

# System 2A

**Location**

Areas with operating temperatures above 120°C/248°F and/or areas under insulation etc.

**Description**

Consists of 200 µm thermally sprayed aluminium or alloys of aluminium top coated with the following systems.

**Pre-qualification is not required**

Product	DFT µm
Hempadur 15570 (diluted) < 120°C	25
Total	25
Hempadur Sealer 05990 < 120°C	25
Total	25
Hempel's Silicone Aluminium 56913/4	25
Total	25

As alternative to thermally sprayed aluminium for areas with service temperature < 120°C phenolic epoxy can be used.

Product	DFT µm
Hempadur 85671	150
Hempadur 85671	150
Total	300

# System 2B

## Location

Areas with operating temperatures above 120°C/248°F and/or areas under insulation etc.

## Description

Consists of 100 µm thermally sprayed zinc or alloys of zinc top coated with the following systems.

**Pre-qualification is required for intermediate and topcoat as per System 1.**

Product	DFT µm
Hempadur Mastic 45880	125
Hempathane HS 55610	75
Total	200
Hempadur Mastic 4588W	125
Hempathane HS 55610	75
Total	200
Hempadur Mastic 47140	125
Hempathane HS 55610	75
Total	200
Hempadur XO Quattro 17870	125
Hempathane HS 55610	75
Total	200
Hempadur XO Quattro 17770	125
Hempathane HS 55610	75
Total	200
Hempadur 47300	125
Hempathane HS 55610	75
Total	200
Hempadur Mastic 4774D	125
Hempathane HS 55610	75
Total	200

**Note**<sup>1</sup> = Other commonly used topcoats may be used as replacement for Hempathane HS 55610 including Hempathane DTM 55620, Hempathane Topcoat 55210, Hempel's Pro Acrylic 55883 and Hempaxane 55030. This note applies to all of the above systems.

**Note**<sup>2</sup> = As pre-qualification is not required additional systems may also be recommended. Contact your Hempel representative for further details. This note applies to all of the above systems.

**Note**<sup>3</sup> = An optional tie-coat may be specified to avoid popping. Typically, 25µm Hempadur 15590 (diluted) or 25µm of the specified epoxy (diluted, mist coat technique) can be used. Contact your Hempel representative for further details. This note applies to all of the above systems.