

Hot dip galvanized coatings on fabricated iron and steel articles - Specifications and test methods

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EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN ISO 1461:2001 sisaldab Euroopa standardi EN ISO 1461:1999 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 18.06.2001 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN ISO 1461:2001 consists of the English text of the European standard EN ISO 1461:1999.</p> <p>This document is endorsed on 18.06.2001 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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<p>Käsitlusala:</p> <p>This standard specifies the general minimum requirements and tests for the properties of coatings applied by hot dipping in zinc on fabricated ferrous products, for example structural steel, steel sheet fabrications, steel products assembled before galvanizing; large tubes already bent or welded before galvanizing, steel forgings, steel stampings, ferrous castings, small components and similar products, the design of which shall be appropriate for the hot dip galvanizing process.</p>	<p>Scope:</p> <p>This standard specifies the general minimum requirements and tests for the properties of coatings applied by hot dipping in zinc on fabricated ferrous products, for example structural steel, steel sheet fabrications, steel products assembled before galvanizing; large tubes already bent or welded before galvanizing, steel forgings, steel stampings, ferrous castings, small components and similar products, the design of which shall be appropriate for the hot dip galvanizing process.</p>
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ICS 25.220.40

Võtmesõnad:

ICS 25.220.40

Descriptors: Metal coatings, steel products, hot dip galvanizing, requirements, testing.

English version

**Hot dip galvanized coatings on fabricated iron
and steel articles**

Specifications and test methods
(ISO 1461 : 1999)

Revêtements par galvanisation à
chaud sur produits finis ferreux –
Spécifications et méthodes d'essai
(ISO 1461 : 1999)

Durch Feuerverzinken auf Stahl
aufgebrachte Zinküberzüge (Stück-
verzinken) – Anforderungen und
Prüfungen (ISO 1461 : 1999)

This European Standard was approved by CEN on 1998-11-08.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

The European Standards exist in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, the Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, the Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart 36, B-1050 Brussels

Foreword

International Standard

ISO 1461 : 1999 Hot dip galvanized coatings on fabricated iron and steel articles – Specifications and test methods,

which was prepared by ISO/TC 107 'Metallic and other inorganic coatings' of the International Organization for Standardization, has been adopted by Technical Committee CEN/TC 262 'Metallic and other inorganic coatings', the Secretariat of which is held by BSI, as a European Standard.

This European Standard shall be given the status of a national standard either by publication of an identical text or by endorsement, and conflicting national standards withdrawn, by August 1999 at the latest.

In accordance with the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard:

Austria, Belgium, the Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, the Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

Endorsement notice

The text of the International Standard ISO 1461 : 1999 was approved by CEN as a European Standard without any modification.

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1 Scope

This Standard specifies the general properties of and methods of test for coatings applied by hot dipping in zinc (containing not more than 2 % of other metals) on fabricated iron and steel articles. It does not apply to:

- a) sheet and wire that are continuously hot dip galvanized;
- b) tube and pipe that is hot dip galvanized in automatic plants;
- c) hot dip galvanized products for which specific standards exist and which may include additional requirements or requirements different from those of this European Standard.

NOTE Individual product standards can incorporate this standard for the coating by quoting its number, or may incorporate it with modifications specific to the product.

After-treatment/overcoating of hot dip galvanized articles is not covered by this standard.

2 Normative references

This Standard incorporates, by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this International/European Standard only when incorporated in it by amendment or revision. For undated references, the latest edition of the publication referred to applies.

EN 1179, *Zinc and zinc alloys — Primary zinc*.

EN ISO 1460, *Metallic coatings — Hot dip galvanized coatings on ferrous materials — Gravimetric determination of the mass per unit area (ISO 1460:1992)*.

EN 22063, *Metallic and other inorganic coatings — Thermal spraying — Zinc, aluminium and their alloys (ISO 2063:1991)*.

EN ISO 2064, *Metallic and other inorganic coatings — Definitions and conventions concerning the measurement of thickness (ISO 2064:1980)*.

EN ISO 2178, *Non-magnetic coatings on magnetic substrates — Measurement of coating thickness — Magnetic method (ISO 2178:1982)*.

ISO 752, *Zinc ingots*.

ISO 2859-1, *Sampling procedures for inspection by attributes — Part 1: Sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection*.

ISO 2859-3, *Sampling procedures for inspection by attributes — Part 3: Skip-lot sampling procedures*.

ISO 10474, *Steel and steel products — Inspection documents*.

3 Term(s) and definition(s)

For the purposes of this standard, the following definitions apply together with those given in EN ISO 2064.

3.1

hot dip galvanizing

formation of a coating of zinc and/or zinc-iron alloys on iron and steel products by dipping prepared steel or cast iron in molten zinc.

3.2

hot dip galvanized coating

coating obtained by hot dip galvanizing

NOTE The term 'hot dip galvanized coating' is subsequently referred to as the 'coating'.