

Painting Datasheet of Welded Tubes

Technical specification:

Color	
Type	Waterborne oven drying enamel - Melamine
Dangerous substances	No dangerous substances allowed as heavy metals (e.g., lead, chrome), carcinogens (e.g., formaldehyde)
Maximum VOC content	14 g/l which is equal less than 1% TOC by weight
Shot blasting	
Tube surface after shot blasting	Sa 2.5 - Sa 2.0
Spraying	
Sprayings system	Spraying with high pressure and added air (air-mix, air-combi)
Wet coating thickness	ca. 110/150 µm
Drying	
Flash-out	about 2 minutes
Drying	7-9 minutes at 60 °C (air temperature)
Burning	13/16 minutes at 165 °C (air temperature)
Coating quality	
Dry coating thickness	NDFT = 25 or 40 µm
Brilliance EN ISO 2813	gloss min70 GU for all RAL tones and for NCS 6030 - Y80R max 10 GU
Color difference EN 13523-22	outdoor exposure: no change after 280 days
Resistance to UV radiation EN 13523-21	outdoor exposure: minor gloss decrease: 10 units after 1000 hours
Pencil test EN ISO 15184	hardness 2H
Cross-cut test EN ISO 2409	adhesion: Class 0 (no damage - grit 5x5 fields per 1mm ²)
Impact resistance EN ISO 6272	10 mm
Conical bend test EN ISO 6860	R = 4 x D (no defects of coating guaranteed)
Tube bending test EN ISO 8491	R = 3x D / α = 90° (absence of cracks, no delamination of the film)
100% humidity test EN ISO 6270-1	exceeding 300 hours
Salt spray test EN ISO 9227	unchanged after 300 hours
Corrosion protection according EN ISO 12944:2018	Suitability for use at minimum for corrosivity category C2 and Durability Category M (Medium)
Bundles	
Resistance to sticking of tubes in bundle at stocking	No surface damage caused by sticking
Bundle shape	Hexagonal bundles
Stripping	6x steel strips, tight strapped

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Color shades offered as standard:

AM Red	NCS 6030 Y80R
Brown-Red	RAL 3011
Flame Red	RAL 3000
Signal Blue	RAL 5005
Moss Green	RAL 6005
Basalt Gray	RAL 7012
Zinc Yellow	RAL 1018
Jet Black	RAL 9005

Examples of color shades, packaging and condition of tube ends:



Marking of tubes body examples:

