

EXPECTED IMPLEMENTATION (FY 2023-24)

975 STRUCTURAL COATING MATERIALS. (REV 10-5-22) (FA 10-18-22) (FY 2023-24)

SECTION 975 is deleted and the following substituted:

975-1 General Requirements.

975-1.1 General: Upon curing, all coatings and/or coating systems must produce an adherent coating that is visually uniform. The composition of the coating is left to the discretion of the manufacturer but the finished product shall meet all requirements of this Section. All coats of multi-coat systems shall be supplied by the same manufacturer. Multi-component coatings shall be prepackaged in the required ratios.

975-1.2 Environmental Requirements: Coating materials and their waste shall be characterized as non-hazardous as defined by Resource Conservation and Recovery Act (RCRA) Subarticle C rules, Table 1 of 40 CFR 261.24 Toxicity Characteristic.

Volatile Organic Compounds (VOC) shall be less than 3.5 pounds per gallon when tested in accordance with ASTM D3960.

975-1.3 Approved Product List (APL): All polymeric coating materials except the materials in 975-4 shall be listed on the Department's Approved Product List (APL). Manufacturers seeking evaluation of their products shall submit the product data sheets, performance test reports from NTPEP or an independent laboratory showing that the product meets the requirements of this Section, a Product SDS or performance test reports showing percent weight compositional analysis including Chemical Abstract Number, ACGIH time weighted average and ceiling exposure limits for all components, lower and upper explosive limits, flash point, boiling point, amount of volatile organic compounds by weight, and specific gravity for each component of the coating system, and a APL application in accordance with Section 6.

975-1.4 Packaging and Labeling: Materials shall be shipped in containers legibly marked with application instructions, lot number, batch number, date of manufacture, shelf life, and Department APL number. Each lot or batch manufactured must have a unique number.

975-1.5 Coating Identification: When applicable, the Department will conduct Fourier Transform Infrared Spectroscopy (FTIR) analysis on coating system components for material identification.

975-2 Structural Steel Coating Systems.

975-2.1 General: Structural steel coatings shall meet the application requirements of Section 560. Prepare and coat sixteen flat and four composite test panels in accordance with AASHTO R-31 (in color White, Grey or Green) for each coating system proposed for approval and submit to the State Materials Office (SMO). Samples will be subject to verification testing by the Department, as identified in 975-2.2. In addition, submit a 1-quart wet sample of each component of each coating system, one container of compatible caulk to the SMO.

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975-2.2 Performance Requirements: Each coating system will be subject to the testing identified in 975-2.2.1 and 975-2.2.2. All coatings, regardless of color, shall meet the requirements in Table 975-1.

975-2.2.1 Random Laboratory Verification Testing: Prepare and coat twelve flat test panels for random laboratory verification testing.

975-2.2.2 Outdoor Exposure Testing: Prepare and coat eight test panels (four flat and four composite) for exposure at the Department's outdoor test site. Panels will be tested in accordance with ASTM G7.

Table 975-1 Structural Steel Coating System Performance Requirements		
Laboratory Testing		
Property	Test Method	Acceptance Criteria
Slip Coefficient	AASHTO R 31 Test No. 1	Min. Class B (primer only)
Salt Fog Resistance	AASHTO R 31 Test No. 2 ASTM D610	Blister Value = 10 Average Rust Creep at the Scribe $\leq 3/32''$ Rust grade $\geq 9S, 9G, 9P$ after 8,760 hours
Salt Fog Resistance Unscribed		Blister Value = 10 Rust grade $\geq 9S, 9G, 9P$ after 8,760 hours
Cyclic Weathering Resistance	AASHTO R 31 Test No. 3	Blister Value = 10 Average Rust Creep at the Scribe $\leq 6/32''$, Color Retention $\Delta E^*_{ab} \leq 8.0$, Gloss loss $\leq 33\%$ after 15 cycles – 336 hours each cycle
Abrasion Resistance	AASHTO R 31 Test No. 4	Wear Index ≤ 2.7 mg/cycle
Adhesion	ASTM D4060 1,000 Cycles, CS-17 Wheel, 1 kg. Weight	Avg. system tensile strength ≥ 800 psi
2-Year Outdoor Testing		
Property	Test Method	Acceptance Criteria
Rusting	ASTM D610 ASTM D1654 a (scribed) ASTM D1654 (un- scribed)	Rust Grade $\geq 9S, 9G, 9P$ Rating of Failure at Scribe ≥ 9 After 2-Years
Blistering	ASTM D714	Blister Value = 10 After 2-Years

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Table 975-1 Structural Steel Coating System Performance Requirements		
Laboratory Testing		
Property	Test Method	Acceptance Criteria
Adhesion	ASTM D4541; annex A4	Avg. Tensile Strength \geq 800 psi (un-scribed area) After 2-Years
Color Retention	ASTM D2244	Avg. $\Delta E^*_{ab} \leq$ 8.0 After 2-Years
Gloss	ASTM D523	Avg. \leq 33% loss of gloss After 2-Years

975-2.3 Structural Steel Coating Systems for New Structures: Systems must meet the general composition requirements of Table 975-2 and this section.

Table 975-2 Structural Steel Coating System General Composition Requirements			
Primer	Intermediate	Finish	Clear (Optional)
Inorganic Zinc-Rich Ethyl Silicate	None	Inorganic Ethyl Silicate	Manufacturers Recommendation
Inorganic Zinc-Rich Ethyl Silicate	Cycloaliphatic Amine Epoxy Or Polyamide Epoxy	Polyurethane	
		Polysiloxane	
		Acrylic	
Inorganic Zinc-Rich Ethyl Silicate	Polyurethane (Epoxy Stripe)	Fluoropolymer	

975-2.3.1 High Performance Coating Systems (Color Pigmented):

975-2.3.1.1 Prime Coat: Provide inorganic zinc-rich primers consisting of zinc dust, functional additives, and an inorganic binder, with appropriate solvents. The composition of the primer shall consist of an inorganic self-curing vehicle, that contains solvent-reducible silicates, titanates, and polymeric versions of the silicates. Zinc dust pigment shall contain a minimum of 77% zinc dust by weight and a maximum lead level of 0.01% in accordance with ASTM D520. The manufacturer shall identify the amount of zinc dust on the product label. The performance requirements for gloss and color retention are not applicable.

975-2.3.1.2 Intermediate Coat: Intermediate coatings must meet Table 975-2. Epoxies must be a cycloaliphatic amine or polyamide.

975-2.3.1.3 Finish Coat: The finish coat shall provide the color and gloss required for the completed coating system. A finish coat may be comprised of a single pigmented coat or a pigmented coat with a clear coat that meets Table 975-2.

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975-2.3.1.4 Clear Coat: The clear coat may contain a dissipating colorant. The dissipating colorant shall be visible for a minimum of 12 hours after application and shall completely dissipate within 96 hours after application.

975-2.3.2 Interior Box Girder Coating: The interior coat shall be one coat of white epoxy paint meeting 975-2.3.1.2 and listed on the Department’s APL. Faying surfaces and areas to be stud welded are to be masked off and coated with a zinc-rich primer from the APL. The performance requirements for gloss and color retention are not applicable.

975-2.4 Structural Steel Coating Systems for Existing Structures: Systems must meet the general composition requirements of Table 975-3 and this section.

Table 975-3 Structural Steel Coating System General Composition Requirements			
Primer	Intermediate	Finish	Clear (Optional)
Organic Zinc-Rich Epoxy Or Inorganic Zinc-Rich Ethyl Silicate	None	Inorganic Ethyl Silicate	Manufacturers Recommendation
Organic Zinc-Rich Epoxy Or Inorganic Zinc-Rich Ethyl Silicate	Cycloaliphatic Amine Epoxy Or Polyamide Epoxy	Polyurethane	
		Polysiloxane	
		Acrylic	
		Fluoropolymer	

975-2.4.1 Prime Coat: Provide inorganic or organic zinc-rich primers consisting of zinc dust, functional additives, and an organic binder with appropriate solvents. The composition of the primer shall consist of an organic vehicle that may chemically cure or may dry by solvent evaporation. Zinc dust pigment shall contain a minimum of 77% zinc dust by weight and a maximum lead level of 0.01% accordance with ASTM D520.

Organic zinc-rich primers shall be used as galvanizing repair compounds for areas greater than 100 square inches.

975-2.4.2 Intermediate Coat: Intermediate coatings must meet Table 975-3 E. Epoxies must be a cycloaliphatic amine or polyamide.

975-2.4.3 Finish Coat: Finish coating shall provide the color and gloss required for the completed coating system. A finish coat may be comprised of a single pigmented coating or a pigmented coating with a clear coat.

975-2.4.4. Clear Coat: The clear coat may contain a dissipating colorant. The dissipating colorant shall be visible for a minimum of 12 hours after application and shall completely dissipate within 96 hours after application.

975-3 Galvanized Steel Coating System.

Coatings applied over galvanized steel shall meet the requirements of Table 975-2 with the exception that test panels shall be galvanized in accordance with ASTM A123 prior to application of subsequent coatings.

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Coatings applied over galvanized steel strain poles, mast arms, and monotube assemblies shall meet the requirements of Section 649 and 975-4.

975-4 Paint for Galvanized Steel Strain Poles, Mast Arms, Monotube Assemblies, Conventional Light Pole Assemblies, and Aluminum Poles, Pedestals, and Posts.

Paint systems shall meet the color requirements as specified in the Contract Documents. All paint systems shall possess physical properties and handling characteristics that are compatible with the application requirements of Section 649 for galvanized steel and Section 646 and 715 for aluminum. Materials shall be specifically intended for use over galvanized steel or aluminum, as appropriate. Paint systems shall exhibit no loss of adhesion or total color difference (ΔE^*_{ab}) greater than 8.0 units for five years after final acceptance as specified in 5-11. Cumulative surface area of delamination in excess of 100 square inches will constitute an adhesion failure. Delamination shall be defined as any area of exposed metal surface subsequent to hand tool cleaning in accordance with SSPC-SP2. A ΔE^*_{ab} value exceeding 8.0 units per the International Commission on Illumination $L^*a^*b^*$ 1976 (CIELAB) space and color difference formula, measured in accordance with ASTM D2244, will constitute a color retention failure.

The Department will measure and enter in the Department's database the CIELAB color chromaticity coordinates for the color of the top coat of sample coupons provided as required by 649-4.3 using a BYK-Gardner Handicolor colorimeter using D65 illuminant and 2-degree geometry settings. The Department-measured CIELAB chromaticity coordinates shall define the initial color and will be used for resolution of color retention failures and the resolution of color retention disputes.

975-5 Elastomeric Coatings.

975-5.1 General: Use an elastomeric coating system to provide a waterproof barrier over post-tensioning anchorages or other areas designated in the Plans. The components of the coating system shall be supplied by a single manufacturer and sold as a waterproof coating system. The surface preparation and application of the coating system shall be performed in strict accordance with the manufacturer's specifications. Upon request, submit a one quart wet sample of each component of each coating system to the SMO.

975-5.2 Physical Properties: The use of an epoxy prime coat is dependent upon the requirements of the manufacturer's waterproofing system. The polyurethane chemistry may be either waterborne aromatic (moisture-curing) or aromatic (moisture-sensitive). The elastomeric coating shall meet the requirements in Table 975-4.

Property	Test Method	Acceptance Criteria
Hardness, Shore A	ASTM D2240	Between 60 and 90
Tensile Strength	ASTM D412	≥ 750 psi
Elongation	ASTM D412	$\geq 400\%$
Tear Strength	ASTM C957	> 70 psi

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Table 975-4 Elastomeric Coatings Performance Requirements		
Property	Test Method	Acceptance Criteria
Abrasion Resistance H-18 wheels 1,000 gm/wheel	ASTM C957	≤350 mg loss / 1,000 revs.
Crack Bridging 1,000 Cycles	ASTM C957	System Passes
Elongation Recovery	ASTM C957	≥94%

975-5.3 System Modifications for Use on Exposed External Anchorages: Provide the elastomeric coating system with a 100% acrylic aliphatic polyurethane top coating where required as shown on Standard Plans Index 462-002, or when applied to other exposed external surfaces. Manufacturers of the elastomeric coating system shall include the acrylic top coating as part of the elastomeric coating system for approval.

975-6 Class 5 Applied Finish Coatings.

975-6.1 General: All coatings shall possess physical properties and handling characteristics compatible with the application requirements of Section 400. Unless otherwise specified, the color of the finish coat shall meet FED-STD-595, Table VIII, Shade No. 36622, or No. 36642 for uncoated weathering steel bridges.

975-6.2 Coating Requirements: Prepare four, 4 inch by 8 inch (except as required below) fiber cement test panels with a mass of 7 to 9 pounds per square foot of surface area to perform the laboratory tests. Apply the finish coating to each test panel at a rate of 50 square feet per gallon, plus or minus 10 square feet per gallon. Seal the corners of all test panels with a high build epoxy or equivalent to prevent moisture ingress at corners and cut edges. Submit the samples to an independent laboratory for testing. Coating performance shall meet the requirements in Table 975-5. Upon request, submit a one quart wet sample of each component of each coating system to the SMO.



Table 975-5 Class 5 Applied Finish Coatings Performance Requirements		
Laboratory Testing		
Property	Test Method	Acceptance Criteria
Resistance to Wind Driven Rain	ASTM D6904	No visible water leaks, and if the rear face of the block is damp, the average gain in weight of the three 8"x16"x2" blocks must be less than 0.2 lb.
Freeze thaw resistance	AASHTO R 31	No disbondment
Water Vapor Transmission	ASTM D1653; Method B, Condition C	WVT ≥ 10 perms
Abrasion Resistance	ASTM D968, 3,000 liters of sand	No loss of coating thickness ASTM D6132
Salt Spray (fog) resistance	ASTM B117, 2,000 hours	No disbondment



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Table 975-5 Class 5 Applied Finish Coatings Performance Requirements		
Laboratory Testing		
Property	Test Method	Acceptance Criteria
Fluorescent UV-Condensation Exposure	ASTM D4587, 2000 hours, 4 hours UV, 4 hours condensation	No blistering (ASTM D714), cracking (visual), or delamination (visual). chalking (ASTM D4214 Method D) rating no less than 8.
Fungal Resistance	ASTM D3273	Rating of 10, ASTM D3274

975-7 Anti-Graffiti Coating Materials.

975-7.1 General Requirements: Anti-graffiti coatings intended for use under this specification shall be of a composition capable of preventing the adhesion of and facilitating the removal of acrylic, polyurethane, and alkyd spray paint. All anti-graffiti coatings shall possess the physical and handling characteristics that are compatible with the requirements of Section 563. The manufacturer shall designate non-sacrificial products as water cleanable in accordance with this Section.

Anti-graffiti coatings shall contain less than 5.0 pounds per gallon volatile organic compounds (VOC) as defined by 40 CFR Part 59, Subpart D, evaluated as per ASTM D3960.

The manufacturer shall supply the following additional information:

1. Technical data sheet that includes installation instructions and graffiti removal instructions by pressure washing with water.
2. Sacrificial Coating Removal instructions, as applicable.
3. Certification that non-sacrificial anti-graffiti coating shall not blister, crack, check, chalk, delaminate, or exhibit a color change of more than 8 dE94 (or dE76) CIE LAB units for a period of one year after installation.

975-7.2 Performance Requirements: For laboratory testing, use flat test panels prepared in accordance with AASHTO R 31.

Outdoor exposure testing will be performed by the Department, if applicable. Submit four, 4 inch by 8 inch fiber cement test panels to the SMO. Panels will be exposed at the Department's outdoor test site in accordance with ASTM G7. Coating performance shall meet the requirements in Table 975-6.

Upon request, submit a one quart wet sample of each component of each coating system to the SMO.

Table 975-6 Anti-Graffiti Coatings Performance Requirements		
Outdoor Exposure Testing – Non-Sacrificial		
Property	Test Method	Acceptance Criteria

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Table 975-6 Anti-Graffiti Coatings Performance Requirements		
Graffiti Resistance (water cleanable)	FM 5-580: 6 months exposure at FDOT test site (2500 psi using pressure washer)	Complete removal of solvent based acrylic, and alkyd based spray paint. No delamination or visual defects.

Laboratory Testing - Sacrificial		
Property	Test Method	Acceptance Criteria
Cyclic Weather Testing	AASHTO R 31: no salt fog, 95°F, 0%- 90% Relative Humidity, 500 hours, alternating RH every 100 hours	No melting or disbondment

Outdoor Exposure Testing - Sacrificial		
Property	Test Method	Acceptance Criteria
Sacrificial Coating removability	FM 5-580: 6 months exposure at FDOT test site (2500 psi using pressure washer)	Complete removal of solvent based acrylic, and alkyd based spray paint from substrate