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Hot-dip ga vanized (zinc

coatings on

fabricated ferrous article

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STANDARDS AUSTRALIA/STANDARDS NEW ZEALAND

REGISTRATION OF AS/NZS 4680:2006

Hot-dip galvanized (hot-dip zinc) coatings on fabricated ferrous articles

REGISTRATION NOTICE

This Standard was published on 31 August 2006.

The following amendments have been registered against this Standard:

Australian Steel Institute
Australian Steel Manufacturers
Bureau of Steel Manufacturers of Australia
Galvanizers Association of Australia
Galvanizers Association of New Zealand
New Zealand Steel Roofing Manufacturers

Introduction: Literature, Culture, Theory 1
Peter Barry

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Australian/New Zealand Standard™

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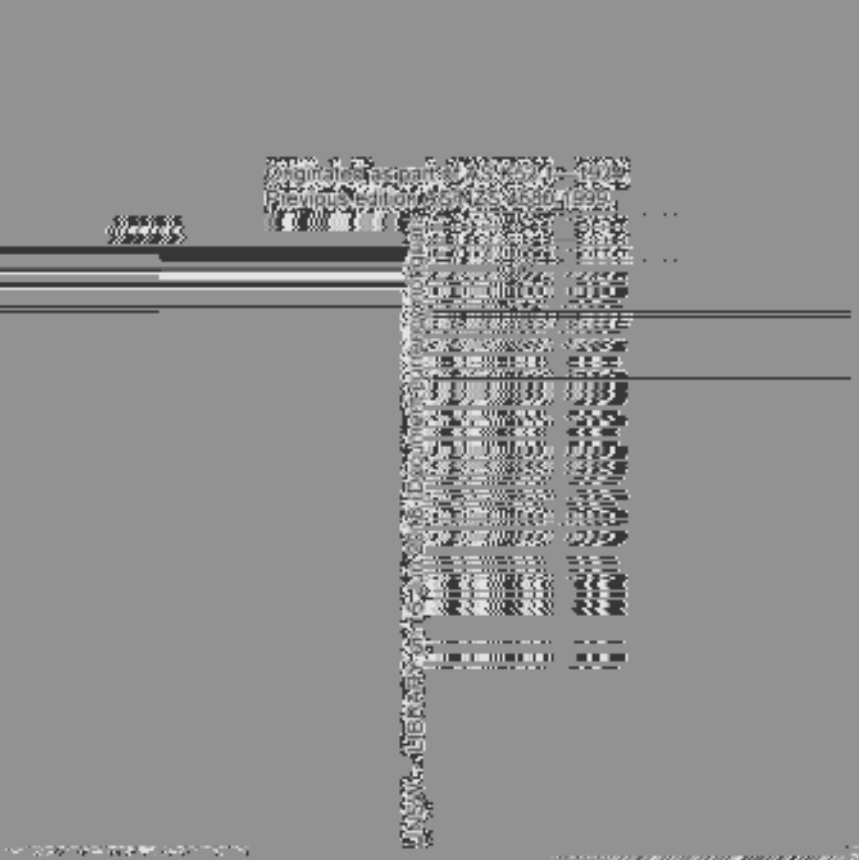



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STANDARDS AUSTRALIA/STANDARDS NEW ZEALAND

Australian/New Zealand Standard

Hot dip galvanized (zinc) coating on fabricated ferrous articles

1 SCOPE

This Standard specifies [illegible] ferrous articles, including assembled steel products, stampings, ferrous castings [illegible]

This Standard does not [illegible]

[illegible] requirements and tests for hot-dip zinc coatings on fabricated structural steel, steel reinforcements, steel sheet fabrications, tubular fabrications, fabricated wire work, steel forgings, steel [illegible] and other small components [illegible]

[illegible] to products such as wire and welded wire fabric (see AS/NZS 4534), sheet (see AS 1397) or open sections (see AS/NZS 4791) and tube hot-dip galvanized in continuous, semi-continuous or specialized plants (see AS/NZS 4792).

NOTES

1 [illegible] and recommendations on information to be supplied by the purchaser to the hot-dip galvanizer at the time of enquiry or order are contained in the purchasing guidelines set out in Appendix A.

2 Means for demonstrating compliance with this Standard are given in Appendix B.

[illegible]

2 REFERENCED DOCUMENTS

The following documents are referred to in this Standard:

AS

1199 Sampling procedures for inspection by attributes

1199.0 Part 0: Introduction to the ISO 2859 attribute sampling system

1199.1 Part 1: Sampling schemes indexed by acceptance [illegible] by lot inspection

[illegible] series)

1397 Steel sheet and strip — Hot-dipped zinc coated or aluminium zinc coated

1627 Metal finishing — Preparation and pretreatment of surfaces

1627.4 Part 4: Abrasive blast cleaning of steel

1815 Metallic materials — Rockwell hardness test (series)

1816 Metallic materials — Brinell hardness test (series)

1817 Metallic materials — Vickers hardness test (series)

2331 Methods of test for metallic and related coatings

2331.1.3 Method 1.3: Local thickness tests — Magnetic method

2331.1.4 Method 1.4: Local thickness tests — Magnetic induction and [illegible] methods

2331.2.9 Method 2.9: Tests for average coating mass per unit area or for thickness — Dissolution methods — Strip and weigh, and analytical [illegible]

2331.2.5 Method 2.5: [illegible] Tests for average coating mass per unit area or for thickness [illegible]

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AS
[illegible] Method [illegible] Corrosion and relative [illegible] tests – Neutral [illegible] test

[illegible] Suggesting of protective coatings

[illegible] Method [illegible] Determination of [illegible]

AS/NZS
[illegible] Safety and laboratories
[illegible] Part [illegible] Planning [illegible] aspects
[illegible] Part [illegible] Chemical aspects

[illegible] Guide to the protection of structural steel against atmospheric corrosion by the use of protective coatings

[illegible] Paints for steel structures
[illegible] Part [illegible] Organic zinc rich primer
[illegible] Part [illegible] Inorganic zinc silicate paint

[illegible] Zinc and zinc aluminium alloy coatings on steel wire

[illegible] Hot-dip galvanized (zinc) coatings on ferrous open sections applied by an in-line process

[illegible] Hot-dip galvanized (zinc) coatings on ferrous open sections applied by a continuous or a specialized process

AS/NZS ISO
[illegible] Quality management systems – Requirements
[illegible] Quality management systems – Guidelines for performance improvements
[illegible] Conformity assessment – Guidance on a third-party certification system for products

ISO
[illegible] Thermal [illegible] – Manual [illegible] and thermal [illegible]

3 DEFINITIONS

For the purpose of this Standard, the definitions below apply.

3.1 Coating mass

The total mass of hot-dip galvanized coating per unit surface area of steel base, on a single [illegible]

3.6 Coating thickness: local

3.7 Galvanizer

3.8 Hot-dip galvanizing

3.9 Hot-dip galvanizing

3.10 Reference area

3.11 Significant surface

4 DESIGN REQUIREMENTS

NOTES

5 BASIS METAL

NOTES

6 GALVANIZING PROCESS

6.1 Pretreatment

6.2 Bath composition

The molten metal in the working area of the galvanizing bath shall contain not less than

3 Threaded components

7 APPEARANCE AND FREEDOM FROM DEFECTS

8 REPAIR AFTER GALVANIZING

8.6 Extent of repairable damaged or uncoate

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8.2 Repair requirements

[illegible]

8.3 Repair after site handling and installation

[illegible]

8.4 Site repair

[illegible]

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9. COATING MASS AND THICKNESS

9.1 Coating mass

The coating mass shall be determined on significant surfaces in accordance with Appendix G, Paragraph G2, G3, G4 and shall comply with the relevant requirements of Tables 1 and 2. Unless otherwise specified, shall be agreeable to both the purchaser and the galvanizer.

Can article includes a number of different thicknesses of steel, each thickness range shall be [illegible] shall apply.

[illegible] carried out in accordance with the requirements of Clause 9.2. The results shall comply with the requirements of Table 1 or 2.

NOTE: Calculation of [illegible] by corrosion [illegible] Appendix H.

9.2 Coating thickness

When determined in accordance with Appendix G, Paragraph G2, the coating thickness on significant surfaces shall be not less than the values given in Table 1 or 2. [illegible] article includes a number of different thicknesses of steel, each thickness [illegible] belonging to as a separate article and the relevant values in Table 1 or 2 [illegible] shall apply.

[illegible]

10. ADHERENCE OF COATING

[illegible]

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TABLE 5[illegible]

REQUIREMENTS FOR COATING THICKNESS AND MASS OF ARTICLES THAT ARE NOT CENTRIFUGED

[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]	[illegible]

TABLE 6[illegible]

REQUIREMENTS FOR COATING THICKNESS AND MASS OF ARTICLES THAT ARE CENTRIFUGED

[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]	[illegible]

PURCHASING GUIDELINES

(Informative)

NERAL

2 INFORMATION TO BE SUPPLIED BY THE PURCHASER

Purchaser should supply the following information at the time of enquiry or order:

Reference to this Standard, i.e. AS/NZS 4680

The nature, chemical composition and mechanical properties of the product to be fabricated and its end use (a drawing and sample are useful).

Any mechanical work required, such as drilling (see Clause 4) and the note of Paragraph 4.0.1.

(d) Any special requirements for frequency of testing.

(e) Whether a passivation coating is required.

(f) Whether removal of surplus zinc on threads is required (see Clause 6.3).

(g) Whether an additional test for uniformity or adherence of the coating is required.

(h) Details of test requirements (see Clause 6).

(i) Whether a test report covering coating mass or thickness is required.

(j) Requirements for independent testing, if applicable.

(k) Whether it is the intention of the purchaser to inspect the coated product before it is

(l) Treatment of fabricant surfaces.

(m) Any special or supplementary requirements such as powder coating or requirements of the information on the [illegible] (see Appendix [illegible]).

(n) Any special coating thickness requirements.

(o) Instructions for renovation of damaged [illegible]

(p) Relevant quality standard [illegible]

[illegible] (see Appendix [illegible]).

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APPENDIX B

MEANS FOR DEMONSTRATING COMPLIANCE WITH THIS STANDARD

(Informative)

B1. SCOPE

This appendix sets out the following different ways by which compliance with this [illegible]

[illegible]

(a) [illegible]

(b) [illegible]

(c) Assurance using the acceptability of the supplier's quality system.

(d) Other such means approved by the manufacturer to supplier and acceptable by the customer.

B2. STATISTICAL SAMPLING

Statistical sampling is a procedure which enables decisions to be made about the quality of batches of items after inspection or testing only of portions of those items. This procedure will only be valid if the sampling of items is [illegible] with the requirements of [illegible].

(a) The sample needs to be drawn randomly from a population of product of known [illegible] known materials at essentially the same time, by essentially the same process [illegible] under essentially the same system of control.

[illegible] sampling plan needs to be defined. A sampling [illegible] sampling and [illegible] producing the same items.

[illegible] provided the statistical sampling to be meaningful to the customer, the manufacturer [illegible] supplier needs to demonstrate how the above conditions have been satisfied. Sampling [illegible] The establishment of a sampling plan should be carried out in accordance with AS 1199 [illegible] guidance to which is given in AS 1199.

B3. PRODUCT CERTIFICATION

[illegible] that products comply with the stated Standard [illegible] manufacture [illegible] should meet the criteria [illegible] from independently sampled production and subsequent verification [illegible] production [illegible] that the products consistently conform to the [illegible] requirements of the standard.

The certification scheme serves to indicate [illegible]

B4. SUPPLIER'S QUALITY SYSTEM

[illegible]

B5. OTHER MEANS OF ASSESSMENT

[illegible]

APPENDIX C

[illegible]

C1 SCOPE

[illegible]

C2 SIZE AND SHAPE

[illegible]

C5 WELDING

Any recognized welding procedure may be used. It is important that the supplier remove all welding slags and spatter prior to delivery to the galvanizer.

[illegible]

C6 VENTING AND DRAINING

C6.1 General

Structures that incorporate enclosed sections should have provision for adequate venting and draining (or ceiling) during galvanizing. At galvanizing temperatures, any moisture presents enclosed sections as rapidly converted to superheated steam capable of generating explosive forces. Venting to the atmosphere is not provided.

The purchaser should confer with the galvanizer during the design and fabrication stages to ensure that [illegible] galvanizer's experience can often assist the purchaser to design a product that can be galvanized safely and that will have a satisfactory galvanized coating.

[illegible] location of vent holes and if required, the method of draining and resealing should [illegible] will the purchaser before galvanizing commences.

C6.2 Hollow [illegible] sections

[illegible] preferable to use full open-mitre [illegible] in the case of welded hollow section assemblies [illegible] with the following [illegible]

[illegible] hole diameters may be [illegible] minimum [illegible] diameter minimum for each [illegible] of enclosed [illegible] available [illegible] NOTE: Examples [illegible] AS/NZS [illegible] galvanizers [illegible]

C7 ASSEMBLIES

(11) HANDLING

Items delivered to the galvanizer should be designed to provide for any special handling requirements.

(12) CASTINGS

To provide high quality galvanized coatings on castings of [illegible] the castings be sound, free from excessive porosity and free from [illegible] castings, the following practices are recommended:

(a) Wherever possible castings should be designed with uniform section thickness.

(b) Large fillet-welds and large pattern numbers should be avoided, and sharp entries should be avoided.

(c) Large grey iron castings should be stress relieved by the supplier. Heat-treated castings should be at least as [illegible] by the supplier.

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APPENDIX D

PREPARATION OF STEEL SURFACES FOR HOT-DIP GALVANIZING

D1 BASIS METAL

D2 Surface conditions

D3 The influence of the steel surface on the hot-dip galvanized coating thickness

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D1.4 Stresses in the basis metal

Some stresses in the basis metal will be relieved during the hot dip galvanizing process, which may cause the coated article to deform.

Whether a steel article that has been cold worked, could become embrittled during galvanizing is dependent on the type of steel and the degree of cold work that it has received. [illegible]

[illegible]

DUPLEX ADDED PROTECTION FOR GALVANIZING PLACE BELOW

[illegible]

(Informative)

F1 SCOPE

[illegible]

F2 PAINTING PROCEDURES

F2.1 General

[illegible]

F2.2 Preparation

[illegible]

F2.3 Painting system

[illegible]

The paint system should be applied to the manufacturer's instructions.

[illegible]

APPENDIX [illegible]

TRANSPORT AND STORAGE OF GALVANIZED ARTICLES

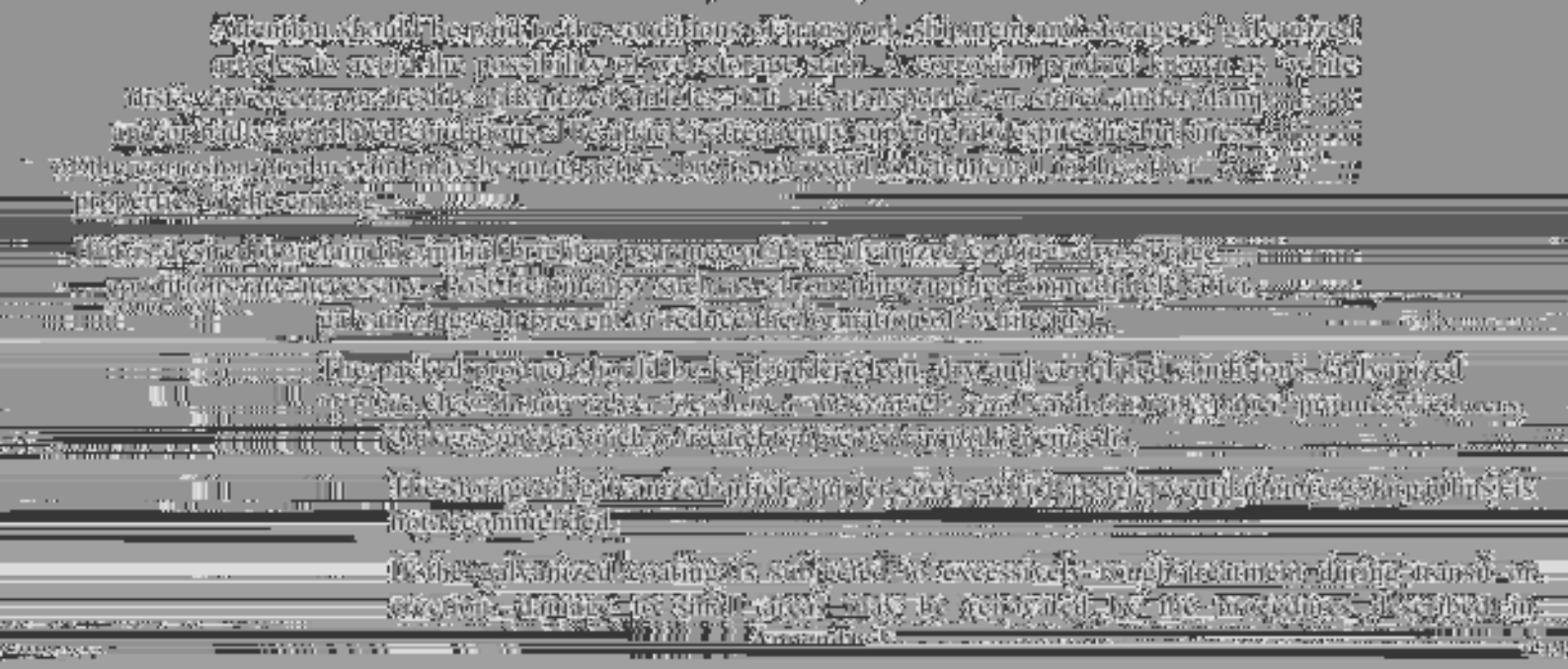
(Informative)

Attention should be paid to the conditions of transport, shipment and storage of galvanized articles to avoid the possibility of wet storage stain. A corrosion product known as white rust or wet storage stain [illegible] galvanized articles [illegible] transported or stored under damp [illegible] conditions. It [illegible] superficial [illegible] [illegible] properties of the coating.

[illegible] desired to retain the initial bright appearance of the galvanized coating, [illegible] conditions are necessary. [illegible] galvanizing can prevent or reduce the formation of white rust.

The packed product should be kept under clean, dry and ventilated conditions. Galvanized [illegible]

[illegible] storage of galvanized articles [illegible] is not recommended.



If the galvanized coating is subjected to excessively rough treatment during transport or storage, damage to small areas may be repaired by the procedures described in [illegible]

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APPENDIX G

DETERMINATION OF COATING MASS AND LOCAL THICKNESS

(Normative)

G1 GENERAL

[illegible] coating on galvanized articles as follows:

(a) Gravimetric method (see Paragraph G2).

(b) Volumetric method (see Paragraph G3).

(c) Mass-on-mass method (see Paragraph G4).

(d) [illegible]

NOTES:

[illegible]

G3 VOLUMETRIC METHOD

G3.1 Method

The method used shall be the hydrogen evolution method for zinc coatings given in AS/[illegible]

[illegible]

Where

[illegible]

G4 MASS-ON-MASS METHOD

[illegible] before and after galvanizing and dividing the difference by the area of the surface before galvanizing.

[illegible] after galvanizing. When the article has cooled to ambient temperature [illegible]

G5 [illegible] FOR LOCAL THICKNESS

G5.1 General

The method used shall be in accordance with either AS/[illegible] or AS/[illegible] or AS/[illegible].

G5.2 Calculation of coating mass

If required, the coating mass can be calculated by multiplying the thickness, in micrometres by 7.15.

G6 TEST REPORT

A test report shall include the following information:

Name of testing authority	(a)
Report number and date of issue	(b)
Batch number and details of the material under test	(c)
Test method used	(d)
Location and details of test samples and test specimens	(e)
Results of the test and a statement of compliance or otherwise with the requirements of this Standard	(f)
Results of any retests carried out	(g)
Reference to this test method, i.e. AS/NZS 4680, Appendix G	(h)

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APPENDIX H

GENERAL INFORMATION ON FACTORS INFLUENCING CORROSION OF GALVANIZED STEEL

(Informative)

H1 SCOPE

This Appendix provides general information on factors that affect the corrosion rate of galvanized steel in the environment. More detailed information is given in the Australian/New Zealand Standard AS/NZS 2312.

H2 ATMOSPHERIC CORROSION

H2.1 GENERAL

The factors that influence external atmospheric corrosion include:

(a) Time of wetness.

(b) Atmospheric pollutants.

(c) Atmospheric hydrogen sulfide content.

(d) Atmospheric salt content.

During which the most suitable of corrosion possible. It is influenced by factors such as and can be quantified to within accuracies in terms that the relative humidity is above 80% for temperatures

include the frequency, strength and prevailing wind and the deposition rate which influence concentration in the atmosphere. Airborne salt has a major influence corrosion rates and can be neglected except when occurring near such as coastal and industrial areas with sulfur dioxide and

wetness is the period of time water which renders atmospheric metal surface, orientation and pollut the number of hours per year above 0°C.

pollutants. Since atmospheric corrosion proceeds more rapidly in the presence of pollutants, particularly sulfur dioxide, and since these pollutants are found in greater concentrations in industrial areas than in rural areas, the corrosion rate is higher in industrial areas than in rural areas. On the other hand, reduces corrosion, while less polluted areas

Rainfall also influences corrosion rates. Frequent rainfall washes away corrosion products and pollutants, thereby reducing the corrosion rate. On the other hand, rainfall can increase the corrosion rate by providing the moisture necessary for the corrosion reaction.

Temperature influences corrosion rates. Generally, corrosion rates increase with increasing temperature. However, the relative humidity is usually lower at higher temperatures and, therefore, the time of wetness is reduced.

H3 LOCAL ENVIRONMENT

EFFECTS

The effects of the general atmospheric environmental factors, such as rainfall, wind, temperature, relative humidity, and the circumstances associated with the local environment can influence and therefore should be taken into account in the evaluation of the corrosivity of the atmosphere.

Local environmental factors that should be considered include:

(a) Sheltering from the direct effects of rainfall.

(b) Presence of dust or dirt.

(c) Presence of corrosive chemicals.

(d) Presence of organic materials that may absorb moisture.

(e) Presence of dissimilar metals in contact or close proximity.

(f) Presence of crevices.

(g) Presence of surfaces that may trap moisture.

(h) Presence of surfaces that may be difficult to clean.

(i) Presence of surfaces that may be difficult to paint.

(j) Presence of surfaces that may be difficult to inspect.

(k) Presence of surfaces that may be difficult to maintain.

(l) Presence of surfaces that may be difficult to repair.

(m) Presence of surfaces that may be difficult to replace.

(n) Presence of surfaces that may be difficult to protect.

(o) Presence of surfaces that may be difficult to monitor.

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(ee) Presence of surfaces that may be difficult to manage.

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(yy) Presence of surfaces that may be difficult to control.

(zz) Presence of surfaces that may be difficult to manage.

[redacted]

[redacted]

[redacted]

[redacted]

ATTENDANCE

INFORMATION ON THE USE OF SAFE PERIODS BETWEEN CLEANING OF GALVANIZED STEEL PRIOR TO PAINTING

(Informative)

[illegible]

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