

MATERIAL SPECIFICATION

582. GALVANIZING

1. SCOPE

This specification covers the quality of zinc coatings applied to iron and steel productions.

2. QUALITY

Zinc coatings shall conform to the requirements of ASTM A 123 for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products or as otherwise specified in the items of work and construction details of the Construction Specification.

ASTM A 123 covers both fabricated and non-fabricated products e.g., assembled steel products, structural steel fabrications, large tubes already bent or welded before galvanizing, and wire work fabricated from non-coated steel wire. It also covers steel forgings and iron castings incorporated into pieces fabricated before galvanizing or which are too large to be centrifuged (or otherwise handled to remove excess galvanizing bath metal). Items to be centrifuged or otherwise handled to remove excess zinc shall meet the requirements of ASTM A 153, except: bolts, screws and other fasteners 1/2 - inch or less in diameter may be coated with electro-deposited zinc or cadmium coating conforming to the requirements of ASTM B 766, coating thickness Class 5, Type III or ASTM B 633, Service Condition SC-3 unless otherwise specified.