

Thin Film Intumescent Coating

Product Data/ Application Instructions

- Thin film solvent based intumescent
- Tested to international fire test standards
- Up to 2 hours fire protection of structural steel
- Off-site or on-site application
- Up to 1.5 mm dry film thickness application in a single coat
- Rapid job completion
- For use in C1, C2, C3 & C4 internal & external environments - no sealer coat required for dry internal C1 service conditions (ISO 12944)

Typical Uses

Intumescent fire protection for internal and external structural steel. Steelguard FM 550 is suitable for off site application by manual airless spray or automatic application with pre-heat and accelerated drying facilities.

Approvals

Steelguard FM 550 has been tested to British Standard 476 Part 21 and UK assessed by Warrington Fire. Appraised by the UK ASFP technical committee and approved for entry in the Yellow Book. Steelguard FM 550 has been assessed in accordance with the Dutch standard NEN 6072:2001 and also been assessed and certified to several national fire test standards.

Mixing

Stir thoroughly before use until the product is uniform throughout. This may cause an apparent thinning effect which is normal for this product. A power mixer should be used.

Physical Data

Appearance when dry	matt					
Colour	white, grey					
Components	1					
Volume solids*	68 ± 3%					
VOC**						
EC SED 1999/13/EC	293g/kg (377 g/l)					
UK PG6/23 (92) Appendix 3 ..	325 g/l					
Curing mechanism	solvent release					
Loading requirements.....	In order to establish the dry film thickness required to give the specified fire resistance reference should be made to the products $A/V \text{ m}^{-1}$ (Hp/A) or limiting temperature tables. Contact your Ameron representative for full details.					
Dry film thickness (µm)	250	400	500	700	1000	1500
Wet film thickness (µm)	370	590	740	1030	1470	2205
Theoretical coverage (m ² /l)	2.72	1.70	1.36	0.97	0.68	0.45
(wet film thicknesses quoted are theoretical for one airless spray coat)						
Specific gravity	1.3 kg/l					
Flashpoint						
(closed cup)	°C	°F				
Steelguard FM 550	25	77				
Amercoat 65	24	75				

*Volume Solids is measured in accordance with ASTM D2697 modified. Slight variations of up to ±3% may occur due to testing variances.

** VOC figures are quoted according to the EC directive 1999/13/EC which are theoretically calculated figures and the UK PG6/23 (92) Appendix 3 which are practically determined figures.



Steelguard FM 550

Surface Preparation

Applied over a blasted and suitably primed steel substrate. The surface must be dry and free of dust, salts, grease and other contaminants immediately before coating. The primer used should be applied in accordance with the specific technical data sheet instructions, and must be approved by Ameron to ensure compatibility with the Steelguard FM 550. The total dry film thickness of primer coats should generally not exceed 150 µm. For epoxy primers the maximum allowable dry film thickness may be extended, consult your Ameron representative prior to intumescent application.

For off-site application Steelguard FM 550 may be applied directly to the blast cleaned substrate provided the steelwork is to be used in dry internal C1 conditions and the dry film thickness exceeds 400 µm. The steel should be abrasive blast cleaned to ISO 8501-1 Sa 2½ with a blast profile of approximately 50-75 µm and should not exceed 100 µm. Coating should occur before degradation of the surface takes place. If oxidation occurs then the steel should be re-prepared. The surface must be dry and free of dust, salts, grease and other contaminants immediately before coating.

Application Methods

Spray application will provide the smoothest finish. Brush application will result in a textured finish.

AIRLESS SPRAY - Use a pump capable of producing a minimum pressure at the tip of 2800 psi (200 kg/cm²). A 30 mesh/500 µm internal filter is recommended. Tip size 19-33 thou' (0.48-0.83mm). For off-site application it is recommended that the product is applied in 700 µm dry film thickness coats allowing a minimum of 8 hours drying at 15°C/59°F between each coat. For on-site higher film thicknesses can be applied in a single application, it is recommended that the dry film thickness of initial coat should not exceed 1.5mm. Subsequent coats as a guide may be applied after 8 hours at 20°C/68°F to a maximum dry film thickness of 1.0 mm per coat.

BRUSH - Apply evenly using a clean, well-loaded brush at up to 300 µm dry film thickness per coat. As a guide allow at least 2 hours drying at 20°C/68°F between coats.

Drying Characteristics

Drying times will vary considerably depending on ambient conditions, method of application, pre-heat and force drying conditions if used, A/V m⁻¹ (Hp/A) of section being coated and applied film thickness. As a guide, at 15°C/59°F a 400 µm dry film thickness coating will be touch dry in approximately 1 hour and hard dry after approximately 40 hours. For further details on the drying times of Steelguard FM 550 refer to the product drying tables or contact your Ameron representative.

Overcoating

The standard recommended topcoat for Steelguard FM 550 is Steelguard 2458 which allows for fast overcoating and job completion. Other approved topcoats but with longer overcoating periods include Amercoat 450S, Amercoat 4310, Amercoat 2136 and PSX 700#. No sealer is required for internal C1 service conditions unless for cosmetic reasons. For internal C2 service conditions Steelguard FM 550 must be adequately sealed with Steelguard 2458 at 60 µm dry film thickness or other approved topcoat. For C3 & C4 external service conditions Steelguard FM 550 must be adequately sealed with two coats Steelguard 2458 at 120 µm total dry film thickness or other approved topcoat. Please contact your Ameron representative for specific recommendations. It is important that the specified intumescent thickness has been achieved before any topcoating.
(#Amercoat 71TC required as a tie coat)

Application Data

Substrate primed abrasive blasted steel

Application methods airless spray, brush

Environmental Conditions

Relative humidity:	up to 85%	
Surface temperature:	5 - 50°C	41 - 122°F
Air temperature	5 - 50°C	41 - 122°F

Surface temperature must be at least 3°C/5°F above the dew point to prevent moisture condensation on the surface.

Potlife not applicable

Thinner not normally necessary

Cleaner Amercoat 65



Steelguard FM 550

Providing the steel is suitably primed and the dry film thickness of the intumescent coating exceeds 250 µm, Steelguard FM 550 can be left externally without a topcoat for up to 12 months. During this period, however, Steelguard FM 550 must be protected from pooling and running water, hot humid environments and immersed conditions.

Steelguard FM 550 must have sufficient drying time before exposure in external conditions. As a guide, at 15°C/59°F, for a dry film thickness of 700 µm, a minimum drying period of 40 hours is recommended from time of application of the final coat before exposure.

Refer to product drying tables for drying and overcoating schedules.

Application Procedure:

1. Flush equipment with recommended cleaner before use.
2. Stir to an even consistency with a power mixer.
3. Thinning is normally not required for airless spray.
4. For airless spray apply a wet even coat in parallel passes. Overlap each pass 50% to avoid bare areas, pinholes or holidays.
5. Give special attention to welds, rough spots, sharp edges and corners, rivets, bolts, etc.
6. Application at 590 µm wet film thickness will normally provide 400 µm dry film.
7. Check thickness of dry coating with a non-destructive dry film thickness gauge, such as Mikrotest or Elcometer. If less than specified thickness, apply additional material as needed.
8. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair larger areas either by spray or brush with Steelguard FM 550 or by trowel, knife, spatula using Steelguard 2450 repair filler.
9. For repair of damaged primerless systems where bare steel is exposed, a suitable primer should be applied prior to re-application of the intumescent coating.
10. In confined areas ventilate with clean air during application and drying until all solvents are removed. Temperature and humidity of ventilating air must be such that moisture condensation will not form on surface.
11. Clean all equipment with recommended cleaner immediately after use or at least at the end of each working day or shift.

Before using the product, read the label on the can and consult the material safety data sheet.

Shipping Data

Pack size	20 and 200 litres
Shipping weight	approx. 29 kg (20 l.)
Shelf life	1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C (41 to 104°F).

Steelguard FM 550



Safety

Since improper use and handling can be hazardous to health and cause of fire or explosion, safety precautions included with application instructions must be observed during all storage, handling, use and drying periods.

Warranty

Ameron warrants its products to be free from defects in material and workmanship. Ameron's sole obligations and Buyer's exclusive remedy in connection with the products shall be limited, at Ameron's option, to either replacement of products not conforming this warranty or credit to Buyer's account in the invoiced amount of the non-conforming products. Any claim under this warranty must be made by Buyer to Ameron in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. Buyer's failure to notify Ameron of such non-conformance as required herein shall bar Buyer from recovery under this warranty.

Ameron makes no other warranties concerning the product. No other warranties, whether express, implied or statutory, such as warranties of merchantability or fitness particular purpose, shall apply. In no event shall Ameron be liable for consequential or incidental damages.

Any recommendations or suggestion relating to the use of the products made by Ameron, whether in its technical literature, or response to specific enquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyer's having requisite skill and know-how in the industry, and therefore it is Buyer to satisfy itself of the suitability of the products for its own particular use and it shall be deemed that Buyer has done so, as its sole descretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

Limitation of Liability

Ameron's liability on any claim of any kind, including claims based upon Ameron's negligence or strict liability, for any loss or damage arising out of, connected with, or resulting from the use of the products, shall in no case exceed the purchase price allocable to the products or part thereof which give rise to the claim.

In no event shall Ameron be liable for consequential or incidental damages.

Due to Ameron's policy of continuous product improvement, the information contained in this Product Data/Application Instructions sheet is subject to change without notice. It is the Buyer's responsibility to check that this issue is current prior to using the product. For the most up-to-date Product Data/Application Instructions always refer to the Ameron Performance Coatings & Finishes website at www.ameroncoatings.com

To avoid any confusion that may arise through translation into other languages, the English version of the Product Data/Application Instructions will be the governing literature and must be referred to in case of deviations with product literature in other languages.

Condition of Sale

All our transactions are subject to our Terms and Conditions of Sale.

Ameron B.V.

Tel +(31) 345 587 587
www.ameron-bv.com

Ameron International Corporation

Tel +(1) 678 393 0653
www.ameroncoatings.com

Ameron (Australia) Pty Ltd.

Tel +(61) 2 9421 8000
www.ameron.com.au

Ameron (New Zealand) Ltd.

Tel +(64) 9 573 1620
www.ameron.co.nz