

Getting the right finish

Thickness of the coating

The thickness of the galvanized coating shall conform with AS/NZS 4680 as shown below.

Table 1

Requirements for coating thickness and mass for articles that are not centrifuged

ARTICLE THICKNESS (mm)	LOCAL COATING THICKNESS (microns)	AVERAGE COATING THICKNESS (microns)	AVERAGE COATING MASS (g/m ²)
1.5mm or less	35	45	320
Over 1.5 to 3mm	45	55	390
Over 3 to 6mm	55	70	500
Over 6mm	70	85	600

Table 2

Requirements for coating thickness and mass for articles that are centrifuged

ARTICLE THICKNESS INCL. CASTINGS (mm)	LOCAL COATING THICKNESS (microns)	AVERAGE COATING THICKNESS (microns)	AVERAGE COATING MASS (g/m ²)
Less than 8mm	25	35	250
8mm and over	40	55	390

The thickness of the galvanized coating should ideally be tested by the purchaser/designer or the galvanizer at the galvanizer's premises, using an approved magnetic measuring device. In the event of any dispute, an independent test is carried out in accordance with AS/NZS 4680, Appendix G.

Surface finish

The galvanized coating will be continuous, adherent and as smooth and evenly distributed as possible. The coating will be free from any defect that is detrimental to the stated end use of the coated article. On silicon-killed steels, it is acceptable that the coating may be dull grey, provided the coating is sound and continuous.

The integrity of the coating is determined by visual inspection and coating thickness measurements.

Where a paint finish is to be applied after galvanized coating, this should be advised at the time of order. All spikes will be removed and all edges will be free from lumps and runs.

Adhesion

The galvanized coating will be sufficiently adherent to withstand normal handling during transport and erection.



TALKING TECHNICAL

Design, specification and inspection of galvanized products

To ensure consistently good galvanized steel products, it is essential that the basic requirements outlined in these guides are incorporated at the design and fabrication stages of production.

These technical guides are designed to be introductory only. All design features should be discussed with a member of our advisory team. Close liaison between the design engineer, materials engineer, specifier, fabricator and galvanizer will ensure the highest galvanizing standards. Perry Metal Protection also distributes a free wallchart and a summary booklet.



Perry Metal Protection is a member of the Galvanizing Association of New Zealand, Galvanizers Association of Australia and is ISO9001 certified.

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For advice on service, quotations and technical knowledge on hot dip galvanizing, contact your local Perry Metal Protection site:

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Alternatively, visit our website www.perrymetalprotection.co.nz or email enquiry@perry.co.nz