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**Continuous hot-dip zinc-coated twin-roll  
cast steel sheet of commercial quality**

*Tôles coulées entre cylindres et galvanisées en continu par immersion  
à chaud, en acier de qualité commerciale*



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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 15208 was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 12, *Continuous mill flat rolled products*.

# Continuous hot-dip zinc-coated twin-roll cast steel sheet of commercial quality

## 1 Scope

This International Standard specifies the characteristics of continuous hot-dip zinc-coated twin-roll cast steel sheet of commercial quality manufactured using the twin-roll cast steel-making process.

The product is intended for applications where resistance to corrosion is of prime importance.

The steel sheet is produced in a number of coating mass, surface treatments and ordering conditions.

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

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

ISO 3497, *Metallic coatings — Measurement of coating thickness — X-ray spectrometric methods*

ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature*

ISO 7438, *Metallic materials — Bend test*

ISO 16160, *Hot-rolled steel sheet products — Dimensional and shape tolerances*

ISO 16162, *Cold-rolled steel sheet products — Dimensional and shape tolerances*

ISO 16163, *Continuously hot-dipped coated steel sheet products — Dimensional and shape tolerances*

## 3 Terms and definitions

For the purposes of this document, the following terms and definitions apply

### 3.1

#### **continuous hot-dip zinc-coated steel sheet**

product obtained by hot-dip coating of cold-reduced sheet coils or hot-rolled sheet coils on a continuous zinc-coating line

### 3.2

#### **normal spangle**

coating formed as a result of unrestricted growth of zinc or zinc iron crystals during normal solidification

NOTE Normal spangle has a metallic lustre and is the type normally furnished for a wide variety of applications. It may be furnished as coating conditions S or N (see 8.4); however, it may be variable in appearance and is not suitable for decorative painting.

### 3.3

#### **minimized spangle coating**

finish obtained by restricting normal spangle formation during the solidification of the zinc crystals

NOTE This product may have some lack of uniformity in surface appearance within a coil or from coil to coil.