



NORMAALI

ISO 12944-5 PROTECTIVE PAINT SYSTEMS

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In this file you can find Nor-Maali's recommended anti-corrosion paint systems for steel structures.

These ISO 12944-5:2019 protective paint systems have been composed and tested in co-operation by our sales, product development and laboratory staff.

If you need more information about our painting systems, contact sales@nor-maali.fi

Atmospheric corrosivity categories:

- C1 – very low
- C2 – low
- C3 – medium
- C4 – high
- C5 – very high

Categories for water and soil:

- Im1 – immersion in fresh water
- Im2 – immersion in sea or brackish water
- Im3 – buried in soil

Durability:

- Low (L) – Up to 7 years
- Medium (M) – 7 years to 15 years
- High (H) – 15 years to 25 years
- Very high (VH) – more than 25 years

The durability range is not a “guarantee time”. Durability is a technical consideration/planning parameter that can help the owner set up a maintenance programme. A guarantee time is a consideration that is the legal subject of clauses in the administrative part of the contract. The guarantee time is usually shorter than the durability range. There are no rules that link the two periods of time.

Corrosivity category	Examples of typical environments (informative only): Exterior	Examples of typical environments (informative only): Interior
C1 – very low	–	Heated buildings with clean atmospheres, e.g. offices, shops, schools, hotels
C2 – low	Atmospheres with low level of pollution: mostly rural areas	Unheated buildings where condensation can occur, e.g. depots, sports halls
C3 – medium	Urban and industrial atmospheres, moderate sulfur dioxide pollution; coastal areas with low salinity	Production rooms with high humidity and some air pollution, e.g. food-processing plants, laundries, breweries, dairies
C4 – high	Industrial areas and coastal areas with moderate salinity	Chemical plants, swimming pools, coastal ship and boatyards
C5 – very high	Industrial areas with high humidity and aggressive atmosphere and coastal areas with high salinity	Buildings or areas with almost permanent condensation and with high pollution

Category	Environment	Examples of environments and structures
Im1	Fresh water	River installations, hydro-electric power plants
Im2	Sea or brackish water	Immersed structures without cathodic protection (e.g. harbour areas with structures like sluice gates, locks or jetties)
Im3	Soil	Buried tanks, steel piles, steel pipes



CORROSIVITY CATEGORY C2

CARBON STEEL

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C2.01 AK 80/1	Norrapid 7 Norrapid 10	AK	1	80									80	1	●			
C2.01 AK 80/2	Praimex Paja-Pohja	AK	1	40					Norrapid 7 Norrapid 10 Norrapid 12	AK	1	40	80	2	●			
C2.01 AY 80/1	Akvanor 100 SG	AY	1	80									80	1	●			
C2.02 AK 100/1	Norrapid 7 Norrapid 10	AK	1	100									100	1	●	●		
C2.02 AK 100/2	Praimex Paja-Pohja	AK	1	60					Norrapid 7 Norrapid 10 Norrapid 12	AK	1	40	100	2	●	●		
C2.02 AY 100/1	Akvanor 100 SG	AY	1	100									100	1	●	●		
C2.03 AK 160/2	Praimex Paja-Pohja	AK	1	80					Norrapid 7 Norrapid 10 Norrapid 12	AK	1	80	160	2	●	●	●	
C2.04 AK 200/3	Praimex Paja-Pohja	AK	1	80	Praimex Paja-Pohja	AK	1	80	Norrapid 7 Norrapid 10 Norrapid 12	AK	1	40	200	3 (2-3)	●	●	●	●
C2.05 AY 120/1	Akvanor 100 SG Norecyl Aqua DTM Norecyl 50	AY	1	120									120	1	●	●	●	
C2.05 EP 120/1	Epotex HB Norepox HS Norepox Aqua DTM	EP	1	120									120	1	●	●	●	
C2.05 EP 120/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	60					Epotex HB Norepox HS Norepox Aqua DTM	EP	1	60	120	2	●	●	●	
C2.05 EP 80/1 *	Epocoat Aqua Primer	EP	1	80									80	1	●	●	●	

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C2.05 EPPUR 120/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	60					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	60	120	2	●	●	●	
C2.05 PUR 120/1	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normadur Aqua DTM	PUR	1	120									120	1	●	●	●	
C2.06 EP 180/2	NorECOat FD Primer	EP	1	100					Norepox Aqua DTM	EP	1	80	180	2	●	●	●	●
C2.06 EP 180/2	Epocoat Aqua Primer	EP	1	80					Norepox HS Norepox Aqua DTM	EP	1	100	180	2	●	●	●	●
C2.06 EPPUR 180/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	100					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	80	180	2	●	●	●	●
C2.06 EPPUR 180/2	NorECOat FD Primer	EP	1	120					NoreFast HS	PUR	1	60	180	2	●	●	●	●
C2.06 EPPUR 180/2	Epocoat Aqua Primer	EP	1	80					Normadur 65 HS Normafine 40 HS Normadur Aqua DTM	PUR	1	100	180	2	●	●	●	●
C2.06 EPPUR 180/2	Norepox Aqua DTM	EP	1	100					Normadur Aqua DTM	PUR	1	80	180	2	●	●	●	●
C2.06 PUR 160/1*	Normafine 80 Normafine HS	PUR	1	160									160	1	●	●	●	●

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C2.07 EPZn(R) 60/1	Normazinc SE Normazinc Plus	Zn(R)	1	60									60	1	●	●	●	
C2.08 EPZn(R)EP 160/2	Normazinc SE Normazinc Plus	Zn(R)	1	60					Epotex HB Norepox HS Norepox Aqua DTM	EP	1	100	160	2	●	●	●	●
C2.08 EPZn(R)PUR 160/2	Normazinc SE Normazinc Plus	Zn(R)	1	60					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normadur Aqua DTM	PUR	1	100	160	2	●	●	●	●



CORROSIVITY CATEGORY C3

CARBON STEEL

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C3.01 AK 100/2	Praimex Paja-Pohja	AK	1	60					Norrapid 7 Norrapid 10 Norrapid 12	AK	1	40	100	2 (1-2)	●			
C3.02 AK 160/2	Praimex Paja-Pohja	AK	1	80					Norrapid 7 Norrapid 10 Norrapid 12	AK	1	80	160	2	●	●		
C3.03 AK 200/3	Praimex Paja-Pohja	AK	1	80	Praimex Paja-Pohja	AK	1	80	Norrapid 7 Norrapid 10 Norrapid 12	AK	1	40	200	3 (2-3)	●	●	●	
C3.04 AK 260/3	Praimex Paja-Pohja	AK	1	90	Praimex Paja-Pohja	AK	1	90	Norrapid 7 Norrapid 10	AK	1	80	260	3 (2-4)	●	●	●	●
C3.05 AY 120/1	Akvanor 100 SG Norecyl Aqua DTM Norecyl 50	AY	1	120									120	1	●	●		
C3.05 EP 120/1	Epotex HB Norepox HS Normastic 405 Norepox Aqua DTM	EP	1	120									120	1	●	●		
C3.05 EP 120/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	60					Epotex HB Norepox HS Norepox Aqua DTM	EP	1	60	120	2	●	●		
C3.05 EP 80/1 *	Epocoat Aqua Primer	EP	1	80									80	1	●	●		
C3.05 EPPUR 120/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	60					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	60	120	2	●	●		
C3.05 PUR 120/1	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normadur Aqua DTM	PUR	1	120									120	1	●	●		

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C3.06 EP 180/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer Normastic 405	EP	1	100					Epotex HB Norepox HS	EP	1	80	180	2	●	●	●	
C3.06 EP 180/2	NorECOat FD Primer	EP	1	100					Norepox Aqua DTM	EP	1	80	180	2	●	●	●	
C3.06 EP 180/2	Epocoat Aqua Primer	EP	1	80					Norepox HS Norepox Aqua DTM	EP	1	100	180	2	●	●	●	
C3.06 EPPUR 180/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	100					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	80	180	2	●	●	●	
C3.06 EPPUR 180/2	NorECOat FD Primer	EP	1	120					NoreFast HS	PUR	1	60	180	2	●	●	●	
C3.06 EPPUR 180/2	Epocoat Aqua Primer	EP	1	80					Normadur 65 HS Normafine 40 HS Normadur Aqua DTM	PUR	1	100	180	2	●	●	●	
C3.06 EPPUR 180/2	Norepox Aqua DTM	EP	1	100					Normadur Aqua DTM	PUR	1	80	180	2	●	●	●	
C3.06 PUR 160/1*	Normafine 80 Normafine HS	PUR	1	160									160	1	●	●	●	
C3.07 EP 180/2 *	Epocoat Aqua Primer	EP	1	80					Norepox Aqua DTM	EP	1	100	180	2	●	●	●	●
C3.07 EP 240/2	Norepox Aqua DTM	EP	1	120					Norepox Aqua DTM	EP	1	120	240	2	●	●	●	●

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C3.07 EPPUR 240/2	NorECOat FD MIO Primer Normastic 405 AL Normastic 405 Harm./ Pun.	EP	1	140					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD	PUR	1	100	240	2 (2-3)	●	●	●	●
C3.07 EPPUR 240/2	NorECOat FD MIO Primer	EP	1	140					Normadur Aqua DTM	PUR	1	100	240	2	●	●	●	●
C3.08 EPZn(R) 60/1	Normazinc SE Normazinc Plus	Zn(R)	1	60									60	1	●	●		
C3.09 EPZn(R)EP 160/2	Normazinc SE Normazinc Plus	Zn(R)	1	60					Epotex HB Norepox HS Norepox Aqua DTM	EP	1	100	160	2	●	●	●	
C3.09 EPZn(R)PUR 160/2	Normazinc SE Normazinc Plus	Zn(R)	1	60					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normadur Aqua DTM	PUR	1	100	160	2	●	●	●	
C3.10 EPZn(R)EP 200/3	Normazinc SE Normazinc Plus	Zn(R)	1	60	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Epotex HB Norepox HS Norepox Aqua DTM	EP	1	60	200	3	●	●	●	●
C3.10 EPZn(R)EPPUR 200/3	Normazinc SE Normazinc Plus	Zn(R)	1	60	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	60	200	3	●	●	●	●
C3.10 EPZn(R)PUR 200/2	Normazinc SE Normazinc Plus	Zn(R)	1	60					Normafine 80	PUR	1	140	200	2	●	●	●	●



CORROSIVITY CATEGORY C4

CARBON STEEL

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C4.01 AK 160/2	Praimex Paja-Pohja	AK	1	80					Norrapid 7 Norrapid 10 Norrapid 12	AK	1	80	160	2	●			
C4.02 AK 200/3	Praimex Paja-Pohja	AK	1	80	Praimex Paja-Pohja	AK	1	80	Norrapid 7 Norrapid 10 Norrapid 12	AK	1	40	200	3 (2-3)	●	●		
C4.03 AK 260/3	Praimex Paja-Pohja	AK	1	90	Praimex Paja-Pohja	AK	1	90	Norrapid 7 Norrapid 10 Norrapid 12	AK	1	80	260	3 (2-4)	●	●	●	
C4.04 AY 120/1	Norecyl Aqua DTM Norecyl 50	AY	1	120									120	1	●			
C4.04 EP 120/1	Epotex HB Norepox HS Normastic 405 Norepox Aqua DTM	EP	1	120									120	1	●			
C4.04 EP 120/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	60					Epotex HB Norepox HS Norepox Aqua DTM	EP	1	60	120	2	●			
C4.04 EP 80/1 *	Epocoat Aqua Primer	EP	1	80									80	1	●			
C4.04 EPPUR 120/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	60					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	60	120	2	●			
C4.04 PUR 120/1	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normadur Aqua DTM	PUR	1	120									120	1	●			

* Tested according to ISO 12944-6:2018

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C4.05 EP 180/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer Normastic 405	EP	1	100					Epotex HB Norepox HS	EP	1	80	180	2	●	●		
C4.05 EP 180/2	NorECOat FD Primer	EP	1	100					Norepox Aqua DTM	EP	1	80	180	2	●	●		
C4.05 EP 180/2	Epocoat Aqua Primer	EP	1	80					Epocoat 210 Norepox HS Norepox Aqua DTM	EP	1	100	180	2	●	●		
C4.05 EPPUR 180/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	100					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	80	180	2	●	●		
C4.05 EPPUR 180/2	NorECOat FD Primer	EP	1	120					NoreFast HS	PUR	1	60	180	2	●	●		
C4.05 EPPUR 180/2	Epocoat Aqua Primer	EP	1	80					Normadur 65 HS Normafine 40 HS Normadur Aqua DTM	PUR	1	100	180	2	●	●		
C4.05 EPPUR 180/2	Norepox Aqua DTM	EP	1	100					Normadur Aqua DTM	PUR	1	80	180	2	●	●		
C4.05 PUR 160/1*	Normafine 80 Normafine HS	PUR	1	160									160	1	●	●		
C4.06 EP 180/2*	Epocoat Aqua Primer	EP	1	80					Norepox Aqua DTM	EP	1	100	180	2	●	●	●	
C4.06 EP 240/2	Norepox Aqua DTM	EP	1	120					Norepox Aqua DTM	EP	1	120	240	2	●	●	●	
C4.06 EP 240/3	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Epotex HB Norepox HS Norepox Aqua DTM	EP	1	80	240	3 (2-3)	●	●	●	

* Tested according to ISO 12944-6:2018

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C4.06 EPPUR 240/2	NorECOat FD MIO Primer	EP	1	140					Normadur Aqua DTM	PUR	1	100	240	2	●	●	●	
C4.06 EPPUR 240/3	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	80	240	3 (2-3)	●	●	●	
C4.07 EP 300/3	NorECOat FD MIO Primer Normastic 405 AL Normastic 405 Harm./ Pun.	EP	1	120	NorECOat FD MIO Primer Normastic 405 AL Normastic 405 Harm./ Pun.	EP	1	120	Epotex HB Norepox HS	EP	1	60	300	3 (2-4)	●	●	●	●
C4.07 EPPUR 300/2	NorECOat HS Primer	EP	1	240					NoreFast HS	PUR	1	60	300	2	●	●	●	●
C4.07 EPPUR 300/3	NorECOat FD MIO Primer Normastic 405 AL Normastic 405 Harm./ Pun.	EP	1	120	NorECOat FD MIO Primer Normastic 405 AL Normastic 405 Harm./ Pun.	EP	1	120	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD	PUR	1	60	300	3	●	●	●	●
C4.08 EPZn(R) 60/1	Normazinc SE Normazinc Plus	Zn(R)	1	60									60	1	●			
C4.09 EPZn(R)EP 160/2	Normazinc SE Normazinc Plus	Zn(R)	1	60					Epotex HB Norepox HS Norepox Aqua DTM	EP	1	100	160	2	●	●		
C4.09 EPZn(R)PUR 160/2	Normazinc SE Normazinc Plus	Zn(R)	1	60					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normadur Aqua DTM	PUR	1	100	160	2	●	●		

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C4.10 EPZn(R)EP 200/3	Normazinc SE Normazinc Plus	Zn(R)	1	60	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Epotex HB Norepox HS Norepox Aqua DTM	EP	1	60	200	3	●	●	●	
C4.10 EPZn(R)EPPUR 200/3	Normazinc SE Normazinc Plus	Zn(R)	1	60	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	60	200	3	●	●	●	
C4.10 EPZn(R)PUR 200/2	Normazinc SE Normazinc Plus	Zn(R)	1	60					Normafine 80	PUR	1	140	200	2	●	●	●	
C4.11 EPZn(R)EP 260/3	Normazinc Plus	Zn(R)	1	60	NorECOat FD Primer NorECOat HS Primer Normastic 405	EP	1	140	Epotex HB Norepox HS Norepox Aqua DTM	EP	1	60	260	3 (3-4)	●	●	●	●
C4.11 EPZn(R)EPPUR 260/3	Normazinc Plus	Zn(R)	1	60	NorECOat FD Primer NorECOat HS Primer Normastic 405	EP	1	140	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normadur Aqua DTM	PUR	1	60	260	3 (3-4)	●	●	●	●



CORROSION CATEGORY C5

CARBON STEEL

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C5.01 EP 180/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer Normastic 405	EP	1	100					Epotex HB Norepox HS	EP	1	80	180	2	●			
C5.01 EP 180/2	NorECOat FD Primer	EP	1	100					Norepox Aqua DTM	EP	1	80	180	2	●			
C5.01 EP 180/2	Epocoat Aqua Primer	EP	1	80					Norepox HS Norepox Aqua DTM	EP	1	100	180	2	●			
C5.01 EPPUR180/2	Epocoat 21 HB NorECOat FD Primer NorECOat HS Primer Normastic 405	EP	1	120					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	60	180	2	●			
C5.01 EPPUR180/2	NorECOat FD Primer	EP	1	120					NoreFast HS	PUR	1	60	180	2	●			
C5.01 EPPUR180/2	Epocoat Aqua Primer	EP	1	80					Normadur 65 HS Normafine 40 HS Normadur Aqua DTM	PUR	1	100	180	2	●			
C5.02 EP 180/2 *	Epocoat Aqua Primer	EP	1	80					Norepox Aqua DTM	EP	1	100	180	2	●	●		
C5.02 EP 240/2	Norepox Aqua DTM	EP	1	120					Norepox Aqua DTM	EP	1	120	240	2	●	●		
C5.02 EP 240/3	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Epotex HB Norepox HS	EP	1	80	240	3 (2-3)	●	●		

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C5.02 EPPUR 240/2	NorECOat FD MIO Primer	EP	1	140					Normadur Aqua DTM	PUR	1	100	240	2	●	●		
C5.02 EPPUR 240/3	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	80	240	3 (2-3)	●	●		
C5.03 EP 300/3	Epocoat 21 HB NorECOat FD MIO Primer NorECOat HS Primer	EP	1	120	Epocoat 21 HB NorECOat FD Primer NorECOat HS Primer	EP	1	120	Epotex HB Norepox HS	EP	1	60	300	3 (2-4)	●	●	●	
C5.03 EPPUR 300/2	NorECOat HS Primer	EP	1	240					NoreFast HS	PUR	1	60	300	2	●	●	●	
C5.03 EPPUR 300/3	Epocoat 21 HB NorECOat FD Primer NorECOat HS Primer	EP	1	120	Epocoat 21 HB NorECOat FD Primer NorECOat HS Primer	EP	1	120	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD	PUR	1	60	300	3 (2-4)	●	●	●	
C5.04 EPPUR 360/3	NorECOat FD MIO Primer Normastic 405 AL Normastic 405 <i>Harm. / Pun.</i>	EP	1	140	NorECOat FD MIO Primer Normastic 405 AL Normastic 405 <i>Harm. / Pun.</i>	EP	1	140	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD	PUR	1	80	360	3	●	●	●	●
C5.05 EPZn(R)EP 160/2	Normazinc SE Normazinc Plus	Zn(R)	1	60					Epotex HB Norepox HS	EP	1	100	160	2	●			
C5.05 EPZn(R)PUR 160/2	Normazinc SE Normazinc Plus	Zn(R)	1	60					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normadur Aqua DTM	PUR	1	100	160	2	●			

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
C5.06 EPZn(R)EP 200/3	Normazinc SE Normazinc Plus	Zn(R)	1	60	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Epotex HB Norepox HS	EP	1	60	200	3	●	●		
C5.06 EPZn(R)EPPUR 200/3	Normazinc SE Normazinc Plus	Zn(R)	1	60	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer NorECOat HS Primer	EP	1	80	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD Normadur Aqua DTM	PUR	1	60	200	3	●	●		
C5.06 EPZn(R)PUR 200/2	Normazinc SE Normazinc Plus	Zn(R)	1	60					Normafine 80	PUR	1	140	200	2	●	●		
C5.07 EPZn(R)EP 260/3	Normazinc Plus	Zn(R)	1	60	NorECOat FD MIO Primer	EP	1	120	Epotex HB Norepox HS	EP	1	80	260	3-4	●	●	●	
C5.07 EPZn(R)EPPUR 260/3	Normazinc Plus	Zn(R)	1	60	NorECOat FD MIO Primer	EP	1	120	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD	PUR	1	80	260	3-4	●	●	●	
C5.08 EPZn(R)EP 320/3	Normazinc Plus	Zn(R)	1	60	Normastic 405	EP	1	200	Epotex HB Norepox HS	EP	1	60	320	3-4	●	●	●	●
C5.08 EPZn(R)EPPUR 320/3	Normazinc Plus	Zn(R)	1	60	Normastic 405	EP	1	200	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD	PUR	1	60	320	3-4	●	●	●	●



CORROSIVITY CATEGORIES C2-C5

HOT DIP GALVANIZED STEEL

Our recommendations for hot dip galvanized steel systems:

*Preparation grade: SaS

*Priming coat: Mist coat with high thinned epoxy primer

System No.	Corrosivity category	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
		Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
G2.01 EP 80/1	C2	Epotex HB	EP	1	80									80	1	●	●	●	
G2.02		N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	●	●	●	●
G2.03 EP 120/1		Epotex HB	EP	1	120									120	1 (1-2)	●	●	●	●
G3.01 EP 80/1	C3	Epotex HB	EP	1	80									80	1	●	●		
G3.02 EP 120/1		Epotex HB	EP	1	120									120	1	●	●	●	
G3.03		N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	●	●	●	
G3.04 EPPUR 160/2		Epocoat 21 Primer	EP	1	80					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD	PUR	1	80	160	2	●	●	●	●
G3.05		N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	●	●	●	●
G4.01 EP 80/1		C4	Epotex HB	EP	1	80									80	1	●		
G4.02 EP 120/1	Epotex HB		EP	1	120									120	1 (1-2)	●	●		
G4.03	N/A		N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	●	●		
G4.04 EP 160/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer		EP	1	80					Epotex HB Norepox HS	EP	1	80	160	2	●	●	●	
G4.05	N/A		N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	●	●	●	
G4.06 EPPUR 200/2	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer		EP	1	100					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS	PUR	1	100	200	2 (2-3)	●	●	●	●

Our recommendations for hot dip galvanized steel systems:

*Preparation grade: SaS

*Priming coat: Mist coat with high thinned epoxy primer

System No.	Corrosivity category	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
		Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
G5.01 EPPUR 120/2	C5	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	60					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD	PUR	1	60	120	2	●			
G5.02a		N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	●		
G5.02b EPPUR 160/2		Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	80					Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD	PUR	1	80	160	2	●	●		
G5.03		N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	●	●	
G5.04 EPPUR 200/3		Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	60	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	60	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD	PUR	1	80	200	3 (2-3)	●	●	●	
G5.05 EPPUR 240/3		Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	80	Epocoat 21 HB Epocoat 21 Primer NorECOat FD Primer	EP	1	80	Normadur 65 HS Normafine 20 Normafine 40 HS Normafine 80 Normafine HS Normathane 50 FD	PUR	1	80	240	3	●	●	●	●



CATEGORIES FOR WATER AND SOIL

CARBON STEEL
Im 1, Im 2, Im 3

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
I.01 EPZn(R)EP 360/3	Normazinc Plus	Zn(R)	1	60	Normastic 405	EP	1	150	Normastic 405	EP	1	150	360	3 (2-4)	●	●	●	
I.02 EPZn(R)EP 500/3	Normazinc Plus	Zn(R)	1	60	Normastic 405	EP	1	220	Normastic 405	EP	1	220	500	3 (2-5)	●	●	●	●
I.03 EP 380/2	Normastic 405 AL	EP	1	190					Normastic 405	EP	1	190	380	2 (2-4)	●	●	●	
I.04 EP 540/2	Epocoat 280 GF	EP	1	270					Epocoat 280 GF	EP	1	270	540	2 (2-4)	●	●	●	●
I.05 EP 400/2	Normastic 405 AL	EP	1	200					Normastic 405	EP	1	200	400	2 (1-3)	●	●	●	
I.06 EP 600/2	Epocoat 280 GF	EP	1	300					Epocoat 280 GF	EP	1	300	600	2 (2-3)	●	●	●	●

Im1, Im2 – TESTED ACCORDING TO ISO 12944-6:2018

System No.	PRIMER COAT				INTERMEDIATE COAT				TOPCOAT				SYSTEM		DURABILITY			
	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	Product name	Product type	Coats	DFT (µm)	DFT (µm) total	Total coats	low	med	high	very high
Im1 HIGH EP 400/2	NorECOat HS Primer	EP	1	200					NorECOat HS Primer	EP	1	200	400	2	●	●	●	
Im1 VERY HIGH EP 600/3	NorECOat HS Primer	EP	1	200	NorECOat HS Primer	EP	1	200	NorECOat HS Primer	EP	1	200	600	3	●	●	●	●
Im2 HIGH EP 500/2	NorECOat HS Primer	EP	1	250					NorECOat HS Primer	EP	1	250	500	2	●	●	●	
Im2 VERY HIGH EP 600/3	NorECOat HS Primer	EP	1	200	NorECOat HS Primer	EP	1	200	NorECOat HS Primer	EP	1	200	600	3	●	●	●	●



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