

CASE STUDY: NAVIGATION BUOYS**LOCATION:** SINGAPORE**MARKET:** MARINE

REQUIREMENT: The port authority has for many years experienced corrosion and severe pitting on many navigational light buoys and beacons used in the port and harbour areas. Customer required an upgrade on the current red lead primer/alkyd topcoat system, being used with only limited success

SURFACE PREPARATION: The buoys were degreased and the entire surface was blast cleaned to Sa2½ as per standard EN ISO 8501-1:2007 to achieve a surface profile of 50 to 75 microns. The preparation was completed with a fresh water wash to remove dust. The buoys were allowed to dry before coating.

COATINGS: The buoys were primed with Corroless EPF. Above the waterline two coats of Corroless RF65, in the required colour were applied to complete the application.

Below the water line:

Product (per coat)	DFT (per coat)	Colour
Corroless EPF	200 microns	Buff
Corroless EPF	200 microns	Black

Above the water line:

Product (per coat)	DFT (per coat)	Colour
Corroless EPF	200 microns	Buff
Corroless RF65	50 microns	Red
Corroless RF65	50 microns	Red

COMMENTS: After a successful trial, over a two year initial period the system was approved. Note for new build the preparation would be the same but care should be taken to remove any mill scale present.

