

## PAINTS FOR CORROSION PROTECTION OF STRUCTURAL STEELWORK IN HIGHWAY APPLICATIONS

### HEMPADUR MASTIC (AL) 45880-19910 – TO HE NO 115

This HAPAS Certificate Product Sheet<sup>(1)</sup> is issued by the British Board of Agrément (BBA), supported by Highways England (HE) (acting on behalf of the Overseeing Organisations of the Department for Transport; Transport Scotland; the Welsh Government; and the Department for Infrastructure, Northern Ireland), the Association of Directors of Environment, Economy, Planning and Transport (ADEPT), the Local Government Technical Advisers Group and industry bodies. HAPAS Certificates are normally each subject to a review every three years.

(1) Hereinafter referred to as 'Certificate'.

This Certificate relates to Hempadur Mastic (AL) 45880-19910, for use as part of a specification for the corrosion protection of structural steelwork in highways applications, in accordance with the *Manual of Contract Documents for Highways Works* (MCHW), Volumes 1 and 2, where Item No 115 is specified.

#### CERTIFICATION INCLUDES:

- factors relating to compliance with HAPAS requirements
- factors relating to compliance with Regulations where applicable
- independently verified technical specification
- assessment criteria and technical investigations
- design considerations
- installation guidance
- regular surveillance of production
- formal three-yearly review.



#### KEY FACTORS ASSESSED

**Corrosion resistance** — a complete paint system incorporating the product will provide satisfactory resistance to corrosion of the substrate steel (see section 6).

**Durability** — a complete paint system, based on the product described in this Certificate, can be expected to perform satisfactorily for a period in excess of 15 years before its first major maintenance (see section 8).



The BBA has awarded this Certificate to the company named above for the product described herein. This product has been assessed by the BBA as being fit for its intended use provided it is installed, used and maintained as set out in this Certificate.

On behalf of the British Board of Agrément

Date of Second issue: 21 November 2019

Originally certificated on 8 February 2016



Brian Moore  
Director

The BBA is a UKAS accredited certification body – Number 113.

The schedule of the current scope of accreditation for product certification is available in pdf format via the UKAS link on the BBA website at [www.bbacerts.co.uk](http://www.bbacerts.co.uk)

Readers MUST check the validity and latest issue number of this Agrément Certificate by either referring to the BBA website or contacting the BBA directly.

Any photographs are for illustrative purposes only, do not constitute advice and should not be relied upon.

## Requirements

In the opinion of the BBA, Hempadur Mastic (AL) 45880-19910, having been registered by Highways England and found to comply with the requirements of CG303 (formerly BD35/14) and approved for ongoing registration, when used in accordance with the provisions of this Certificate will satisfy or contribute to satisfying the requirements of the:

- MCHW<sup>(1)</sup>, Volume 1 (Paints), Series 1900 and 5000
- MCHW<sup>(1)</sup>, Volume 2, Series NG 1900 and NG 5000
- *Design Manual for Roads and Bridges* (DMRB), CG303 *Quality assurance scheme for paints and similar protective coatings*
- DMRB, BD 87/05.

(1) The MCHW is operated by the Overseeing Organisations: Highways England (HE), Transport Scotland, the Welsh Government and the Department for Infrastructure (Northern Ireland).

## Regulations

### Construction (Design and Management) Regulations 2015

### Construction (Design and Management) Regulations (Northern Ireland) 2016

Information in this Certificate may assist the client, designer (including Principal Designer) and contractor (including Principal Contractor) to address their obligations under these Regulations.

See sections: 1 *Description* (1.2) and 3 *Delivery and site handling* (3.1 and 3.2) of this Certificate.

## Technical Specification

### 1 Description

1.1 Hempadur Mastic (AL) 45880-19910 is a two-pack, high-build, aluminium epoxy primer comprising a base and a curing agent, for use as part of a specification for the corrosion protection of structural steelwork in highways applications, in accordance with the MCHW, Volumes 1 and 2, where item No 115 is specified. The product is available in one colour, aluminium.

1.2 The product has the following characteristics:

Specific gravity	base	1.64
	curing agent	0.97
	mixed	1.50
Volume solids (%)	mixed	80
Flashpoint (°C)	base	37
	curing agent	43
	mixed	25
VOC content (g·l <sup>-1</sup> )	mixed	216.

### 2 Manufacture

2.1 The product is manufactured by a batch-blending process.

2.2 As part of the assessment and ongoing surveillance of product quality, the BBA has:

- agreed with the manufacturer the quality control procedures and product testing to be undertaken
- assessed and agreed the quality control operated over batches of incoming materials
- monitored the production process and verified that it is in accordance with the documented process
- evaluated the process for management of nonconformities
- checked that equipment has been properly tested and calibrated

- undertaken to carry out the above measures on a regular basis through a surveillance process, to verify that the specifications and quality control being operated by the manufacturer are being maintained.

2.3 The management system of the manufacturer has been assessed and registered as meeting the requirements of BS EN ISO 9001 : 2015 by LRQA Denmark (Certificate 00008968).

### 3 Delivery and site handling

3.1 The product is supplied in 5 and 20 litre packs, in the correct proportions. The gross weight of the mixed 20 litre container is 29.5 kg.

3.2 The Certificate holder has taken the responsibility of classifying and labelling the product under the *CLP Regulation (EC) No 1272/2008 on the classification, labelling and packaging of substances and mixtures*. Users must refer to the relevant Safety Data Sheet(s).

3.3 When stored in its original containers in a paint store in the conditions recommended by the Certificate holder, the product has a minimum shelf-life of 36 months.

## Assessment and Technical Investigations

The following is a summary of the assessment and technical investigations carried out on Hempadur Mastic (AL) 45880-19910.

## Design Considerations

### 4 Use

Where included as part of the specifications for a paint system as listed in the *Supplement to Paints for Corrosion Protection of Structural Steelwork in Highways Applications*<sup>(1)</sup>, Hempadur Mastic (AL) 45880-19910 is satisfactory for use as a primer on:

- steel surfaces prepared by abrasive blast cleaning to surface standard Sa 2½ to BS EN ISO 8501-1 : 2007 and BS 7079-A1 : 1989
- steel surfaces prepared by abrasive blast cleaning to surface standard St3 in accordance with BS EN ISO 8501-1 : 2007 and BS 7079-A1 : 1989
- bright or sound metal coatings
- sound weathered coatings

(1) Product Sheet 99 of this Certificate.

### 5 Practicability of installation

Application is designed to be carried out by operatives familiar with this type of product.

### 6 Corrosion resistance

The product has been registered in accordance with the requirements of CG303 and can contribute to corrosion resistance when included as part of the specification for a paint system as listed in the *Supplement to Paints for Corrosion Protection of Structural Steelwork in Highways Applications*.

### 7 Maintenance

Regular planned maintenance may be required as per section 8. Damage can be repaired in accordance with the MCHW, Volume 1 (Paints), Series 5000.

## 8 Durability

A complete paint system incorporating the product described in this Certificate can be expected to perform satisfactorily for a period in excess of 15 years before its first major maintenance.

## Installation

## 9 Application

9.1 Substrates must be cleaned and prepared in accordance with the MCHW, Volume 1 (Paints), Series 1900 and 5000, and the Certificate holder's instructions.

9.2 The base is mixed using a power agitator; the entire contents of the curing agent are added, and the product is mixed thoroughly.

9.3 The product is applied by airless spray (tip 0.017 to 0.023 inches, output fluid pressure 250 bar), to achieve a dry film thickness (dft) range of 125 to 200 µm. The Certificate holder can advise on suitable spray equipment.

9.4 Small areas can be coated by brush, if required.

9.5 The product is overcoated with the Certificate holder's products holding the appropriate HAPAS approvals, observing the minimum overcoating period given in Table 1.

*Table 1 Application properties*

Characteristic	Temperature (°C)			
	5	10	20	30
Surface dry (hours)	12	8	4	2
Hard dry (hours)	38	19	6.5	5
Minimum overcoating time (hours)	36	18	6	5
Pot life (hours)	—	1.5	1	0.75

9.6 The product must be used within the pot life given in Table 1.

## Technical Investigations

## 10 Tests

10.1 Tests were conducted on the liquid product and the results assessed to determine:

- density
- flashpoint
- volume solids
- viscosity
- volatile organic content
- pot life
- other composition requirements.

10.2 Tests were conducted on the product as an applied coating and the results assessed to determine:

- opacity of primer, undercoat and topcoat
- colour designation
- visual comparison of primer, undercoat and topcoat colours against the declared standard
- gloss

- time to surface dry (Ballotini)
- time to hard dry
- application and appearance
- minimum overcoating time
- film thickness
- flexibility (topcoats only).

10.3 Tests were conducted on the product as part of a complete system and the results assessed to determine:

- artificial weathering of topcoat
- scratch resistance of single-pack topcoat and of two-pack topcoat
- impact resistance
- adhesion for systems of thicknesses <250 µm, and >250 µm
- resistance to salt spray
- resistance to sulphur dioxide
- humidity.

## 11 Investigations

The manufacturing process was evaluated, including the methods adopted for quality control, and details were obtained of the quality and composition of materials used.

### Bibliography

BS 7079-A1 : 1989 *Preparation of steel substrates before application of paints and related products — Visual assessment of surface cleanliness — Representative photographic examples of the change of appearance imparted to steel when blast-cleaned with different abrasives*

BS EN ISO 8501-1 : 2007 *Preparation of steel substrates before application of paints and related products — Visual assessment of surface cleanliness — Rust grades and preparation grades of uncoated steel substrates and of steel substrates after removal of previous coatings*

BS EN ISO 9001 : 2015 *Quality management systems — Requirements*

CG303 (formerly BD 35/14) *Design Manual for Roads and Bridges (DMRB), Volume 2 Highway Structures : Design (Substructures and Special Structures), Materials, Section 3 Paints and Other Protective Coatings Part 1 Quality assurance Scheme for Paints and Similar Protective Coatings*

BD 87/05 *Design Manual for Roads and Bridges (DMRB), Volume 3 Highway Structures : Inspection and Maintenance, Section 2 Maintenance — Part 2 Maintenance Painting of Steelwork Coatings — Part 2 Quality Assurance Scheme for Paints and Similar Protective Coatings*

Manual of Contract Documents for Highway Works, Volume 1 *Specification for Highway Works, Series 1900 Protection of steelwork against corrosion*

Manual of Contract Documents for Highway Works, Volume 1 *Specification for Highway Works, Series 5000 Maintenance painting of steelwork*

Manual of Contract Documents for Highway Works, Volume 2 *Notes for Guidance on the Specification for Highway Works, Series 1900 Protection of steelwork against corrosion*

Manual of Contract Documents for Highway Works, Volume 2 *Notes for Guidance on the Specification for Highway Works, Series 5000 Maintenance painting of steelwork*

### 12 Conditions

#### 12.1 This Certificate:

- relates only to the product/system that is named and described on the front page
- is issued only to the company, firm, organisation or person named on the front page – no other company, firm, organisation or person may hold or claim that this Certificate has been issued to them
- is valid only within the UK
- has to be read, considered and used as a whole document – it may be misleading and will be incomplete to be selective
- is copyright of the BBA
- is subject to English Law.

12.2 Publications, documents, specifications, legislation, regulations, standards and the like referenced in this Certificate are those that were current and/or deemed relevant by the BBA at the date of issue or reissue of this Certificate.

12.3 This Certificate will remain valid for an unlimited period provided that the product/system and its manufacture and/or fabrication, including all related and relevant parts and processes thereof:

- are maintained at or above the levels which have been assessed and found to be satisfactory by the BBA
- continue to be checked as and when deemed appropriate by the BBA under arrangements that it will determine
- are reviewed by the BBA as and when it considers appropriate.

12.4 The BBA has used due skill, care and diligence in preparing this Certificate, but no warranty is provided.

12.5 In issuing this Certificate the BBA is not responsible and is excluded from any liability to any company, firm, organisation or person, for any matters arising directly or indirectly from:

- the presence or absence of any patent, intellectual property or similar rights subsisting in the product/system or any other product/system
- the right of the Certificate holder to manufacture, supply, install, maintain or market the product/system
- actual installations of the product/system, including their nature, design, methods, performance, workmanship and maintenance
- any works and constructions in which the product/system is installed, including their nature, design, methods, performance, workmanship and maintenance
- any loss or damage, including personal injury, howsoever caused by the product/system, including its manufacture, supply, installation, use, maintenance and removal
- any claims by the manufacturer relating to CE marking.

12.6 Any information relating to the manufacture, supply, installation, use, maintenance and removal of this product/system which is contained or referred to in this Certificate is the minimum required to be met when the product/system is manufactured, supplied, installed, used, maintained and removed. It does not purport in any way to restate the requirements of the Health and Safety at Work etc. Act 1974, or of any other statutory, common law or other duty which may exist at the date of issue or reissue of this Certificate; nor is conformity with such information to be taken as satisfying the requirements of the 1974 Act or of any statutory, common law or other duty of care.