

Inspection and Test Plan Reviewed and Approved by Customer	IFC DWGs	Inspection and Test plan shall be submitted to the Engineer for review and approval before fabrication is commenced.	ITP-002-39028- Span 2 Rev C	Project Manager/ Engineer
Identify paint spec & colour	Specification for coating steelwork on highway structure IFC structure DWG	<b>Coating Specification:</b> Zinc metal thermal Spray TSZ150S and Sealer coat <b>Paint Specification</b> - Anti Graffiti paint system <b>Structure Colour</b> - Resene Armadillo 2GR10	Painting Project Commencement Meeting Minutes	Project Manager/ Engineer
Preparing Test panels	Specification for coating steelwork on highway structure NZTA S9	Testing panels (250 mm x 250 mm) showing Blasted surface profile and the metal spray (unsealed and sealed) to be provided along with material certificate, manufacturer's data sheet, brand of sealer, equipment type and set up parameter, name of operator who prepared panel. after satisfactory testing of the sample panel, none of the above items shall be changed.	Inspection report by Paint inspector	
Confirmation on protective coatings preparation by painting contractor	Project Structure Specification C07 Rev. 01 AS/NZS 5131 Clause 9.8.4	The surface needs to be in comply with P3 Treatment based on AS/NZS 5131 clause 9.8.4 Removal of all burrs, fins and weld defect, weld spatter, weld slags and dressing of any weld to removed sharp edges / spatter, undercut, visible porosity. All sharp edges are ground to a smooth 2 mm radius.	-	Project Manager/ Engineer
Surface Preparation	Specification for coating steelwork on highway structure NZTA S9 AS/NZS 5131	Any surface contamination shall be removed in accordance with NACE No. 2/ SSPC-SP 10 (AS 1627.1). Abrasive blast to SSPC-SP 10 (AS 1627.4 Sa 2 1/2) Surface profile shall be within 40 µm to 75µm  surface preparation shall not be Carried out in following condition: a) when surface temperature are less than 3C above dew point b) when the relative humidity of the air is above 85% c) in condition of poor visibility with light below 200 lx	ITP signed to verify blasting completed to Class 2½ finish  Contractor paint inspection report	
Zinc metal thermal spray (85/15 Zn/Al)	TSZ150S	The coating should be uniform in thickness without excessive drips, sags, porosity or inconsistencies. Thickness measurement need to be performed and thickness to be in range of 150 micron ±20%	Contractor paint inspection report	
Coat #1 - Sealer Coat -Penguard Universal	Specification for coating steelwork on highway structure NZTA S9	A mist coat of Penguard Universal (low viscosity epoxy sealer) to be applied within 2.5 hours after application of thermal metal spray  Penguard Universal applied to minimum 50 µm DFT  The coating shall be free from breaks in the coating, runs, sags, wrinkles, fat edge, dust or sand, irregular coated patches, dry spray, brush mark, blisters and pin holes	Contractor paint inspection report	
Coat #2 - Penguard Universal	Specification for coating steelwork on highway structure NZTA S9	Recoating interval needs to be considered based on paint data sheet and ambient temperature Penguard Universal applied to minimum 150 µm DFT.  The coating shall be free from breaks in the coating, runs, sags, wrinkles, fat edge, dust or sand, irregular coated patches, dry spray, brush mark, blisters and pin holes	Contractor paint inspection report	
Coat #3 - Hardtop Optima	Specification for coating steelwork on highway structure NZTA S9	Recoating interval needs to be considered based on paint data sheet and ambient temperature Hardtop Optima applied to minimum 75 µm DFT. Structure Colour - Resene Armadillo 2GR10  The coating shall be free from break in the coating, runs, sags, wrinkles, fat edge, dust or sand, irregular coated patches, dry spray, brush mark, blisters and pin holes	Coating application record by Coating contractor Coating inspection report by Inspector	
Adhesion test on plate sample which painted along with steel structure	Specification for coating steelwork on highway structure NZTA S9 ASTM D3359	Adhesion test shall be performed on plate sample determined by the X-cut tape test using method A of ASTM D3359 The acceptance criteria is 4A (Approve adhesive tape is 3M No. 810 scotch Magic Tape transparent pressure sensitive paint)	Coating application record by Coating contractor Coating inspection report by Inspector	
> Visual Inspection of steel structure > Approved for Transport to PFS	Specification for coating steelwork on highway structure NZTA S9	> Items covered by ITP visually inspected, any defects to be remediated before transporting from protective coating facility. > Coating reports reviewed.	Coating application record by Coating contractor Coating inspection report by Inspector	Project Manager/ Engineer