

Construction use of color-coated thin sheet steel products

SELECTION RECOMMENDATIONS



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Recommendations for selection of color-coated thin sheet steel products in construction

This guide has been prepared to assist in the selection of Ruukki products for various applications. Color-coated thin sheet steel offers an excellent option for building roofs, facades, rainwater systems, and flashings due to its durability, appearance, and cost-effectiveness. Proper material selection ensures the required durability in the intended use conditions.

When selecting color coatings for construction products and applications, it is essential to consider the designed service life of the building, environmental conditions, and other possible specific requirements. Based on these factors, Ruukki offers suitable color coatings and steel grades for each project to achieve optimal durability, maintainability, and the desired appearance.

TOWARDS CARBON-NEUTRAL CONSTRUCTION

Color-coated steel is an ecologically excellent choice. Most GreenCoat® products have a coating where rapeseed oil and other renewable raw materials are used. SSAB has long experience of Bio-based Technology (BT) in GreenCoat® products. This patented solution reduces the ecological footprint of GreenCoat® products. GreenCoat® contains no hexavalent chromium and is a leader in sustainable building solutions, thanks to its color coating, full recyclability, compliance with REACH regulations, and numerous environmental certifications.

SSAB's production facilities in Finland and elsewhere are globally recognized as one of the most advanced in steel manufacturing. Production is among the cleanest and most efficient in terms of carbon dioxide emissions, and continuous efforts are directed towards fully carbon-free steel production. Zero™ steel based on recycled steel is also available for construction products. Fossil-free hydrogen-reduced steel will be available on the

market in 2026, and around 2030, most of SSAB's production will be fossil-free.

Color-coated thin sheet steel products also require maintenance. When properly maintained, they can reach a service life of at least 60 years. Steel is easy to recycle and reuse, and its production generates fewer carbon dioxide emissions than the manufacturing of other common building materials. Steel is one of the few materials that can be fully recycled in a closed loop. This means that steel can be efficiently reused over and over again without losing its properties or performance and without generating hazardous waste.

SERVICE LIFE OF BUILDING

Color coating is expected to retain its technical properties and appearance for a long time. Coating should retain its performance specifications throughout the building's service life and require minimal maintenance costs. The indicative designed service lives for various types of buildings are defined in the standard EN 1990 (Table 1).

Designed service life = The assumed period for which a structure or part of it is to be used for its intended purpose with anticipated maintenance but without major repair being necessary.

Table 1. Indicative designed service life for different types of buildings (EN 1990).

Designed service life category	Indicative designed service life (years)	Examples
1	10	Temporary structures ¹⁾
2	10...25	Replaceable structural parts
3	15...30	Agricultural and similar structures
4	50	Building structures and other common structures
5	100	Monumental building structures, bridges, and other civil engineering structures

¹⁾ Structures or parts of structures that can be dismantled with a view to being re-used should not be considered as temporary.

ENVIRONMENTAL CONDITIONS

Environmental conditions affect significantly the selection of color-coated steel. Color coating is exposed to ultraviolet (UV) radiation from sunlight, which will gradually alter the chemical structure of coating. This leads to gloss loss, color fading, and, over time, reduced corrosion protection. Additionally, moisture, heat, air pollutants, and other substances stress the coating.

Color coatings react to various weather conditions quite differently. Therefore, it is always necessary to verify a product's suitability for the concerned atmospheric corrosivity category (EN ISO 12944-2). Color-coated thin sheet steel can be used in corrosivity categories C1–C3, and the best color coatings can also be used in category C4. The conditions in category C5 are extremely aggressive, and the suitability for use should be evaluated on a case-by-case basis, with the understanding that long-term durability cannot be guaranteed. Color-coated thin sheet steel is not suitable for offshore (CX) environments.

Color-coated thin sheet steels are also well-suited for dry indoor conditions, where indoor air classifications must be taken into account. Exceptions are interior spaces with constant humidity and highly corrosive conditions for which color-coated thin sheet steel products are poorly suited. Color-coated thin sheet steels must not be used in the structures of swimming halls and spas. The corrosivity categories are presented in more detail in Table 2.

The technical data of Ruukki products can be found at www.ruukki.com.

Table 2. Atmospheric corrosivity categories (EN ISO 12944-2).

Corrosivity category	Thickness loss (after first year of exposure)		Examples of typical atmospheres (informative only)	
	Low-carbon steel, μm	Zinc, μm	Exterior	Interior
C1 very low	$\leq 1,3$	$\leq 0,1$		Heated buildings with clean atmospheres, e.g. offices, shops, schools, hotels.
C2 low	$> 1,3$ to 25	$> 0,1$ to 0,7	Atmospheres with low level of pollution: mostly rural areas.	Unheated buildings where condensation can occur, e.g. depots, sport halls.
C3 medium	> 25 to 50	$> 0,7$ to 2,1	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	> 50 to 80	$> 2,1$ to 4,2	Industrial areas and coastal areas with moderate salinity.	Chemical plants, swimming pools, coastal ship and boatyards.
C5 very high	> 80 to 200	$> 4,2$ to 8,4	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.
CX extreme	> 200 to 700	$> 8,4$ to 25	Offshore areas with high salinity and industrial areas with extreme humidity and aggressive atmosphere and subtropical and tropical atmospheres.	Industrial areas with extreme humidity and aggressive atmosphere.

The most common corrosivity category in inland is C2, while in larger city centres it can be C3, and on islands, at coastal areas and at heavy industry factories either C3, C4 or sometimes even C5 depending on the location.

Agricultural buildings are not listed as examples in the EN ISO 12944-2 standard table for atmospheric corrosivity categories. On farms, such as in piggeries and cowsheds, the conditions are generally very humid, and the surfaces are exposed to ammonia, methane, and hydrogen sulfide, so special attention must be paid to material selection.

WHY COLOR-COATED STEEL?

GreenCoat® steel is manufactured in SSAB's steel mill and then hot-dip galvanized on both sides in the Hämeenlinna production facility. The zinc coating (Z, 100–350 g/m²) is lead-free and has a zinc content of over 99%. The hot-dip galvanized thin sheet steel is then painted in SSAB's continuous color coating line of either Hämeenlinna, Kankaanpää or Finspång.

Over 40 years of extensive outdoor tests worldwide ensure that GreenCoat® products withstand even the harshest weather conditions, including strong winds, rain, snow, salty water, ice, UV radiation, high humidity, and storms.

The structure of GreenCoat® steel is shown in Figure 1. In the color coating line, both sides of the hot-dip galvanized steel are thoroughly cleaned and pre-treated, improving the corrosion resistance and maximizing

the adhesion of the primer. The primers contain anti-corrosion pigments, providing the product with highly durable corrosion protection. The choice of topcoat determines the product's final technical and aesthetic properties.

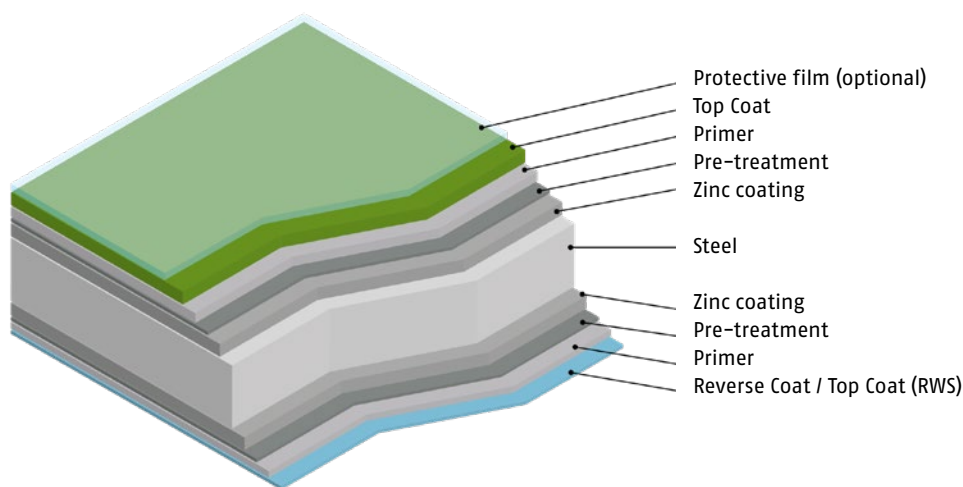


Figure 1. The structure of GreenCoat® steel (SSAB)

For example, a roof made from GreenCoat Pural BT matt coated steel will require maintenance painting only after several decades, and the maintenance painting will extend the roof's service life up to 20 years.

All color coatings have a fire classification of either A1 or A2-s1, d0 (EN 13501-1), meaning they either do not contribute to fire or have no significant contribution to fire growth.

ROOFING PROFILES

Ruukki recommends GreenCoat Pural BT matt product for roofing applications, classified under Ruukki 50 Plus quality class. The product has a zinc coating of 275 g/m². GreenCoat Pural BT matt coating provides excellent UV and corrosion resistance. It also offers excellent formability and scratch resistance. GreenCoat Pural BT matt has been developed to be as perfect roof coating as possible.

The typical steel thickness used is between 0,50 – 0,60 mm, depending on the roofing profile. For load-bearing profiles used as roofing, either GreenCoat Pural BT (for corrosivity category C4) or polyester coating (for C3) is used.

Roof surfaces are exposed to more intense UV radiation compared to other building surfaces. Standing snow, water, and wet debris cause stress on the roof surface, requiring the coating to have high corrosion resistance. Snow, ice, and walking on the roof cause additional wear, so the coating must also have good abrasion resistance.

By using the appropriate walkways of roof required by building codes, the mechanical wear of color coating caused by walking on the roof is reduced, and the overall service life of the roof is improved. Walkways, such as ladders and roof bridges, are made of hot-dip galvanized and powder-coated steel.



TRADITIONAL STANDING SEAM ROOFS

Ruukki primarily recommends GreenCoat Pural BT matt TinSmithPro for all traditional standing seam roofs, classified under Ruukki 50 Plus quality class. The product has a zinc coating of 275 g/m². Typically, Ruukki

recommends using 0,60 mm thick steel in TinSmithPro (TSP) grade.

When installing a traditional standing seam roof for a high-value building or a roof that requires a lot of work on site, hot-dip galvanized steel has traditionally been used as the raw material. For such roofs, Ruukki recommends GreenCoat TSP Legacy.

GreenCoat TSP Legacy is a tinsmith product designed for roofs where the roof can be painted on site, giving it a traditional and handmade appearance. It is recommended to be painted immediately after installation, not needed to wait for zinc patination, unlike with unpainted hot-dip galvanized tinsmith products.

The product's two-layer coating is optimized to provide excellent corrosion protection and a strong base for painting on site. This eliminates the need for a separate primer, as required with unpainted hot-dip galvanized steel roofs, and one painting is often enough for treatment on site.

Additionally, the surface of Legacy has higher friction, reducing the risk of slipping on the roof. The backside is protected with a grey reverse coat system for corrosion resistance. In cold temperatures, the coating of traditional standing seam roof must also withstand manual forming with hand tools, which meets Ruukki's recommendation.

This product provides clear cost benefits compared to using only hot-dip galvanized solutions, as scaffolding does not need to be re-installed later for post-painting, and the site can be handed over to the customer immediately after the roof installation and painting.

More information is available in Ruukki's GreenCoat TSP Legacy product sheet.

LOAD-BEARING TRAPEZOIDAL SHEETS AS ROOFING

Load-bearing trapezoidal sheets are commonly used as roofing in unheated storage buildings and shelters. Profiles are available with heights ranging from 45 mm to 153 mm, depending on the span and load conditions of the supporting structure.

In corrosivity category C3, polyester coating is used with a zinc coating of 275 g/m². In corrosivity category C4, GreenCoat Pural BT coating is used on top of the zinc.

To prevent water dripping due to condensation on the underside of the roof, a perlite-containing water-borne anti-condensation coating is available on the epoxy-coated reverse side.

LOAD-BEARING TRAPEZOIDAL SHEETS IN INSULATED ROOFS

Load-bearing trapezoidal sheets are widely used in insulated roofs of industrial buildings, public buildings, sports halls, and warehouses. In these cases, the choice of the coating depends on the indoor environmental conditions.

Typically, the corrosivity category indoors is not more than C2, in which case either a zinc coating of 275 g/m² or polyester coating with a zinc coating of 100 g/m² is suitable.

For more demanding humid conditions (corrosivity category C3), a zinc coating of 275 g/m² with polyester coating is used. In category C4 conditions, polyester is replaced by GreenCoat Pural BT coating.

FAÇADE CLADDINGS AND SANDWICH PANELS

The most important property of facade coatings is the long-term retention of appearance, which is why easy-to-clean and dirt-repellent surface are crucial. The material thickness varies depending on the product: 0,50 – 0,70 mm for facade profiles and 1,20 mm for facade cassettes. In sandwich panels the thickness is typically 0,60 mm for the external sheet and 0,50 mm for the internal sheet.

Ruukki primarily recommends GreenCoat Pural BT satin and GreenCoat Pural BT metallic coatings for facades, due to their excellent UV resistance and very good stain resistance properties. GreenCoat Pural BT coating is also suitable for demanding environments (corrosivity category C4).



Recommendations shortly:

- The best facade coatings are GreenCoat Pural BT satin and GreenCoat Pural BT metallic:
 - Suitable for corrosivity categories C2–C4 (EN ISO 12944-2).
 - Excellent resistance to UV radiation of the sun (RUV4–5, EN 10169) and heat.
 - Very good stain resistance properties.
- GreenCoat Cool coating is recommended for projects requiring a heat-reflective surface.
- For powder-coated facades, it is recommended to use Qualicoat Class 2 powder coating, which provides significantly better UV resistance than standard powder coating.

FLASHINGS OF BUILDINGS

Flashings are related to visible roof and facade surfaces, which are expected to remain clean and intact for decades. The material thickness varies depending on the building type and product but typically ranges between 0,50–0,70 mm.

In addition, the color coating must have good formability and abrasion resistance. Ruukki primarily recommends GreenCoat Pural BT coating for flashings, as it provides excellent bending resistance and scratch resistance.

For designed service life categories 1–3 of EN 1990, polyester or GreenCoat Crown BT coating can also be used.

RAINWATER SYSTEMS

Gutters in rainwater systems require excellent corrosion resistance, scratch resistance, and ease of cleaning due to flowing water and debris. Therefore, color-coated steel used in gutters must be coated with top coat on both sides. Ruukki recommends GreenCoat RWS Pural and GreenCoat RWS Pro coatings manufactured by SSAB.

Steel is the right and appropriate material choice for rainwater systems, as its mechanical properties match those of steel roofs (e.g. similar thermal expansion, no unfavorable galvanic couple is formed). Additionally, steel is a strong and durable material, which makes it highly resistant to permanent deformation. This is a very important feature in rainwater systems.

Ruukki's rainwater systems are designed to be compatible with steel, tile, and bitumen roofs. Ruukki's rainwater system efficiently removes rainwater from the roof and conducts it away from the building's foundation. The design of the high-quality rainwater system is pleasing to the eye and has also top class functionality. Bends shaped smooth reduce debris accumulation. Practical external brackets do not collect debris on gutter or hinder cleaning.

All components of the rainwater system are made of 0,60 mm thick hot-dip galvanized, double-sided color-coated steel in compliance with European standards. Ruukki's rainwater systems are tested under extreme Nordic conditions and manufactured using the best and modern methods, following product standards EN 1462 and EN 612. High-quality raw materials and coatings ensure a long service life in corrosivity categories C2 – C3.

Factory-made components are precise, tight, and easy to install. The finished rainwater system is almost maintenance-free. A light annual cleaning of debris and impurities will keep the rainwater system functional and is enough to give the best protection for your home against rainwater for decades.

Rainwater systems can be implemented either from pre-fabricated, extendable components manufactured in the factory, or using Rainway-machines developed by Piristeel Oy (part of Ruukki), for manufacturing of seamless gutters on sites. A seamless gutter manufactured on site is always tailored and dimensioned by a professional to ensure maximum technical performance, watertightness, long-term durability, and minimal material waste, packaging waste, and carbon footprint of transportation.



ROOF SAFETY PRODUCTS

The roof and its accessories are an important and visible façade of the building, which is also intended to protect people and the surrounding. The building and its surroundings must always be maintained in a condition that meets health, safety, and usability requirements. Building codes also require the use of connected walkways to all maintenance-requiring areas and equipment on the building, as well as anchoring points for safety rope. Ruukki's roof safety products enhance the functionality, usability and safety of buildings, creating a high-quality and efficient solution. By using walkways, mechanical stress on the roof surface is reduced, which prolongs the service life of the roof's color coating. Ruukki's roof safety products are manufactured at Piristeel's factory.

Various accessories are installed on roofs to improve building functionality and usability, and it is important to protect these with snow guards. For example, roof ladders, roof bridges, roof pass-throughs, roof windows and hatches, chimneys, and rainwater systems should always be protected with appropriate snow guards to reduce the risk of damage caused by snow loads.

A well-designed and implemented roof safety product system ensures overall operational safety, even in challenging Nordic outdoor conditions. Functionality is ensured by regular inspections and maintenance when necessary. For Ruukki's roof safety products, light, regular checks and maintenance are usually sufficient. The building's location and local winter conditions may significantly affect the extent of maintenance needed. The building owner is responsible for maintaining the roof safety products, ensuring that they remain in good condition, and monitoring that excessive snow loads do not damage them.

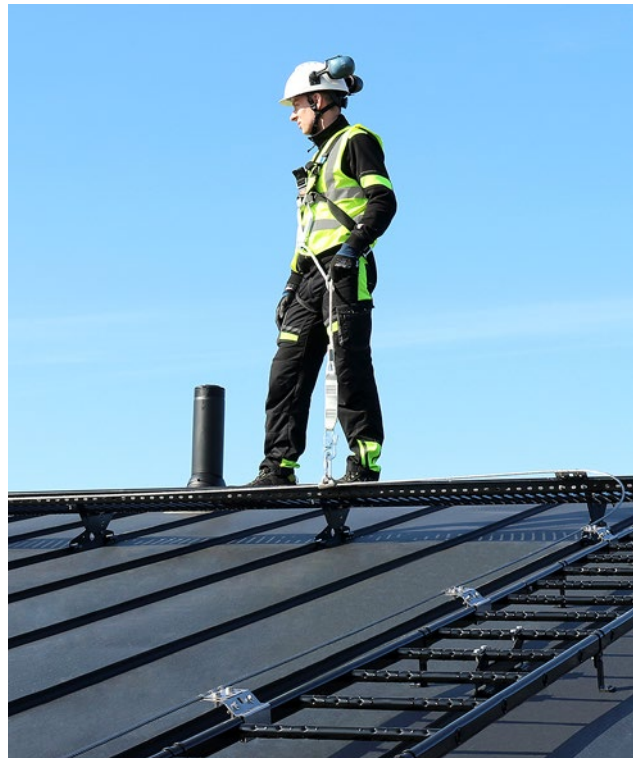
Ruukki's roof safety products are made of domestic hot-dip galvanized or Galfan-coated structural steel, manufactured using the world's cleanest methods. To enhance corrosion protection and wear resistance, and extend the life cycle of the products, the products are powder-coated after shaping using modern coating methods in Kauhava factory of Piristeel Oy. High-quality and weather-resistant Qualicoat Class 1 TGIC-free powder coating is used for standard products. The colors of the powder coating used for Ruukki's roof safety products are based on Pural color standards to ensure the best possible visual compatibility between the accessories and the roof surface. Special colors can also be manufactured for project-specific needs.

The thickness of the final coating layer is approximately 80 – 100 µm. The powder coating forms a strong, hard layer on the surface, improving abrasion resistance and protecting the steel against moisture. Products with a single powder coating layer are intended for use in corrosivity categories C2 – C3. For very demanding and rare corrosivity category C4 conditions in Finland, 2-layer powder coating can be considered to use on a case-by-case basis. The service life of Ruukki's powder-coated roof safety products is same as that is with color-coated steel roof.

Based on the specifications of the harmonized product standards for roof walkways (EN 516 and EN 12951), walkways that comply with the scope of the standards belong to A1 fire rating without testing. When taking into account the use and location of metal roof safety products in the building, their fire behaviour typically does not require special attention, however, according to EN 13501-1 reaction to fire tests, the classification of polyester powder-coated roof safety products manufactured by Piristeel Oy is A2-s1, d0.

INTERIOR WALLS AND CEILINGS

For interior applications, cleanliness and ease of cleaning are essential properties. The emission class M1 guarantees that the coating does not emit harmful substances into the indoor air. Ruukki recommends M1-classified polyester coating for indoor use in corrosivity categories C1 – C3. Additionally, in agricultural



construction, for example in animal shelters, the conditions set special requirements for chemical, moisture and wear resistance of the coating. For these buildings Ruukki recommends GreenCoat Pural BT product.

SCREWS

Ruukki recommends to use Ruukki Viktoria™ screws for fastening of roofing sheets. Additionally, it can be used for fastening of overlapped thin sheet steels. Only stainless steel screws are recommended for fastening of façade cladding products and in the interior of agricultural buildings.

The Ruukki Viktoria™ screw is fully protected from the head to the drill point. Additionally, the screw head, washer, and the upper part of the screw body are coated with Qualicoat Class 1 powder coating. The entire solution has been thoroughly tested and found to be well suited for corrosivity category C3 according to EN ISO 12944-2. The Qualicoat-classified powder coating provides an extra protection for the screw head, washer, and the upper part of the screw body. The protective treatment covers the entire screw, and its different layers from the outer surface are the following: special coating – passivation layer – zinc layer.

For thin sheet fastening, Ruukki recommends the special screw made of stainless steel which Piristeel Oy has thoroughly tested and it always includes a high-quality washer and gasket. The screw is intended, for example, for the installation of such accessories that are fastened directly to the thin sheet such as to roof or facade panels, without a separate support structure or battens behind the thin sheet. The special thread of the screw creates a very good pull-out strength even to the thin sheet steel.

Use recommendations of color coatings

There is a suitable coating available for almost every building project when environmental conditions, designed service life, and specific requirements are considered. The following tables present Ruukki's coating recommendations for different applications and conditions, as well as warranty periods.

STEEL GRADES, THICKNESSES, AND PROTECTION FOR VARIOUS APPLICATIONS

Ruukki's recommendations for steel grades, thicknesses, and protection for the most common applications are presented in Table 3.

Table 3. Steel grades, thicknesses, and corrosion protection for various applications.

Application	Steel grade	Thickness	Protection
Tile sheet and standing seam roofings, and trapezoidal profiles (not load-bearing profiles)	S280GD, S320GD	0,50–0,70 mm	Z275 + color coating
Load-bearing trapezoidal sheet roofings	S350GD	0,70–1,50 mm	Z275 + color coating
Load-bearing sheets for insulated roofs	S350GD	0,70–1,50 mm	Z100 + color coating Z275 + color coating Z275
Flashings of buildings	S280GD, S320GD	0,50–0,70 mm	Z275 + color coating
Traditional standing seam roofs	TinSmithPro	0,60 mm	Z275 + color coating Z350 + Legacy
Liberta panels and lamellas	DX51D	1,20 mm	Z275 + color coating
Cladding profiles and sandwich panels	S280GD, S320GD	0,50–0,70 mm	Z275 + color coating
Rainwater systems	DX52D/RWS, FAX, deep drawing grades	0,50–0,70 mm	Z275 + color coating

Unpainted hot-dip galvanized thin sheet steel is recommended for use only up to corrosivity category C2.

The warranty periods for color coatings in different corrosivity categories for roof and facade products are presented in Table 4, and use recommendations are shown in Table 5. All color-coated thin sheet steels are always hot-dip galvanized (Z275).

Table 4. Coating warranties for Ruukki's color-coated steels in different corrosivity categories (C2–C5, EN ISO 12944-2).

Application	Color coatings	Technical warranty (C2–C3)	Aesthetic warranty (years)			
			C2	C3	C4	C5
Roofing profiles	GreenCoat Pural BT matt	50	25	25	≤ 20 ¹⁾	≤ 5 ¹⁾
	GreenCoat Crown BT matt	40	15	15		
	Rough Matt Polyester	40	15	15		
Traditional standing seam roofs	GreenCoat Pural BT matt	50	25	25	≤ 20 ¹⁾	≤ 5 ¹⁾
Facade claddings and sandwich panels	GreenCoat Pural BT satin	50	25	25	≤ 20 ¹⁾	≤ 5 ¹⁾
	GreenCoat Pural BT metallic	50	25	25	≤ 20 ¹⁾	≤ 5 ¹⁾
	GreenCoat Hiarc matt	50	25	25		
Common use	Polyester	30	10	10		

¹⁾ C4 and C5 are highly demanding conditions, so only project-specific warranties may be issued under certain restrictions, depending on the environment of the location. Ruukki's contact information can be found at www.ruukki.com.

Country-specific warranties can be applied for products. For more information please contact local sales office of Ruukki to ensure the local warranty of Ruukki.

Table 5. Recommendations for the use of colour-coated steels for roofing and façade products in different corrosivity categories.

Color-coated steel (Product data: www.ssab.com/GreenCoat)	Corrosion resistance class (EN 10169)	UV- resistance class (EN 10169)	Corrosivity categories (EN ISO 12944-2)															
			C2				C3				C4				C5			
			L	M	H	VH	L	M	H	VH	L	M	H	VH	L	M	H	VH
GreenCoat Pural BT matt	RC5+	RUV5																
GreenCoat Pural BT satin	RC5+	RUV4-5																
GreenCoat Pural BT metallic	RC5+	RUV4																
GreenCoat Hiarc matt	RC4	RUV5																
GreenCoat Crown BT matt	RC5	RUV3																
Rough Matt Polyester	RC4	RUV3																
Polyester	RC3	RUV2-3																

Durability ranges and first maintenance painting recommendations (EN ISO 12944-1): LOW (L) < 7 years, MEDIUM (M) 7–15 years, HIGH (H) 15–25 years, VERY HIGH (VH) more than 25 years. Color-coated steel is in general recommended to use up to that corrosivity category, where HIGH durability can be guaranteed.

The most common corrosivity category in inland is C2. In larger city centres it can be C3, and on islands, at coastal areas and at heavy industry factories either C3, C4 or sometimes even C5 depending on the location. The best coatings recommended by Ruukki are suited to corrosivity categories C1 – C4 and can be used in designed service life categories 1 – 4 of building. For example, when using GreenCoat Pural BT matt coating on a roof in corrosivity category C2, the need for the first maintenance painting comes not until after more than 25 years.

Ruukki's GreenCoat Pural BT matt coating of the Ruukki 50 Plus quality class designed for outdoor use has excellent corrosion resistance and resistance to UV radiation of the sun. The excellent properties guarantee a long service life and the lowest life cycle costs on roofs. For facades, the most suitable coatings are GreenCoat Pural BT satin and GreenCoat Pural BT metallic.

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RUUKKI

Ruukki Construction Oy, Panuntie 11, 00620 Helsinki
+358 20 59 150, ruukki.com

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