

SECTION 143

GALVANIZING

143.1 GENERAL

These specifications cover the hot-dip galvanizing of various metals where required by the detailed plans or specifications.

143.2 REFERENCES

143.2.1 ASTM

A 116	A 153
A 120	A 392
A 121	A 444
A 123	A 525

143.3 SPECIFICATIONS

Materials shall be hot-dip galvanized and the weight and uniformity of coating determined in accordance with the standard specifications given in the Table 143.3

143.4 WORKMANSHIP

The galvanizing shall be applied in such a manner that the spelter will not peel off. The finished product shall be free from blisters and excess spelter; and the coating shall be even, smooth, and uniform throughout. Machine work, dye work, cutting, punching, bending, welding, drilling, thread cutting, and other fabricating shall be done as far as is practicable before the galvanizing. No member shall be galvanized which is out of alignment. All members, nuts, bolts, washers, etc. shall be galvanized before a structural unit is assembled. All uncoated spots or damaged coatings due to poor workmanship, rough handling, or any other reason shall be cause for rejection.

143.5 TEST COUPONS

Test coupons for determining the quality of the galvanizing shall be wired to the materials to be galvanized before immersion in such a manner as to represent the amount of coating deposited on the materials.

143.6 REPAIR OF GALVANIZED SURFACES

Unless otherwise specified, where galvanized surfaces are field or shop cut, broken, burned, or abraded, thus breaking the galvanizing, the locations

thus damaged shall be coated with "Galvalloy" or "Galvicon" or an approved equal.

143.7 MEASUREMENT AND PAYMENT

Galvanizing will be considered a subsidiary item to the product so treated. No separate measurement or payment will be made.

TABLE 143.3

GALVANIZING SPECIFICATIONS

Material or Test	Std. Spec. ASTM	Class
Corrugated Metal Pipe	A 444	
Flat Steel or Iron Sheets	A 525	
Iron or Steel Wire	A 116	2
Chain-Link fabric (Galv. after Fabrication)	A 392	1
Barbed Wire	A 121	2
Steel Pipe Rails	A 120	
Structural Shapes, Tie Rods, Ornamental Iron Railings, Handrails, Manhole and Catch Basin Steps, and Curb Armor	A 123	
Bolts, Nuts, Washers, Anchor Bolts, Packing Spools, Gray Iron and Malleable Iron Castings, and Steel Castings	A 153	
Guard Rails	A 525	