



# Highland International, Inc.

Engineered Paint Systems

800-444-1438

[www.highland-international.com](http://www.highland-international.com)

## COATING SYSTEMS GUIDE for FOSSIL POWER PLANTS

Steel Surface	Surface Preparation	Coating System	# Coats	Min. Dry Mill Thickness per coat	
<b>Severe Exposure</b>					
<b>Non-Immersion; Exterior Previously Painted</b> Structural Steel, scrubber steel, precipitators, lagging, storage tanks, cranes, piping, grating	SSPC SP-2	<b>Primers</b>			
	Hand Tool Clean	#475C Series 2-K Epoxy Dry-Fall Primer	1	4.0 - 6.0	
	or				
	SSPC SP-3	<b>DTM's</b>			
	Power-Tool Clean	#485C Series 2-K Epoxy Dry-Fall Primer/Finish	2	4.0 - 6.0	
		#854 Urethane Modified Sil/Alk Brush & Roll DTM	2	3.0 - 4.0	
		<b>Topcoats</b>			
		#68 Series 2-K Aliphatic Urethane Dry-Fall Topcoat	1	3.0 - 4.0	
		#775 Series Silicone Alkyd Brush & Roll Topcoat	1	2.0 - 3.0	
	<b>Moderate Exposure</b>				
			<b>Primers</b>		
			#475C Series 2-K Epoxy Dry-Fall Primer	1	3.0 - 4.0
			#84 Series "Fast Dry" High Solids Rust Inhibitive Primer	1	3.0 - 4.0
		<b>DTM's</b>			
		#485C Series 2-K Epoxy Dry-Fall Primer/Finish	1	4.0 - 6.0	
		#854 Series Urethane Modified Sil/Alk Brush & Roll DTM	2	2.0 - 3.0	
		<b>Topcoats</b>			
		#68 Series 2-K Aliphatic Urethane Dry-Fall Topcoat	1	2.0 - 3.0	
		#775 Series Silicone Alkyd Brush & Roll Topcoat	1	2.0 - 3.0	
<b>Severe Exposure - Field/Shop</b>					
		<b>Primers</b>			
	SSPC SP-6	#475C Series 2-K Epoxy Dry-Fall Primer	1	4.0 - 6.0	
	Commercial Blast	#77 Series HiGrip High Solids 2-K Polyamide Epoxy Primer	1	4.0 - 6.0	
	or				
	SSPC SP-10	<b>DTM's</b>			
	Near White Metal	#485C Series 2-K Epoxy Dry-Fall Primer/Finish	2	4.0 - 6.0	
		#77 Series HiGrip High Solids 2-K Polyamide Epoxy DTM	1	6.0 - 8.0	
		#854 Series Urethane Modified Sil/Alk Brush & Roll DTM	2	3.0 - 4.0	
		<b>Topcoats</b>			
		#66 Series 2-K High Solids Polyurethane Brush & Roll Topcoat	1	3.0 - 4.0	
		#68 Series 2-K Aliphatic Urethane Dry-Fall Topcoat	1	3.0 - 4.0	
		#775 Series Silicone Alkyd Brush & Roll Topcoat	2	3.0 - 4.0	
<b>Moderate Exposure - Field/Shop</b>					
		<b>Primers</b>			
		#475C Series 2-K Epoxy Dry-Fall Primer	1	3.0 - 4.0	
		#77 Series HiGrip High Solids 2-K Polyamide Epoxy Primer	1	3.0 - 4.0	
		#84 Series "Fast Dry" High Solids Rust Inhibitive Primer	1	3.0 - 4.0	
		<b>DTM's</b>			
		#485C Series 2-K Epoxy Dry-Fall Primer/Finish	1	4.0 - 6.0	
		#77 Series HiGrip High Solids 2-K Polyamide Epoxy DTM	1	4.0 - 6.0	
		#854 Series Urethane Modified Sil/Alk Brush & Roll DTM	2	2.0 - 3.0	
		<b>Topcoats</b>			
		#66 Series 2-K High Solids Polyurethane Brush & Roll Topcoat	1	2.0 - 3.0	
		#68 Series 2-K Aliphatic Urethane Dry-Fall Topcoat	1	2.0 - 3.0	
		#775 Series Silicone Alkyd Brush & Roll Topcoat	1	2.0 3.0	



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<b>High Temperature</b>		<b>Applied to Hot Surface</b>			
Stacks, Soot blowers, piping, vents, combustion turbines, etc.	SSPC SP-6	<b>DTM's</b>			
	Commercial Blast or	<i>May be applied to 350°F hot surfaces</i>			
		#802HA Silicone Copoly 600°F Gray DTM (Ambient Cure)	1	3.0 - 4.0	
	SSPC SP-3	#812HA Silicone Copoly 600°F Black DTM (Ambient Cure)	1	3.0 - 4.0	
	Hand Tool Clean to SP-6 standard	#79HA HiTemp 2-K Polyamide Epoxy Aluminum DTM	1	4.0 - 5.0	
	SSPC SP-10	<i>May be applied to 400°F hot surfaces</i>			
	Near White Metal	#815HA Silicone Copoly 500°F DTM (Available in colors)	2	2.0 - 2.5	
	SSPC SP-10	<i>May be applied to 500°F hot surfaces</i>			
	Near White Metal	#805HA Silicone Copoly 1000°F Topcoat (Available in colors)	2 or 3	1.5 - 2.5	
		#808HA Silicone Copoly 1300°F Gray DTM	2 or 3	1.5 - 2.5	
		#810HA Silicone Copoly 1300°F Black DTM	2 or 3	1.5 - 2.5	
			<b>Applied to Ambient Surface</b>		
	SSPC SP-6	<b>Primers</b>			
	Commercial Blast or	#830 HiTemp 400°F Dry-Fall Light Yellow Primer	1	2.0 - 3.0	
		#860 HiTemp 400°F Light Yellow Primer	1	2.0 - 3.0	
	SSPC SP-3				
	Hand Tool Clean to SP-6 standard				
		<b>Dam's</b>			
SSPC SP-10	#802 Silicone Copoly 600°F Gray DTM (Ambient Cure)	1	3.0 - 4.0		
Near White Metal	#812 Silicone Copoly 600°F Black DTM (Ambient Cure)	1	3.0 - 4.0		
	#815 Silicone Copoly 500°F DTM (Available in colors)	2	2.0 - 2.5		
	#805 Silicone Copoly 1000°F Topcoat (Available on colors)	2	1.5 - 2.5		
	#808 Silicone Copoly 1300°F Gray DTM	2	1.5 - 2.5		
	#810 Silicone Copoly 1300°F Black DTM	2	1.5 - 2.5		
	#807 HiTemp 1300°F Aluminum DTM	2	1.5 - 2.0		
	#79 HiTemp 350°F 2-K Polyamide Epoxy Aluminum DTM	1	4.0 - 5.0		
		<b>Topcoats</b>			
	#840 HiTemp 375°F Dry-Fall Enamel Topcoat	1	2.0 - 3.0		
	#865 HiTemp 375°F Enamel Topcoat	1	2.0 - 3.0		
	<i>*802, 812, 805, 808, 810 and 807 are all available in the Dry-Fall formulas</i>				
	<i>*805, 808, 810, 815 all require heat cure at 250°F for 4 hours</i>				