

Part 642 – Specifications

Chapter 3 – National Standard Material Specifications

Material Specification 582—Galvanizing

A. Scope

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

B. Quality

- (1) Zinc coatings shall conform to the requirements of ASTM A123 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.
- (2) ASTM A123 covers both fabricated and nonfabricated products; e.g., assembled steel products, structural steel fabrications, large tubes already bent or welded before galvanizing, and wire work fabricated from noncoated 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).
- (3) Items to be centrifuged or otherwise handled to remove excess zinc shall meet the requirements of ASTM A153, except bolts, screws, and other fasteners 0.5 inch or less in diameter may be coated with electro-deposited zinc or cadmium coating conforming to the requirements of ASTM B766, coating thickness Class 5, Type III, or ASTM B633, Service Condition SC-3, unless otherwise specified.