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Standard Practice for Preparation of Zinc (Hot-Dip Galvanized) Coated Iron and Steel Product and Hardware Surfaces for Painting¹

This standard is issued under the fixed designation D6386; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (z) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope*

1.1 This practice describes methods of preparing surfaces of new and weathered hot-dip galvanized steel for painting. Hot-dip galvanized steel is produced by the immersion of fabricated or unfabricated products in a bath of molten zinc, as specified in Specifications A123/A123M or A153/A153M. This practice covers surface preparation on iron and steel products and hardware that have not been painted previously. Galvanized surfaces may have been treated with protective coatings to prevent the occurrence of wet storage stain. This practice does not apply to sheet galvanized steel products nor to the coil coating or continuous roller coating processes. Sheet and coil surface preparation can be done in accordance with Practice D7396.

1.2 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only

1.3 This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and to determine the application of regulatory limitations prior to use.

2. Referenced Documents

2.1 ASTM Standards.2

- A123/A123M Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products
- A153/A153M Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware

A780 Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings

B201 Practice for Testing Chromate Coatings on Zinc and Cadmium Surfaces

D7396 Guide for Preparation of New, Continuous Zinc-Coated (Galvanized) Steel Surfaces for Painting

E376 Practice for Measuring Coating Thickness by Magnetic-Field or Eddy-Current (Electromagnetic) Testing Methods

2.2 Society for Protective Coatings Specifications:3

Surface Preparation Specification No. 1 Solvent Cleaning Surface Preparation Specification No. 2 Hand Tool Cleaning Surface Preparation Specification No. 3 Power Tool Cleaning

Surface Preparation Specification No. 7 Brush-Off Blast Cleaning

Surface Preparation Specification No. 11 Power Tool Cleaning to Bare Metal

Paint Specification No. 27 Basic Zinc Chromate-Vinyl Butyral Wash Primer

3. Summary of Practice

3.1 This practice describes the preparation methods that provide clean and suitable galvanized surfaces for painting, specifically so that an applied coating system can develop the adhesion necessary for a satisfactory service life.

3.2 The zinc coating is constantly in a state of change. From the time the steel part is removed from the galvanizing kettle, the exposed zinc coating interacts with the environment to form, first zinc oxides, next zinc hydroxides, and then zinc carbonates.4 The process of complete conversion of the outer layer of zinc carbonates can take up to two years of exposure to the environment, depending on the local climatological conditions. During the first stage, known as newly galvanized steel, the exposed surface consists mainly of zinc metal with a small amount of zinc oxide. During the second stage, known as partially weathered galvanized steel, the exposed surface

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¹ This practice is under the jurisdiction of ASTM Committee D01 on Paint and Related Coatings, Materials, and Applications and is the direct responsibility of Subcommittee D01,46 on Industrial Protective Coatings.

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