SECTION 05 05 10
METAL GALVANIZING

PART 1 GENERAL

1.1 SECTION INCLUDES
A. Application of a zinc coating on fabricated metal items.
B. Repair of damaged galvanized surfaces.

1.2 REFERENCES
A. ASTM A 123: Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products.
B. ASTM A 153: Standard Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware.
C. ASTM A 780: Standard Practice for Repair of Damaged Hot-Dip Galvanized Coatings.
D. ASTM B 6: Standard Specification for Zinc (Slab Zinc).
E. ASTM E 376: Standard Practice for Measuring Coating Thickness by Magnetic-Field or Eddy-Current (Electromagnetic) Test Methods.
F. FS TT-P-641: Primer Coating, Zinc Dust -Zinc Oxide (for Galvanized Surfaces).
G. MIL P-21035: Paint, High Zinc Dust Content, Galvanizing Repair.

1.3 QUALITY ASSURANCE
A. When requested, verify weight of zinc coating in accordance with ASTM E 376.

PART 2 PRODUCTS

2.1 ZINC METAL
A. Use zinc for coating that conforms to ASTM B 6 and is at least equal to the grade designated as "Prime Western".

PART 3 EXECUTION

3.1 GALVANIZING
A. Provide a zinc coating for those items indicated or specified to be galvanized as follows:
   1. ASTM A 123 for galvanizing rolled, pressed and forged steel shapes, plates, bars and strips 1/8 inch thick and heavier.
   2. ASTM A 153 for galvanizing iron and steel hardware.

3.2 WEIGHT OF COATING
A. Apply zinc on 1/8 inch to 3/16 inch thick steel at a rate of at least 2ounces per square foot of surface area.
B. Apply zinc on 1/4 inch and thicker steels at a rate of at least 2.3 ounces per square foot

with no individual test measuring less than 2-ounces per square foot of surface area.

3.3 **REPAIR OF DAMAGED COATING**
    A. Repair all shop damaged galvanized surfaces by the metallizing, hot stick or zinc rich paint, ASTM C 780 process.
    B. Repair field damaged, cut, burned or uncoated surfaces in the field by coating with a dust-zinc oxide paint conforming to FS TT-P-641 or MIL P-21035.

END OF SECTION