOTAL SYSTEM</th>
<th>CORROSIVITY CATEGORY</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Factory building site</td>
<td>Total system</td>
<td>Corrosivity category</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Priming coat</td>
<td>Intermediate coat</td>
<td>Top coat</td>
<td>Number of coats</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1</td>
<td>SikaCor® Aktivprimer Rapid®</td>
<td>80</td>
<td>Sika® CorroTop NEW</td>
<td>60</td>
</tr>
<tr>
<td>2</td>
<td>SikaCor® EG-1 VHS</td>
<td>100</td>
<td></td>
<td>120</td>
</tr>
<tr>
<td>3</td>
<td>SikaCor®-6630 High Solid</td>
<td>120</td>
<td>SikaCor®-6630 High Solid</td>
<td>120</td>
</tr>
<tr>
<td>4</td>
<td>SikaCor® EG-1 VHS</td>
<td>120</td>
<td></td>
<td>120</td>
</tr>
<tr>
<td>5</td>
<td>SikaCor®-6630 High Solid</td>
<td>200</td>
<td>SikaCor®-6630 High Solid</td>
<td>200</td>
</tr>
<tr>
<td>6</td>
<td>SikaCor® EG-1 or SikaCor® EG-1 Rapid</td>
<td>80</td>
<td>SikaCor® EG-5®</td>
<td>80</td>
</tr>
<tr>
<td>7</td>
<td>SikaCor® EG 120</td>
<td>120</td>
<td></td>
<td>120</td>
</tr>
<tr>
<td>8</td>
<td>Sika Poxicolor® Rapid</td>
<td>120</td>
<td>SikaCor® EG-120</td>
<td>120</td>
</tr>
<tr>
<td>9</td>
<td>SikaCor® EG-1 or SikaCor® EG-1 Rapid</td>
<td>80</td>
<td>SikaCor®-6630 High Solid</td>
<td>SikaCor®-6630 High Solid</td>
</tr>
<tr>
<td>10</td>
<td>SikaCor® EG-1 VHS</td>
<td>150</td>
<td></td>
<td>SikaCor® EG-5®</td>
</tr>
</tbody>
</table>

1) SikaCor® EG-5® alternatively, SikaCor® EG-4, Sika® Permacor®-2230 VHS, Sika® Permacor®-2330
2) For galvanized surfaces, sweep blasting is necessary

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* SikaCor® EG-5® alternatively, SikaCor® EG-4, Sika® Permacor®-2230 VHS, Sika® Permacor®-2330
* For galvanized surfaces, sweep blasting is necessary
### TABLE 4
**REFURBISHMENT OF OLD COATINGS**

Coating systems for corrosion protection of steel structures subject to various atmospheric conditions, based on ISO 12944 part 5.

<table>
<thead>
<tr>
<th>SYSTEM NO.</th>
<th>Partial surface preparation</th>
<th>Priming coat</th>
<th>Nominal coating thickness (µm)</th>
<th>Number of coats</th>
<th>Top coat</th>
<th>Nominal coating thickness (µm)</th>
<th>Number of coats</th>
<th>CORROSIVITY CATEGORY</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>P St 3</td>
<td>SikaCor® Aktivprimer Rapid</td>
<td>80</td>
<td>1</td>
<td>SikaCor®-6630 High Solid</td>
<td>160</td>
<td>2</td>
<td>C3</td>
</tr>
<tr>
<td>2</td>
<td>P St 3</td>
<td>SikaCor®-6630 High Solid</td>
<td>80</td>
<td>1</td>
<td>SikaCor®-6630 High Solid</td>
<td>160</td>
<td>2</td>
<td>C3</td>
</tr>
<tr>
<td>3</td>
<td>P St 3</td>
<td>Sika Poxicolor® Primer HE NEW</td>
<td>120</td>
<td>1</td>
<td>SikaCor® EG-120</td>
<td>120</td>
<td>1</td>
<td>C4</td>
</tr>
<tr>
<td>4</td>
<td>P Ma</td>
<td>Sika Poxicolor® Primer HE NEW</td>
<td>120</td>
<td>1</td>
<td>SikaCor® EG-1VHS</td>
<td>120</td>
<td>1</td>
<td>C4</td>
</tr>
<tr>
<td>5</td>
<td>P Ma</td>
<td>Sika® Poxicolor Primer HE NEW</td>
<td>80</td>
<td>1</td>
<td>SikaCor® EG-1 VHS</td>
<td>80</td>
<td>2</td>
<td>C4</td>
</tr>
<tr>
<td>6</td>
<td>P Sa 2½</td>
<td>SikaCor® EG Phosphat or SikaCor® EG Phosphat Rapid</td>
<td>80</td>
<td>1</td>
<td>SikaCor® EG System or SikaCor® EG System Rapid</td>
<td>160</td>
<td>2</td>
<td>C5-M/C5-I</td>
</tr>
</tbody>
</table>

**BOSCH**

**Parkhaus**
TABLE 5  FEATURES OF OUR SHOP PRIMERS, PRIMING AND INTERMEDIATE COATS

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

<table>
<thead>
<tr>
<th>Product</th>
<th>Description</th>
<th>VOC g / l</th>
<th>Density kg / l approx.</th>
<th>Volume solids % approx.</th>
<th>Dry film thickness μm</th>
<th>Min. application temperature at 10° C</th>
<th>Stackability</th>
<th>Recommended topcoats</th>
<th>Max. waiting time for overcoating</th>
</tr>
</thead>
<tbody>
<tr>
<td>SikaCor® Aktivprimer Rapid</td>
<td>1-pack alkyd resin primer</td>
<td>352</td>
<td>1.6</td>
<td>60</td>
<td>60 - 80</td>
<td>+5 °C</td>
<td>4 h</td>
<td>SikaCor® Steel Protect VHS Rapid SikaCor® -6630 High Solid</td>
<td>unlimited</td>
</tr>
<tr>
<td>SikaCor® Steel Protect VHS Rapid</td>
<td>1-pack alkyd resin primer</td>
<td>294.5</td>
<td>1.55</td>
<td>65</td>
<td>60 - 120</td>
<td>+5 °C</td>
<td>10 h</td>
<td>SikaCor® Steel Protect VHS Rapid SikaCor® -6630 High Solid</td>
<td>unlimited</td>
</tr>
<tr>
<td>Sika Poxicolor® Rapid</td>
<td>2-pack fast-curing epoxy resin primer</td>
<td>272</td>
<td>1.6</td>
<td>68</td>
<td>80 - 120</td>
<td>-10 °C</td>
<td>9 h</td>
<td>SikaCor® EG-1 / EG-1 VHS Sika® 2-K-PUR top coats</td>
<td>1 year</td>
</tr>
<tr>
<td>Sika Poxicolor® Primer HE NEW</td>
<td>2-pack epoxy resin primer, surface-tolerant</td>
<td>260</td>
<td>1.3</td>
<td>67</td>
<td>80 - 100</td>
<td>+5 °C</td>
<td>12 h</td>
<td>SikaCor® EG-1 / EG-1 VHS Sika® 2-K-PUR top coats</td>
<td>1 year</td>
</tr>
<tr>
<td>SikaCor® EG Phosphat</td>
<td>2-pack zinc phosphate epoxy resin primer</td>
<td>320</td>
<td>1.6</td>
<td>62</td>
<td>20 - 80</td>
<td>+5 °C</td>
<td>10 h</td>
<td>SikaCor® EG-120 SikaCor® EG-1 / EG-1 VHS Sika® 2-K-PUR top coats</td>
<td>1 year</td>
</tr>
<tr>
<td>SikaCor® EG Phosphat Rapid</td>
<td>2-pack fast-curing zinc phosphate epoxy resin primer</td>
<td>336</td>
<td>1.6</td>
<td>57</td>
<td>60 - 80</td>
<td>-10 °C</td>
<td>4 h</td>
<td>SikaCor® EG-120 SikaCor® EG-1 / EG-1 VHS Sika® 2-K-PUR top coats</td>
<td>1 year</td>
</tr>
<tr>
<td>SikaCor® ZP Primer</td>
<td>2-pack zinc rich primer based on epoxy resin</td>
<td>308</td>
<td>2.8</td>
<td>67</td>
<td>60 - 80</td>
<td>+5 °C</td>
<td>3 h</td>
<td>Sika® 2-K-PUR-top coats</td>
<td>4 years</td>
</tr>
<tr>
<td>SikaCor® Zinc R Rapid</td>
<td>2-pack fast-curing zinc rich primer based on epoxy resin</td>
<td>336</td>
<td>2.8</td>
<td>63</td>
<td>60 - 80</td>
<td>-10 °C</td>
<td>1 h</td>
<td>Sika® 2-K-PUR-top coats</td>
<td>1 year</td>
</tr>
<tr>
<td>Sika® Permacor®-2311 Rapid</td>
<td>2-pack zinc rich primer based on epoxy resin</td>
<td>375</td>
<td>2.5</td>
<td>59</td>
<td>60 - 80</td>
<td>-10 °C</td>
<td>4 h</td>
<td>Sika® Permacor®-2215 EG VHS Sika® Permacor®-2230 VHS</td>
<td>4 years</td>
</tr>
<tr>
<td>Sika® Permacor®-2305 Rapid</td>
<td>2-pack zinc phosphate epoxy resin primer</td>
<td>375</td>
<td>1.5</td>
<td>55</td>
<td>100 - 160</td>
<td>-10 °C</td>
<td>13 h</td>
<td>Sika® Permacor®-2215 EG VHS Sika® Permacor®-2230 VHS</td>
<td>1 year</td>
</tr>
<tr>
<td>Sika® Permacor®-2204 VHS</td>
<td>2-pack very high solid epoxy primer containing zinc dust and micaceous iron oxide</td>
<td>225.5</td>
<td>2.05</td>
<td>77</td>
<td>80 - 160</td>
<td>+10 °C</td>
<td>12 h</td>
<td>Sika® Permacor®-2215 EG VHS Sika® Permacor®-2230 VHS</td>
<td>3 months</td>
</tr>
<tr>
<td>Sika® Permacor®-2215 EG VHS</td>
<td>2-pack very high solid epoxy M.I.O. intermediate coat</td>
<td>247</td>
<td>1.9</td>
<td>72</td>
<td>80 - 160</td>
<td>+5 °C</td>
<td>16 h</td>
<td>Sika® Permacor®-2230 VHS Sika® Permacor®-2230 VHS Sika® Permacor®-2230 VHS</td>
<td>3 months</td>
</tr>
<tr>
<td>Sika® Permacor®-2706 EG</td>
<td>2-pack epoxy M.I.O. based intermediate coat. Base coat for galvanized steel.</td>
<td>476</td>
<td>1.4</td>
<td>45</td>
<td>40</td>
<td>+10 °C</td>
<td>24 h</td>
<td>Sika® Permacor®-2230 VHS Sika® Permacor®-2230 VHS Sika® Permacor®-2230 VHS</td>
<td>6 months</td>
</tr>
<tr>
<td>SikaCor® EG-1</td>
<td>2-pack epoxy M.I.O. based intermediate coat. Base coat for galvanized steel.</td>
<td>368</td>
<td>1.6</td>
<td>60</td>
<td>60 - 120</td>
<td>+5 °C</td>
<td>10 h</td>
<td>Sika® 2-K-PUR-top coats</td>
<td>4 years</td>
</tr>
<tr>
<td>SikaCor® EG-1 Rapid</td>
<td>2-pack fast-curing epoxy M.I.O. based intermediate coat. Base coat for galvanized steel.</td>
<td>368</td>
<td>1.6</td>
<td>56</td>
<td>60 - 120</td>
<td>-10 °C</td>
<td>5 h</td>
<td>Sika® 2-K-PUR-top coats</td>
<td>1 year</td>
</tr>
<tr>
<td>SikaCor® EG-1 VHS</td>
<td>2-pack very high solid epoxy M.I.O. intermediate coat</td>
<td>180</td>
<td>1.8</td>
<td>78</td>
<td>80 - 160</td>
<td>+5 °C</td>
<td>13 h</td>
<td>Sika® EG-4/5 Sika® Permacor®-2230 VHS</td>
<td>1 year</td>
</tr>
</tbody>
</table>
## TABLE 6
**FEATURES OF OUR TOP COAT PRODUCTS**

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

<table>
<thead>
<tr>
<th>Product</th>
<th>Description</th>
<th>VOC</th>
<th>Density</th>
<th>Volume solids</th>
<th>Dry film thickness</th>
<th>Mix. application temperature</th>
<th>Stackability at 10°C</th>
<th>Stackability at 20°C</th>
<th>Priming coat for repairs</th>
</tr>
</thead>
<tbody>
<tr>
<td>SikaCor®-6630 High Solid</td>
<td>1-pack very high solid epoxy M.I.O. intermediate coat</td>
<td>322</td>
<td>1.4</td>
<td>62</td>
<td>80</td>
<td>+5°C</td>
<td>16 h</td>
<td>18 h</td>
<td>SikaCor® Aktivprimer Rapid</td>
</tr>
<tr>
<td></td>
<td></td>
<td>345</td>
<td>1.5</td>
<td>61</td>
<td></td>
<td></td>
<td></td>
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</tr>
<tr>
<td>SikaCor® EP Color</td>
<td>2-pack epoxy resin top coat, satin finish</td>
<td>320</td>
<td>1.6</td>
<td>62</td>
<td>80</td>
<td>+5°C</td>
<td>7 h</td>
<td>4 h</td>
<td>Sika® Poxicolor® Primer HE NEW</td>
</tr>
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<td></td>
<td></td>
<td></td>
<td>SikaCor® EG Phosphat</td>
</tr>
<tr>
<td>SikaCor® PUR Color NEW</td>
<td>2-pack polyurethane top coat, satin finish</td>
<td>378</td>
<td>1.4</td>
<td>55</td>
<td>80-160</td>
<td>+5°C</td>
<td>6 h</td>
<td>4 h</td>
<td>Sika® Poxicolor® Primer HE NEW</td>
</tr>
<tr>
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<td>SikaCor® EG Phosphat</td>
</tr>
<tr>
<td>SikaCor® EG-4</td>
<td>2-pack polyurethane top coat with micaceous iron oxide</td>
<td>420</td>
<td>1.4</td>
<td>55</td>
<td>60-100</td>
<td>+5°C</td>
<td>16 h</td>
<td>12 h</td>
<td>Sika® Poxicolor® Primer HE NEW</td>
</tr>
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<td>SikaCor® EG Phosphat</td>
</tr>
<tr>
<td>SikaCor® EG-5</td>
<td>2-pack polyurethane top coat</td>
<td>420</td>
<td>1.3</td>
<td>61</td>
<td>60-100</td>
<td>+5°C</td>
<td>18 h</td>
<td>14 h</td>
<td>Sika® Poxicolor® Primer HE NEW</td>
</tr>
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<td>SikaCor® EG Phosphat</td>
</tr>
<tr>
<td>SikaCor® EG-120</td>
<td>2-pack low VOC polyurethane top coat</td>
<td>263</td>
<td>1.3</td>
<td>70</td>
<td>120</td>
<td>+5°C</td>
<td>20 h</td>
<td>11 h</td>
<td>Sika® Poxicolor® Primer HE NEW</td>
</tr>
<tr>
<td></td>
<td></td>
<td>272</td>
<td>1.6</td>
<td>70</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>SikaCor® EG Phosphat</td>
</tr>
<tr>
<td>Sika® Pemacor®-2230 VHS</td>
<td>2-pack very high solid polyurethane top with excellent UV resistance</td>
<td>252</td>
<td>1.4</td>
<td>70</td>
<td>60-100</td>
<td>+5°C</td>
<td>15 h</td>
<td>6 h</td>
<td>Sika® Pemacor®- 2204 VHS</td>
</tr>
<tr>
<td>Sika® Permacor®-2330</td>
<td>2-pack polyurethane top with excellent UV resistance</td>
<td>403</td>
<td>1.3</td>
<td>56</td>
<td>50-80</td>
<td>0°C</td>
<td>18 h</td>
<td>8 h</td>
<td>Sika® Poxicolor® Primer HE NEW</td>
</tr>
</tbody>
</table>

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1) Data based on micaceous iron oxide colours
2) Accelerated with SikaCor PUR Accelerator

Sika® Permacor® and Sika® Pyroplast® fire protection systems

1-pack waterborne, 1-pack solvent-based and 2-pack solvent-free intumescent coating systems for indoor and outdoor use.

See product data sheets
As a subsidiary of the globally operative Sika AG, Baar/Switzerland Sika Deutschland GmbH is one of the leading suppliers of building chemical product systems as well as sealants and adhesives for industrial manufacturing.

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