

System Selection for Transmission and Substation Structures

System Reference	Surface	Surface Preparation (Steel Structures Painting Council)	Coating System	Number of Coats	Minimum Dry Mil Thickness (required per coat)
GALVANIZED STEEL					
1	Weathered and/or Previously Painted	SSPC SP-2 Hand Tool Clean (or) SSPC SP-3 Power Tool Clean	Moderate Exposure (Limited Colors) KL4400 Series Anodic S/P Paint	1	6.0 - 10.0
			Structures with Heavy Rust KL6000 Tri-Polar Ferrite Primer KL4400 Series Anodic S/P Paint (or) 6-208 SPEEDHIDE® Red Oxide KL4400 Series Anodic S/P Paint	Spot Prime 1	2.0 - 3.0 6.0 - 10.0
			Moderate Exposure (Wide Color Selection) AMERCOAT® One single component Epoxy Primer PSX® One single component Polysiloxane Topcoat	1 1	2.0 - 3.0 1.5 - 2.5
			Severe Exposure (Wide Color Selection) AK2/400 AMERLOCK® AL Aluminum Primer Amercoat 450H Series	1 1	4.0 - 8.0 2.0 - 3.0
2	New and/or Unpainted (Unweathered)	SSPC SP-7 Brush-Off Blast (or) 97-687 Vinyl-Butyral Wash Primer @ 0.3-0.5	Moderate Exposure (Limited Colors) KL4400 Series Anodic S/P Paint	1	6.0 - 10.0
			Moderate Exposure (Wide Color Selection) Amercoat One single component Epoxy Primer PSX One single component Polysiloxane Topcoat	1 1	2.0 - 3.0 1.5 - 2.5
			Severe Exposure (Wide Color Selection) AK2/400 Amerlock White Primer AK2/400 Amerlock Primer (tinted) Amercoat 450H Series	1 1 1	3.0 - 5.0 3.0 - 5.0 2.0 - 3.0
CARBON STEEL					
3	Previously Painted	SSPC SP-2 Hand Tool Clean (or) SSPC SP-3 Power Tool Clean	Moderate Exposure (Limited Colors) KL6000 Tri-Polar Ferrite Primer KL4400 Series Anodic S/P Paint	Spot Prime* 1	2.0 - 3.0 6.0 - 10.0
			Moderate Exposure (Wide Color Selection) KL6040 Tri-Polar White Primer KL6000 Tri-Polar Ferrite Primer KLF Series Kolor-Sil Enamel (or) 6-212 Speedhide White 6-208 Speedhide Red Oxide 95-5000 Series SIL-SHIELD™	Spot Prime Spot Prime* 1	2.0 - 3.0 2.0 - 3.0 1.5 - 2.5
			Severe Exposure (Wide Color Selection) AK2/400 Amerlock White Primer AK2/400 Amerlock Primer (tinted) Amercoat 450H Series	1 1 1	3.0 - 5.0 3.0 - 5.0 2.0 - 3.0

*Full Prime may be required depending upon severity of corrosion.

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4	New and/or Unpainted	SSPC SP-10 Near White Metal Blast Clean	Moderate Exposure (Limited Colors) 94-260 MULTI-PRIME® White Primer 94-258 Multi-Prime Red Oxide KL4400 Series Anodic S/P Paint	1 1 1	1.5 - 2.0 1.5 - 2.0 6.0 - 10.0
			Moderate Exposure (Wide Color Selection) KL6040 Tri-Polar White Primer KL6000 Tri-Polar Ferrite Primer KLF Series Kolor-Sil Enamel (or) 6-212 Speedhide White 6-208 Speedhide Red Oxide 95-5000 Series Sil-Shield	Spot Prime Spot Prime 1 Spot Prime Spot Prime 1	2.0 - 3.0 2.0 - 3.0 1.5 - 2.5 2.0 - 3.0 2.0 - 3.0 1.5 - 2.5
			Severe Exposure (Wide Color Selection) AK2/400 Amerlock White Primer AK2/400 Amerlock Primer (tinted) Amercoat 450H Series	1 1 1	3.0 - 5.0 3.0 - 5.0 2.0 - 3.0
TOWER FOOTING PROTECTION					
5		SSPC SP-3 Power Tool Clean (Minimum)	Standard Conditions AK2/400 Amerlock AL Aluminum Primer	2	4.0 - 8.0
		SSPC SP-6 Commercial Blast Clean (Preferred where practical)	Cool/Damp Conditions KL4600 Kolor-Tar	2	5.0 - 7.0



Customer Service Phone Number: (800) 238-8596