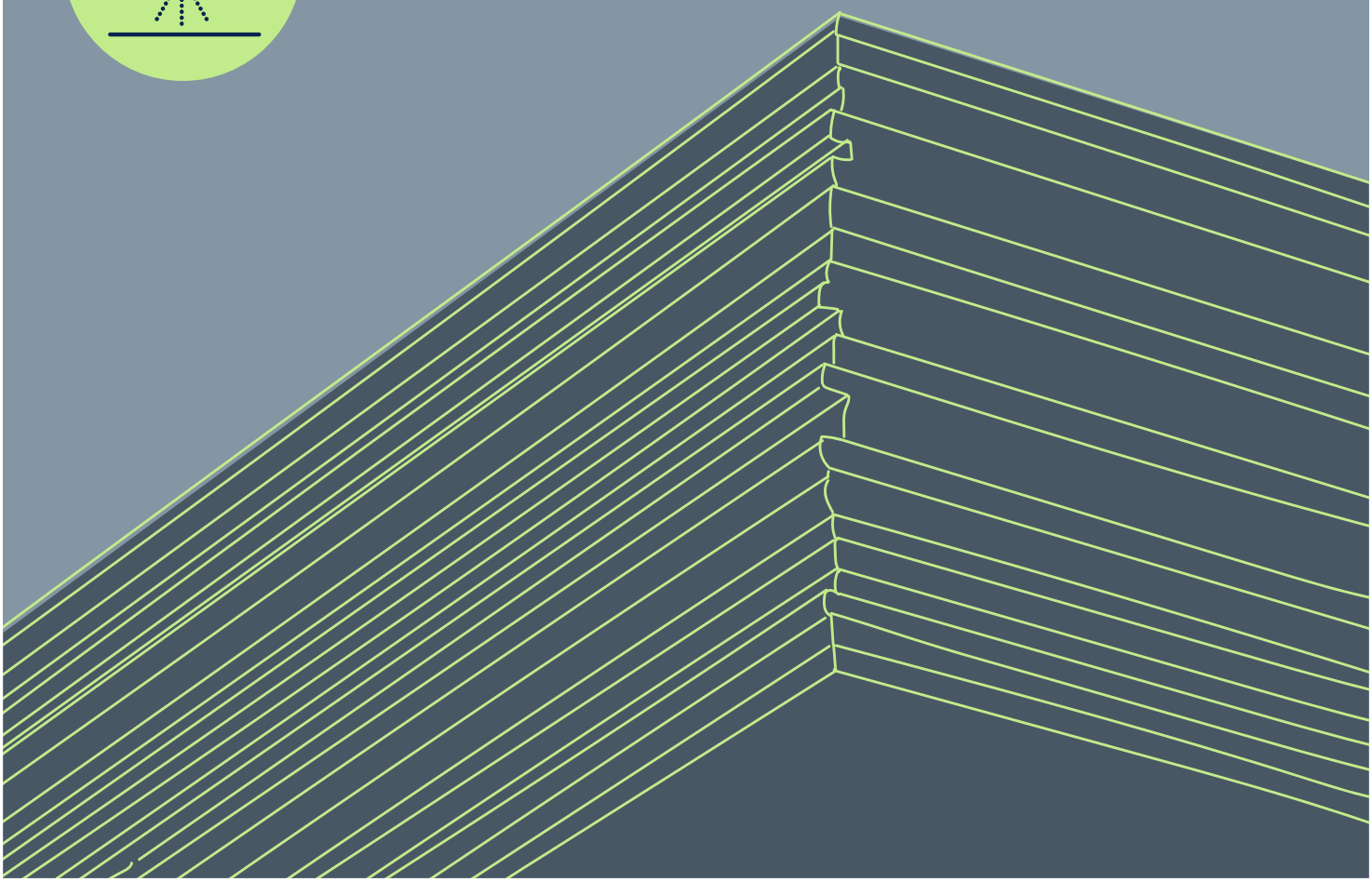
Temporary protection
Maximum impact

Shot blasted and primer coated heavy plates



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Shot blasting

Mechanically shot blast-descaling – SA 2 $^{1}/_{2}$ in accordance with ISO 8501 as standard – using steel shot can be offered for special surface cleanliness requirements. In only shot blasted state, heavy plate is extremly susceptible to rust and requires special care and quick processing.

Shopprimer

Prefabrication primer according to EN 10238: thin coating which is mechanically applied to blast cleaned steel and in order to provide temporary corrosion protection for steel components during their processing, transport and storage.

Overview of weight and dimensional parameters		
Mechanical blast-descaling (steel shot) with works coating (shopprimer)	max. thickness	200 mm
	max. width	4,500 mm
	max. length	28,000 mm
	max. per-meter weight	4.0 t/m
	max. item weight	38 t

Other dimensions and higher item weights are possible upon agreement.

Standard shopprimer used by Dillinger:

Primer type (if not otherwise agreed)	Colours	Dry film thickness recommended by the primer manufacturer [µm][1)]	Corrosion resistance	Weldability	Cuttability
zinc silicate	red grey reddish grey	15 to 20	high[2)]	high	high

If you would like a shopprimer to be applied, Dillinger uses zinc silicate shopprimers with a dry film thickness of 15 - 20 µm[1)] as standard for all plates, including our proprietary steels DILLIDUR and DILLIMAX. Zinc silicate shopprimers are characterised by a high level[2)] of corrosion resistance. They are excellent to process in terms of weldability and cuttability. Due to processing conditions, an adjustment of the process parameters may be necessary. Please note that other regulations can forbid an overwelding of the primer coat and therefore the shopprimer has to be removed before welding. When applying paint directly to the primer coat, the requirements of the paint on the primer must be considered.

Please also note that it is necessary to adhere to special environmental and health-safety provisions during cutting and welding of primer coated plates due to the fumes emitted. Please contact the primer manufacturer in case of doubt.

On request, other shopprimer types are available.

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[1)] To set the recommended dry film thickness, a layer thickness approx. 5 µm thicker is applied in the Dillinger coating facilities before the solvent evaporates and documented by measurements on a glass plate in accordance with EN 10238.
[2)] Temporary prefabrication corrosion protection with durability of 6 - 12 months (indication by the manufacturer: at moderate corrosiveness, class C3 according to ISO 12944)