

**ITEM 573.1015nn02 M - FIELD CLEANING AND PAINTING - TOTAL REMOVAL TO SP-10
(SPRAY PROHIBITED)**

DESCRIPTION

This work shall consist of pressure washing, abrasive blast cleaning to remove all paint, rust, millscale, and other corrosion producing contaminants, and painting structural steel surfaces with three (3) full coats of new paint, where indicated by the Contract Documents.

MATERIALS

1. **Paint and Thinner.** Paint and thinner shall be selected from the Department's Approved List, "Moisture-Curing Urethane Paint Systems". No substitutions will be allowed.

The shelf life of all paint shall be a maximum of 12 months from the date of manufacture. All acceptances of paint shall expire within 12 months from the date of manufacture.

All paint (primer, intermediate, and finish coats) used on any one structure shall be produced by the same manufacturer.

Each single coat of paint shall be a color different from the others. The color of the primer and the intermediate paints shall be at the Contractor's option, and shall provide contrast with the underlying substrate. The color of the finish paint shall be as specified in the Contract Documents, or as ordered by the Engineer.

2. **Water for Washing.** Water for pressure washing shall be clean, fresh water. A soluble salt remover such as Chlor-Wash, Hold Tight 102, or approved equal will be used in the wash water and mixed at a ratio recommended by the manufacturer. The salt remover must be approved by the paint manufacturer for use with their product. Salt water will not be allowed.
3. **Abrasive for Blast Cleaning.** Abrasive material for blast cleaning may be selected by the contractor. All abrasive shall be free of lead and corrosion producing contaminants. The abrasive selected for use shall be designed to leave a profile of approximately 40 µm to 65 µm in a dense, uniform pattern of depressions and ridges. Silica sand and other types of non-metallic abrasive containing more than 1.0% crystalline (free) silica, by weight, will not be allowed.
4. **Basis of Acceptance.** All primer, intermediate, and finish paint, and thinner material, shall be accepted on the basis of the manufacturer's name, and the product name, appearing on the Department's Approved List.

Water for washing and abrasive material for blast cleaning shall be approved by the Engineer.

Only paint and thinner arriving at the work site in new, unopened containers shall be used.

Containers of paint shall be labeled with the manufacturer's name, product name, batch number, and date of manufacture. Paint that has not been used within 12 months from the date of manufacture shall be removed from the work site.

**ITEM 573.1015nn02 M - FIELD CLEANING AND PAINTING - TOTAL REMOVAL TO SP-10
(SPRAY PROHIBITED)**

CONSTRUCTION DETAILS

All structural steel members, railings, downspouts, and other miscellaneous steel items as indicated by the Contract Documents shall be cleaned of all paint, rust, millscale, and corrosion producing products, stripe coated and painted with three (3) full coats of new paint, the primer coat, the intermediate coat, and the finish coat.

1. **Surface Preparation.** Steel surfaces shall be prepared for painting by a combination of pressure washing and abrasive blast cleaning. If the paint to be applied has more stringent or additional surface preparation requirements than this specification, the Contractor shall prepare the surface in accordance with the paint manufacturers recommendations.

Pressure washing to remove dirt and debris shall be performed first. Abrasive blast cleaning to remove all paint, rust, and millscale shall be performed second.

- a. **Pressure Washing.** All steel surfaces to be painted shall first be pressure washed, using equipment operating at a minimum pressure of 21.5 MPa, and with a minimum flow of 9.5 L/minute. The pressure washer shall be operated at a distance of 150 mm to 300 mm from the steel surface. Water may be heated. After washing, the surface shall be allowed to dry before subsequent abrasive blast cleaning work is done.

Pressure washing shall be performed to remove dirt, dust, animal waste, and water soluble contaminants. Clean, fresh water shall be used with sufficient pressure to remove surface contaminants and loose material. Hand scraping and hand scrubbing with a stiff bristled brush will be required as necessary to remove debris. When the washing is completed, the cleaned surfaces will be free of dust, dirt, oil and grease, animal waste, salts, and other debris. When necessary, oil and grease will be removed by hand-wiping using solvents as described in SSPC SP 1. The areas will be pressure washed again following this cleaning.

After pressure washing, the cleaned surfaces shall be visually free of dust, dirt, oil and grease, animal waste, salts, and other debris.

Pressure washing will only be allowed when ambient air temperatures are greater than 4.5°C and rising. In no case shall pressure washing be performed when in the opinion of the Engineer spent wastewater will freeze on roadway or bridge surfaces, or in any other way create a hazardous situation.

During washing operations, a containment shall be suspended around and beneath the work area to contain all paint chips, corrosion residue, and other solid particles that become dislodged by pressure washing (see *Note*¹). All such solid residue shall be

¹*Note: The containment for pressure washing is intended to capture solid paint chips and other solid debris that may become dislodged from washing operations. The containment may be constructed of water permeable or water impermeable materials. Spent washwater will not require collection and will be allowed to fall to the underlying road, ground, or waterway, providing the other requirements of this specification are met. The exception for the collection of spent washwater will be for structures over a public water supply. When a bridge crosses a public water supply the spent washwater must be diverted, or collected, and disposed of on the adjoining land mass, at a location away from the waters edge.*

ITEM 573.1015nn02 M - FIELD CLEANING AND PAINTING - TOTAL REMOVAL TO SP-10 (SPRAY PROHIBITED)

contained, collected, and allowed to air dry for treatment and disposal as hazardous paint removal waste under Item 571.01 M, as directed by the Engineer. The containment provided shall also prevent all spray and residue from falling on or interfering with traffic, pedestrians, or surrounding property, above or below the structure. Extreme care shall be exercised to ensure that vehicles, pedestrians, and property are not exposed to the cleaning process. All structures over water courses shall be washed during the seasonal periods indicated in the Contract Documents. If no schedule is provided, washing shall occur only when adequate flow in the stream exists to dilute possible contaminants. Operations shall be sequenced so as to clean structures over small bodies of water or small streams in the spring of the year, or in a period when flows are greatest. Streams categorized by the Department of Environmental Conservation (DEC) as "CT(s)", i.e. trout spawning, shall be washed prior to July 1 and bridges located at DEC yearling trout stocking sites shall not be washed during April. When washing operations are performed on bridges over a public water supply, e.g., reservoir, or on bridges in the watershed area of New York City water supply, the spent washwater shall be diverted, or collected, and disposed of on the adjoining land mass, at a location away from the waters edge.

To minimize contamination of the washed surfaces, subsequent cleaning, priming and painting work shall be performed within 7 calendar days of the completion of washing work. If more than 7 days pass by or if the steel surfaces become dirty, they shall be re-washed in accordance with this specification, at no additional cost.

b. **Blast Cleaning to Near White Metal**

All surfaces shall have all paint, rust and rust scale, mill scale, and other corrosion producing contaminants removed by abrasive blast cleaning in accordance with SSPC-SP No. 10/NACE No. 2, Near-White Blast Cleaning.

The blasted surface profile will be measured in accordance with ASTM D4417, Method C. The Contractor is responsible for ensuring that the blasted steel profile meets the requirements of the paint manufacturer's data sheets.

The surface of the area blast cleaned in any one day shall be no greater than the surface area of steel that can be prime coated in the same working day.

All cleaned surfaces will be inspected by the Engineer prior to painting. Any areas that are painted before being inspected shall be cleaned and restored to the SP-10 standard and repainted at no additional cost. If the cleaned surface begins to rust or becomes contaminated in any matter prior to applying primer, the surface will be restored to SP-10 standard.

All equipment and compressors used in the cleaning operation shall be equipped with all necessary filters and traps to prevent moisture, oil, and other contaminants from being

ITEM 573.1015nn02 M - FIELD CLEANING AND PAINTING - TOTAL REMOVAL TO SP-10 (SPRAY PROHIBITED)

deposited on clean surfaces.

If recyclable abrasive are used they shall be cleaned of all paint, chips, rust, millscale and other foreign material after each use, and prior to reuse. All equipment used for cleaning abrasive shall be specifically designed for this purpose, and approved by the Engineer.

Special attention shall be given to the edges of beam flanges, angles and plates, bearings, rivets, the heads of nuts and bolts, and similar surfaces that are marginally accessible and difficult to clean. These surfaces are often difficult to access, and are labor intensive and hard to clean. To remove heavy deposits of rust and scale, hand pounding using a hammer, or power tool cleaning using a needle gun or de-scaler may be necessary before abrasive blast cleaning work begins.

All fin, tears, slivers, burred and sharp edges that are present or occur during the blasting operation shall be removed by grinding, and then the area shall be reblasted to provide the required 40 μ m to 65 μ m deep anchor profile.

Throughout abrasive blast cleaning work, care shall be taken to protect newly painted surfaces from the cleaning operations. Tarps, covers, or other devices approved by the Engineer shall be used to protect new paint from damage. Damaged paint shall be thoroughly wire brushed or if visible damage occurs, reblasted to the required condition, and then repainted. All repair to damaged paint surfaces shall be approved by the Engineer.

After cleaning operations are completed, all residue generated by the cleaning work shall be removed by vacuuming using HEPA filtered vacuums. A HEPA filter shall be defined as a filter that is at least 99.97% efficient for particles that are 0.3 μ m in diameter, or larger.

Corroded and deteriorated surfaces that have been cleaned to bare metal by abrasive blasting shall be accepted by visual comparison to a project prepared standard(s) for each structure. The contractor shall prepare a project standard by abrasive blast cleaning a representative area on the structure that is being prepared for painting. The prepared standard shall generally conform to SSPC VIS 02-12, "Guide and Reference Photographs for Steel Surfaces Prepared by Dry Abrasive Blast Cleaning", Condition Photographs A SP 10, B SP 10, C SP 10, D SP 10, G₁ SP 10, G₂ SP 10, G₃ SP 10, as applicable based on initial condition, and shall be approved by the Engineer before the start of general cleaning work. At least one standard shall be prepared for each structure that is being specified for cleaning. More than one standard may be necessary if the cleaned steel differs significantly from the photographic standards due to surface conditions or other factors. Each standard shall be at least 300 mm x 300 mm in size, and shall be located in an area of the structure that is accessible to, and approved by the Engineer. The contractor shall protect the work standard from corrosion and contamination throughout the duration of

ITEM 573.1015nn02 M - FIELD CLEANING AND PAINTING - TOTAL REMOVAL TO SP-10 (SPRAY PROHIBITED)

work by applying a clear coat of polyurethane. At the completion of cleaning work the project standard shall be re-cleaned and painted in accordance with this specification. If in the opinion of the Engineer the project standard becomes deteriorated, or otherwise ineffective, it shall be re-established in accordance with this specification at no additional cost.

2. **Painting.** Painting shall consist of applying three full coats of new paint and a stripe coat to all surfaces cleaned to bare metal. The first full coat shall be primer, followed by the application of a full coat of intermediate paint, and a full coat of finish paint, to all steel surfaces designated to be painted.

a. **Material Storage.** Paint in storage shall be protected from damage and maintained between 4.5°C and 29.5°C.

b. **Specifications and Inspection Equipment.** Prior to the start of and throughout the duration of work the contractor shall supply the Engineer with the following specifications and equipment. *No work shall begin until these materials have been delivered to, and accepted by the Engineer.*

1. One bound copy of the Steel Structures Painting Council surface preparation specification, SSPC-SP 10/NACE No. 2 - Near-White Blast Cleaning.
2. One bound each of the Steel Structures Painting Council pictorial standards, SSPC-VIS 02-12, Guide and Reference Photographs for Steel Surfaces Prepared by Dry Abrasive Blast Cleaning
3. One bound copy of the Steel Structures Painting Council method SSPC-PA2, Paint Application Specification No. 2 - Measurement of Dry Film Thickness With Magnetic Gages.
4. One Air Thermometer, pocket type, -10°C to +40°C.
5. One Surface Thermometer, -10°C to +40°C.
6. One Magnetic Dry Film Thickness Gage, Type 2 (fixed probe), with a digital readout display capable of measuring 1 µm to 1500 µm in 1 µm increments.
7. Two Wet Film Thickness Gages, Prong Type, capable of measuring 25 µm to 125 µm in 25 µm increments.
8. One copy of ASTM D 4417-93 (1999) Test Methods for Field Measurement of

**ITEM 573.1015nn02 M - FIELD CLEANING AND PAINTING - TOTAL REMOVAL TO SP-10
(SPRAY PROHIBITED)**

Surface Profile of Blast Cleaned Steel

9. Profile micrometer with extra course tape.

- c. Atmospheric Conditions. No paint shall be applied when the receiving surface and ambient temperatures are less than 1.5°C or greater than 38°C. No paint shall be applied unless the receiving surface is absolutely dry. Paint shall not be applied when the relative humidity is more than 95% unless the coating manufacturers requirements are more stringent. No paint will be applied during rain regardless if painting occurs within a containment.

In general, no paint shall be applied in the months of December, January, February, or March. If the contractor requests approval to apply paint in winter months, and if in the Engineer's opinion satisfactory results can be achieved, then the substrate shall be enclosed, painted under cover, and protected from the surrounding air. The interior of the enclosure shall be heated and the steel painted when the surface temperature is 10°C or greater. Direct application of heat to the steel surface will not be allowed. The painted steel shall remain enclosed and heated for a minimum of eight hours, or until the applied coating is dry, whichever is longer. No additional payment will be made for the cost of enclosing, heating and protecting paint that has been applied in conditions of cool weather.

When painting inside an enclosure adequate mechanical ventilation shall be supplied to meet OSHA regulations for worker exposure to solvents, fumes, lead and other provisions. When mechanical ventilation is provided, filtration of the exit air will not be required. No additional payment will be made for the cost of ventilation.

- d. Mixing Paint. All paint shall be thoroughly mixed with mechanical mixers in accordance with the manufacturer's recommendations. After mixing the bottom of the container shall have no unmixed pigment.
- e. Solvents and Thinners. Paint may be thinned only if recommended by the manufacturer and only if approved by the Engineer. Only approved thinner shall be used. Use of unauthorized solvents and thinners, or using excess amounts of solvents and thinners is prohibited. Any area where unauthorized solvents or thinners are used will result in the Contractor restoring the surface to SP-10 at no expense to the State.

Thinning shall be performed by pouring one-half of the thoroughly mixed paint into a empty, clean container. The required thinner is then added to one of the half-size portions, and the two portions are remixed to obtain a homogenous mixture.

The paints specified for this work have a limited pot life because of their reaction with the moisture in the atmosphere. The paint will gel when it nears the end of its pot life.

**ITEM 573.1015nn02 M - FIELD CLEANING AND PAINTING - TOTAL REMOVAL TO SP-10
(SPRAY PROHIBITED)**

Thinning to reduce the viscosity of gelled paint will not be allowed. The pot life of this paint can be extended by covering open containers to reduce exposure to moisture, and by keeping containers of paint cool.

- f. Paint Application. No painting shall begin until cleaned surfaces have been inspected and approved by the Engineer. The contractor shall provide safe, stable, and direct access to the work area for the Engineer's inspection.

Paint may be applied using brush, roller or spray methods, unless spray painting is prohibited by the Contract Documents. When spray painting is prohibited, paint shall be applied using brushes or rollers only. All paint shall be applied so as to produce a uniform, even coating free of runs, sags, drips, ridges or other defects.

To ensure adequate paint film thickness, stripe painting using primer shall be required on the following surfaces: all welds, rivets, bolts, nuts, and edges of plates, angles, bearings, lattice pieces or other shapes, and corners and crevices. To provide contrast, paint for stripe coating shall be a color that is different than the color of the receiving surface. The stripe coat may be applied before or after the first full coat of primer is applied. Such striping shall extend a minimum of 25 mm from the edge. To prevent removal of the stripe paint by the following coat of paint, the stripe coat shall be allowed to set-to-touch before the next paint coat is applied. However, on bare metal surfaces the stripe coat shall not be permitted to dry for a period long enough to allow rusting of the unprimed steel.

Complete protection against paint spatter, spillage, overspray, wind blown paint, or similar releases of paint shall be provided. Covers, tarps, mesh, and similar materials shall be placed around the work area to protect public and private property, pedestrian, vehicular, marine or other traffic, all portions of the bridge, highway appurtenances, waterways, and similar surrounding areas and property, upon, beneath, or adjacent to the structure.

- g. Paint Film Thickness. Paint shall be applied in such a quantity so as to produce the minimum specified dry film thickness for the type of paint material being used (see Approved List - Moisture-Curing Urethane Paint Systems).

The dry film thickness shall be determined in accordance with SSPC-PA 2, Paint Application Specification No. 2 - Measurement of Dry Film Thickness with Magnetic Gages, using a Type 2 fixed probe magnetic gages, equipped with a digital readout display.

Areas failing to meet the specified minimum dry film thickness shall be overcoated with the same type of paint to produce at least the total dry film thickness required.

If the recommended profile is exceeded, the contractor must either re-blast to the required profile or apply additional paint at no additional cost to the State. The amount of additional

ITEM 573.1015nn02 M - FIELD CLEANING AND PAINTING - TOTAL REMOVAL TO SP-10 (SPRAY PROHIBITED)

paint thickness required will be determined by the profile specified on the manufacturers data sheets subtracted from the profile depth achieved by blasting. The additional paint will be applied as an additional intermediate coat(s). Under no circumstances will the contractor be allowed to apply the primer, intermediate, or finish coat thicker than specified to substitute for the additional paint required.

- h. **Painting Schedule.** Primer shall be applied to bare metal surfaces within twelve hours of the cleaning operation and before visible rust appears on the cleaned surface. Failure to apply primer to a bare metal surface within twelve hours or before the appearance of visible rust shall result in recleaning the surface in accordance with this specification, at no additional cost.

All coats of paint shall be overcoated with the subsequent coat in accordance with the time period specified for the paint material that is being used (see Approved List - Moisture-Curing Urethane Paint Systems). To prevent intercoat adhesion failure, recoating with the next coat of primer, intermediate, and finish paint, must be performed within the maximum specified time period, or 14 days, whichever is shorter. If the contractor fails to recoat within the specified time period the surface to be painted shall be recleaned by abrasive blast cleaning to bare metal, and repainted in accordance with this specification, at the contractors expense.

METHOD OF MEASUREMENT

Payment shall be made by the lump sum price bid.

BASIS OF PAYMENT

The lump sum price bid shall include the cost of all labor, materials and equipment necessary to complete the work. The cost of providing protection against damage during pressure washing and paint application shall be included in the bid price. Payment for the containment and disposal of dust and paint waste generated by surface preparation work will be paid for under other items, however, payment for the accumulation of paint removal waste for deposition in the paint removal containers shall be included in this item. Progress payments will be made based on the percentage of the structure cleaned and primed and painted with two full coats of paint in accordance with this specification.

Payment will be made under:

ITEM 573.1015nn02 M - FIELD CLEANING AND PAINTING - TOTAL REMOVAL TO SP-10
(SPRAY PROHIBITED)

Item No.	Item	Pay Unit
573.1015nn02 M	<u>FIELD CLEANING AND PAINTING - TOTAL REMOVAL TO SP-10 (SPRAY PROHIBITED)</u>	Lump Sum (for each structure)

Note: nn denotes serialized pay item. See §101-53

DISAPPROVED BY
EI 05-038