

**TERASELE KANTAVAD KUUMTSINKPINDED
(TÜKKTSINKIMINE). NÕUDED JA KATSEMEETODID**

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

EESTI STANDARDI EESSÕNA**NATIONAL FOREWORD**

See Eesti standard EVS-EN ISO 1461:2009 sisaldab Euroopa standardi EN ISO 1461:2009 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 1461:2009 consists of the English text of the European standard EN ISO 1461:2009.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas.	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation.
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English Version

Hot dip galvanized coatings on fabricated iron and steel articles - Specifications and test methods (ISO 1461:2009)

Revêtements par galvanisation à chaud sur produits finis
en fonte et en acier - Spécifications et méthodes d'essai
(ISO 1461:2009)

Durch Feuerverzinken auf Stahl aufgebrachte Zinküberzüge
(Stückverzinken) - Anforderungen und Prüfungen (ISO
1461:2009)

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Foreword

This document (EN ISO 1461:2009) has been prepared by Technical Committee ISO/TC 107 "Metallic and other inorganic coatings" in collaboration with Technical Committee CEN/TC 262 "Metallic and other inorganic coatings", the secretariat of which is held by BSI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by November 2009, and conflicting national standards shall be withdrawn at the latest by November 2009.

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Endorsement notice

The text of ISO 1461:2009 has been approved by CEN as a EN ISO 1461:2009 without any modification.

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

1 Scope

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

- a) sheet, wire and woven or welded mesh products that are continuously hot dip galvanized;
- b) tube and pipe that are hot dip galvanized in automatic plants;
- c) hot dip galvanized products (e.g. fasteners) for which specific standards exist and which might include additional requirements or requirements which are different from those of this International Standard.

NOTE Individual product standards can incorporate this International Standard for the coating by quoting its number, or can incorporate it with modifications specific to the product. Different requirements can also be made for galvanized coatings on products intended to meet specific regulatory requirements.

After-treatment/over-coating of hot dip galvanized articles is not covered by this International Standard.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 752, *Zinc ingots*

ISO 1460, *Metallic coatings — Hot dip galvanized coatings on ferrous materials — Gravimetric determination of the mass per unit area*

ISO 2064, *Metallic and other inorganic coatings — Definitions and conventions concerning the measurement of thickness*

ISO 2178, *Non-magnetic coatings on magnetic substrates — Measurement of coating thickness — Magnetic method*

ISO 2808, *Paints and varnishes — Determination of film thickness*

ISO 2859-1, *Sampling procedures for inspection by attributes — Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection*

ISO 2859-2, *Sampling procedures for inspection by attributes — Part 2: Sampling plans indexed by limited quality (LQ) for isolated lot inspection*

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

ISO 3549, *Zinc dust pigments for paints — Specifications and test methods*

ISO 3882, *Metallic and other inorganic coatings — Review of methods of measurement of thickness*

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

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

EN 13283, *Zinc and zinc alloys — Secondary zinc*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 2064 and the following apply.

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 a zinc melt

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”.

3.3 coating mass
total mass of zinc and/or zinc alloys per area of surface

NOTE The coating mass is expressed in grams per square metre, g/m².

3.4 coating thickness
total thickness of zinc and/or zinc alloys

NOTE The thickness is expressed in micrometres, µm.

3.5 significant surface
part of the article covered or to be covered by the coating and for which the coating is essential for serviceability and/or appearance

3.6 control sample
article or group of articles from a lot that is selected for sampling

3.7 reference area
area within which a specific number of single measurements are made

3.8 local coating thickness
mean value of coating thickness obtained from the specific number of measurements within a reference area for a magnetic test or the single value from a gravimetric test

3.9 mean coating thickness
average value of the local thicknesses