

Job No: 17529

Version: 2

Project Name: Tangiteroria Bridge

Date: _____

<i>Responsible Party</i>				<i>Activity</i>			
<i>Symbol</i>	<i>Description</i>	<i>Symbol</i>	<i>Description</i>	<i>Symbol</i>	<i>Description</i>	<i>Symbol</i>	<i>Description</i>
QM	Quality Manager	TPI	Third Party Inspector	R	Record	H	Hold Point
CI	Protective Coatings Inspector	PM	Project Manager	D	Documentation Review	W	Witness Point
CS	Protective Coatings Supervisor	PE	Project Engineer	P	Perform Activity	M	Monitor Point
PCS	Protective Coatings Staff	CL	Client Representative	T	Testing		

 Approved: _____
 Quality Manager

Item	Process Description in Sequence	Quality Control Activity	Acceptance Criteria		Verification	Inspection Activity					
			Acceptance Criteria	Reference Standard	Recording Document	Activity	Coatings Supervisor	Activity	Coatings QA/QC Inspector	Activity	Client/TIP
1.0	Corrosion protection prior to new steel going to site.										
1.1	Degrease and clean	Degrease using degreaser and two rag method	All surfaces free from oil, grease and other contaminants	Paint Manufacturers specification And AS 1627.1	Paint QA Sheet	P		W			
1.2	Atmospheric conditions checked for blasting	Relative humidity should not exceed 85% and difference between steel temperature and dew point to be 3 and above	Work protected from unfavourable weather conditions and no work commenced within dew point conditions	Paint Manufacturers specification And AS 1627.4	Paint QA Sheet	P		M / R			
1.3	Abrasive blast with non metallic media to Sa2.5 blast with a profile between 35 and 75 microns	Dry Abrasive blast using best practice to Sa2.5 cleanliness with a profile of 35 – 75 microns	Visual inspection to Sa2.5 standard. Profile measurement using Testex tape to between 35 and 75 microns	Paint Manufacturers specification And AS 1627.4 And AS 3894.5	Paint QA Sheet	P		H / R			

Item	Process Description in Sequence	Quality Control Activity	Acceptance Criteria		Verification	Inspection Activity					
			Acceptance Criteria	Reference Standard		Activity	Coatings Supervisor	Activity	Coatings QA/QC Inspector	Activity	Client/TIP
1.4	Check Abrasive Blast profile	Profile to be in range of 35 to 75 microns. Use Testex tape or profile gauge to measure profile. Record to Daily inspection sheet	Surface profile to measure between 35 and 75 microns	Paint Manufacturers Specification	Paint QA Sheet	P		D/M/R			
1.5	Atmospheric conditions checked prior to applying the first coat of coating system	Relative humidity should not exceed 85% and difference between steel temperature and dew point to be 3 and above.	Work protected from unfavourable weather conditions and no work commenced within dew point conditions	Paint Manufacturers Specifications and AS 3894.7 And AS 3894.10	Paint QA Sheet	P		D / M / R			
1.6	Application of Coat #1	Applied within 4 hours of last abrasive blast and before any discolouration of the prepared surface occurs	To reblast if there are changes to the prepared blasted surface			P		M			
1.7	Mix paint as per manufacturers recommendations	Coatings to be mixed by power mixer or paddle. Allow induction time as per manufacturers recommendations. Record batch numbers	Record of Batch numbers		Paint QA Sheet	P		M/R			
1.8	Stripe Coat all edges (except those being welded), welds, bolt holes, inaccessible areas, etc	Brush apply stripe coat to areas as required. Record paint quantity used	All edges, welds, etc are coating		Paint QA Sheet	P					
1.9	Apply full spray coat of the first coat to all surfaces	WFT measurement by wet film comb as per AS 3894.3 Appendix 3. Record paint quantity used	50% overlap with no misses or runs. WFT as specified and checked by painter regularly using a wet film comb	AS3894.3	Paint QA Sheet	P		M			

Item	Process Description in Sequence	Quality Control Activity	Acceptance Criteria		Verification	Inspection Activity					
			Acceptance Criteria	Reference Standard		Activity	Coatings Supervisor	Activity	Coatings QA/QC Inspector	Activity	Client/TIP
1.10	Cure time of first coat	As per Manufacturers specifications and product datasheet	Coating to be cured to recoat and hard	Coating to be cured hard for either recoat if required and for transportation		P		M			
1.11	Dry film thickness check of first coat	DFT as per manufacturers specification and as per AS 3894.3	Coating to be at correct film thickness as per manufacturers specification	AS 3894.3	Paint QA Sheet	P		T / R			
1.12	Repair defects as per repair specification – increase coating to low thickness areas	DFT acceptance criteria as per AS 3894.3	Coating conforms to the DFT requirements	AS 3894.3		P		H			
1.13	Repeat Tasks 1.7, 1.9 – 1.12 for atmospheric checks, mixing and application of the subsequent coat	Refer Tasks 1.7, 1.9 – 1.12	As per Tasks 1.7, 1.9 – 1.12	As per Tasks 1.7, 1.9 – 1.12	Paint QA Sheet	P					
1.14	Final inspection prior to handing over to transportation	DFT acceptance criteria as per AS 3894.3 Coatings conforms to the DFT requirements.	Coating conforms to the requirements	Paint manufacturers specification And AS 3894.3	Paint QA Sheet	P		H			
2.0	Complete final inspection documentation for presentation to the client			AS 3894.12	Final report						

Approved Coatings Specifications

Altex / Carboline specification TG-2025-185378 – Holding primer

[illegible]