

**Test description**

Test start: 22.01.2024 6am  
Test end: 26.09.2024 6am

Frames, painted with the L2 powder paint, were prepared for tests in a salt spray chamber. Frames were placed in the salt chamber on a plastic gutter. Tests were carried out in the Ascott S450ip salt spray chamber, which is intended, among others, for salt tests, for compliance with the standard PN-EN ISO 9227 "Corrosion testing in artificial atmospheres".

**Description of the sample**

Product code: Powder coated frames  
Quantity: 2 pcs  
Material: powder coated steel

**Test conditions**

|                                  |  |
|----------------------------------|--|
| According to norm                | <b>PN-EN ISO 9227</b> „Corrosion tests in artificial atmospheres — Salt spray tests” |
| Exposure time                    | Neutral salt spray test NSS<br>96h   |
| pH of a 5% solution of NaCl      | 6.5-7.2  |
| Chamber operating temperature    | 35°C   |
| Humidifier operating temperature | 45°C   |
| Compressed air pressure          | 98 kPa ± 10 kPa  |
| Salt spray fall rate             | 1 – 2 ml/80 cm <sup>2</sup> ·h   |
| Salt spray method                | continuous   |

|   |                      |                     |
|---|----------------------|---------------------|
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**Evaluation of samples during / after completion of the tests**

Samples were assessed for compliance with the PN-EN ISO 10289: 2002 standard

Visual assessment from a distance of 0.5m ( $\pm 0.1$ m) with a naked eye in uniform, diffused light.

**Customer requirements**

Not specified

**Description of samples after 96 hours of exposure in the salt chamber**

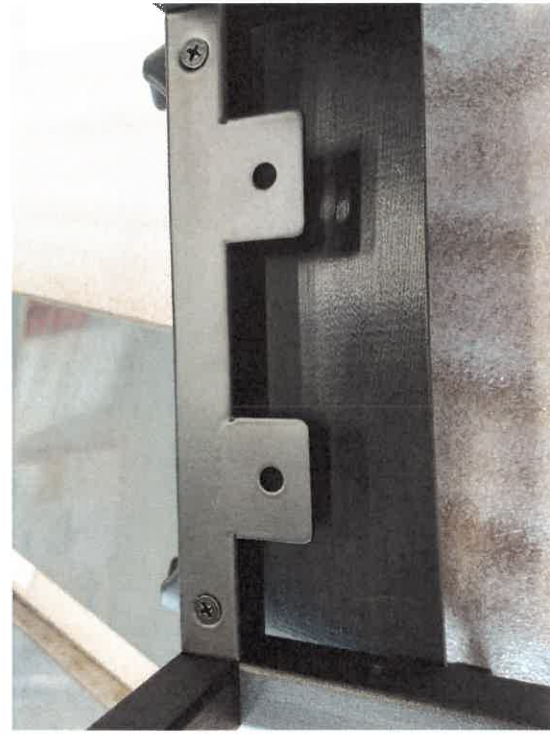
| Sample no | Product              | Quantity | Description after 96 hour test  |
|-----------|----------------------|----------|---|
| 1         | Frame in L2 coating  | 1 pc     | After the test, all surfaces of the angle were assessed visually. There were slight traces of red corrosion in the mounting holes.  |
| 2         | Frame in L36 coating | 1 pc     | The element has been visually assessed after:<br>- 96 h - no visible changes on external surfaces; traces, leakage of internal corrosion visible at welds, mounting holes and in places of connection |

**Photo documentation**

Frames before test:  
**L2 coating**



**L36 coating**





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After 96 hours in the salt spray chamber:

L2 coating



L36 coating





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### Test results

After completion of tests, the sample was lined.  
After 1 hour of waiting, they were cleaned in running water from the remnants of the sprayed solution.  
Dried sample was subjected to visual evaluation acc. to norm ISO 10289.

| No. | Sample no    | Description   | Test result           |
|-----|--------------|---|-----------------------|
| 1.  | Frame in L2  | Slight rusting at holes, welds, in places of connection between 0,25 and 0,5 %, 7/7 s | For customer approval |
| 2.  | Frame in L36 | Slight rusting at holes, welds, in places of connection between 0,25 and 0,5 %, 7/7 s | For customer approval |

**The report is valid for all frames produced using the same material and coatings.**

The test was performed in an internal, non-accredited lab.

Report was prepared by:

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