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Hot dip galvanized coatings on fabricated iron and steel articles — Specifications and test methods

*Revêtements par galvanisation à chaud sur produits finis en fonte et
en acier — Spécifications et méthodes d'essai*



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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 107, *Metallic and other inorganic coatings*, Subcommittee SC 4, *Hot dip coatings (galvanized, etc.)*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 262, *Metallic and other inorganic coatings*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This fourth edition cancels and replaces the third edition (ISO 1461:2009), which has been technically revised.

The main changes are as follows:

- definitions have been added for 'galvanizer', 'after-treatment', 'additional coating', 'wet storage stain' and 'duplex system' in [Clause 3](#);
- the difficulty to remove flux residues and zinc ash when access is restricted has been recognised in [6.1](#);
- procedures for choice of reference areas have been clarified and additional requirements to avoid reference areas on certain small ancillary elements on a larger article have been added in [6.2.3](#);
- requirements for renovation of uncoated areas have been revised: the requirements for the pigment of a zinc-containing paint to conform with ISO 3549 have been removed; [Annex C](#) has been extended to include additional information on the suitability of different methods of renovation given in [6.3](#);
- all requirements related to coating thickness, including [Table 3](#) and [Table 4](#), have been placed within [6.5](#), including requirements linked to the size of the article in the control sample previously within [6.2.3](#); the lower coating thicknesses that can result in ultra-low reactive steels are recognised in new requirements for these steel types in [6.5](#);
- information on corrosion resistance of galvanized coatings has been updated, including the reference to ISO 9224 for longer-term corrosion resistance in [Annex E](#).

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.