



Designation: A123/A123M – 24

Standard Specification for Zinc (Hot-Dip Galvanized) Coatings on Iron and Steel Products¹

This standard is issued under the fixed designation A123/A123M; 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 (ε) indicates an editorial change since the last revision or reapproval.

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

1. Scope*

1.1 This specification covers the requirements for zinc coating (galvanizing) by the hot-dip process on iron and steel products made from rolled pressed and forged shapes, castings, plates, bars, and strips.

1.2 This specification covers both unfabricated products and fabricated products, for example, assembled steel products, structural steel fabrications, large tubes already bent or welded before galvanizing, and wire work fabricated from uncoated steel wire. This specification also covers steel forgings and iron castings incorporated into pieces fabricated before galvanizing or which are too large to be centrifuged (or otherwise handled to remove excess galvanizing bath metal).

NOTE 1—This specification covers those products previously addressed in Specifications A123–78 and A386–78.

1.3 This specification does not apply to wire, pipe, tube, or steel sheet which is galvanized on specialized or continuous lines, or to steel less than 22 gauge (0.0299 in.) [0.76 mm] thick.

1.4 The galvanizing of hardware items that are to be centrifuged or otherwise handled to remove excess zinc (such as bolts and similar threaded fasteners, castings and rolled, pressed and forged items) shall be in accordance with Specification A153/A153M.

1.5 Fabricated reinforcing steel bar assemblies are covered by the present specification. The batch galvanizing of separate reinforcing steel bars shall be in accordance with Specification A767/A767M and the continuous galvanizing of reinforcing bars shall be in accordance with Specification A1094/A1094M.

1.6 This specification is applicable to orders in either inch-pound units (as A123) or SI units (as A123M). Inch-pound units and SI units are not necessarily exact equivalents. Within the text of this specification and where appropriate, SI

units are shown in parentheses. Each system shall be used independently of the other without combining values in any way. In the case of orders in SI units, all testing and inspection shall be done using the metric equivalent of the test or inspection method as appropriate. In the case of orders in SI units, such shall be stated to the galvanizer when the order is placed.

1.7 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 ASTM Standards:²

- A47/A47M Specification for Ferritic Malleable Iron Castings
- A90/A90M Test Method for Weight [Mass] of Coating on Iron and Steel Articles with Zinc or Zinc-Alloy Coatings
- A143/A143M Practice for Safeguarding Against Embrittlement of Hot-Dip Galvanized Structural Steel Products and Procedure for Detecting Embrittlement
- A1094/A1094M Specification for Continuous Hot-Dip Galvanized Steel Bars for Concrete Reinforcement
- A153/A153M Specification for Zinc Coating (Hot-Dip) on Iron and Steel Hardware
- A384/A384M Practice for Safeguarding Against Warpage and Distortion During Hot-Dip Galvanizing of Steel Assemblies
- A385/A385M Practice for Providing High-Quality Zinc Coatings (Hot-Dip)
- A767/A767M Specification for Zinc-Coated (Galvanized) Steel Bars for Concrete Reinforcement
- A780/A780M Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings

¹ This specification is under the jurisdiction of ASTM Committee A05 on Metallic-Coated Iron and Steel Products and is the direct responsibility of Subcommittee A05.13 on Structural Shapes and Hardware Specifications.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at www.astm.org/contact. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

*A Summary of Changes section appears at the end of this standard



A902 Terminology Relating to Metallic Coated Steel Products

B6 Specification for Zinc

B487 Test Method for Measurement of Metal and Oxide Coating Thickness by Microscopical Examination of Cross Section

B602 Guide for Attribute Sampling of Metallic and Inorganic Coatings

B960 Specification for Prime Western Grade-Recycled (PWG-R) Zinc

D6386 Practice for Preparation of Zinc (Hot-Dip Galvanized) Coated Iron and Steel Product and Hardware Surfaces for Painting

D7803 Practice for Preparation of Zinc (Hot-Dip Galvanized) Coated Iron and Steel Product and Hardware Surfaces for Powder Coating

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

3. Terminology (See Fig. 1)

3.1 Definitions:

3.1.1 The following terms and definitions are specific to this specification. Terminology **A902** contains other terms and definitions relating to metallic-coated steel products.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *average coating thickness, n*—the average of three specimen coating thicknesses.

3.2.2 *black, adj*—denotes the condition of not galvanized or otherwise coated. For purposes of this specification the word “black” does not refer to the color or condition of surface, or to a surface deposit or contamination.

3.2.3 *coating thickness grade, n*—the numerical value from **Table 1** at the intersection of a material category and a thickness range.

3.2.4 *gross gross inclusions, n*—the iron/zinc intermetallics present in a galvanized coating in a form other than finely dispersed pimples.

3.2.4.1 *Discussion*—These inclusions would create an exposed steel spot if they were removed from the coating. These inclusions are raised surfaces and are easily knocked off through contact with lifting straps or chains, tools, fixtures, or other galvanized parts.

3.2.5 *intended use, n*—the objective or function a product is designed to be used for which is not primarily aesthetic in

nature. This includes functional features of the product, required fit-up to other parts, or ability to be painted or powder coated.

3.2.6 *masking, n*—the practice of treating a portion of the steel surface with a material not removable by chemical cleaning during the galvanizing process to achieve purposely ungalvanized areas.

3.2.7 *material category, n*—the general class or type of material or process of manufacture, or both, that nominally describes a unit of product, or from which a unit of product is made. For example, bar grating belongs to the category “strip,” handrail belongs to the category “pipe,” etc. Refer to **Appendix X1** for additional examples.

3.2.8 *multi-specimen article, n*—a unit of product whose surface area is greater than 160 in.² [100 000 mm²]. For thickness testing purposes, articles whose surface area is greater than 160 in.² are subdivided into three continuous local sections, nominally equal in surface area, each of which constitutes a specimen. In the case of any such local section containing more than one material category or steel thickness range as delineated in **Table 1**, that section will contain more than one specimen (see **Fig. 1**).

3.2.9 *sample, n*—a collection of individual units of product from a single lot selected in accordance with Section 7, and intended to represent that lot for acceptance. If a sample is taken as representing the lot for acceptance, the sample shall be taken at random from the lot without regard to the perceived quality or appearance of any individual unit in the lot being sampled. The sample consists of one or more test articles.

3.2.10 *single-specimen article, n*—a unit of product whose surface area is equal to or less than 160 in.² [100 000 mm²] or that is centrifuged or otherwise similarly handled in the galvanizing process to remove excess galvanizing bath metal (free zinc). For thickness testing purposes, the entire surface area of each unit of product constitutes a specimen. In the case of any such article containing more than one material category or steel thickness range as delineated in **Table 1**, that article will contain more than one specimen (see **Fig. 1**).

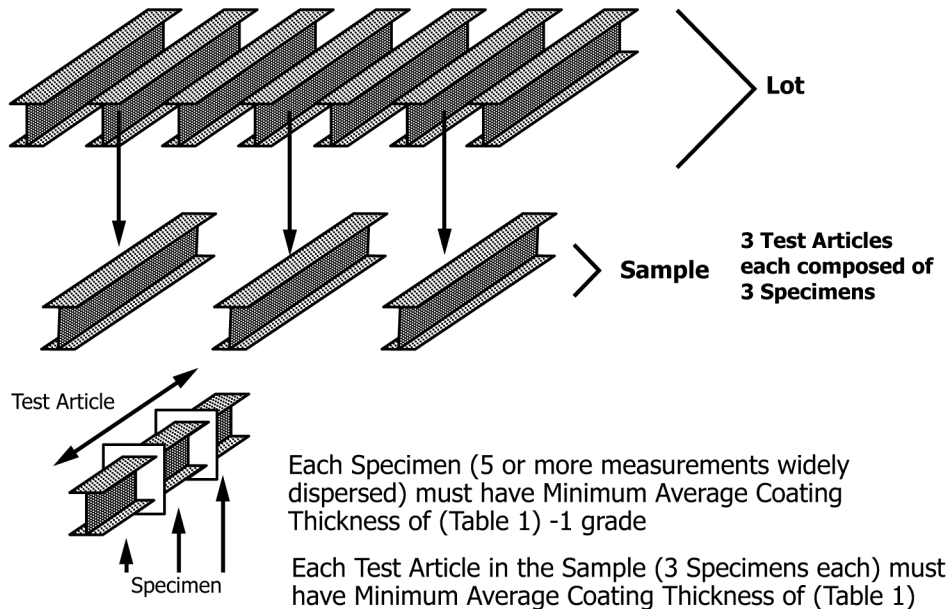
3.2.11 *specimen, n*—the surface of an individual test article or a portion of a test article, upon which thickness measurements are to be performed, which is a member of a lot, or a member of a sample representing that lot. For magnetic thickness measurements, specimen excludes any area of the surface which is subject to processes (such as flame cutting,

TABLE 1 Minimum Average Coating Thickness Grade by Material Category

Material Category	All Specimens Tested Steel Thickness Range (Measured), in. [mm]					
	<1/16 [<1.6]	≥1/16 to <1/8 [≥1.6 to <3.2]	≥1/8 to <3/16 [≥3.2 to 4.8]	≥3/16 to <1/4 [≥4.8 to <6.4]	≥1/4 to <5/8 [≥6.4 to <16.0]	≥5/8 [≥16.0]
Structural Shapes	45	65	75	75	100	100
Strip and Bar	45	65	75	75	75	100
Plate	45	65	75	75	75	100
Pipe and Tubing	45	45	75	75	75	75
Wire	35	50	60	65	80	80
Reinforcing Bar	100	100
Forgings and Castings	100	100	100

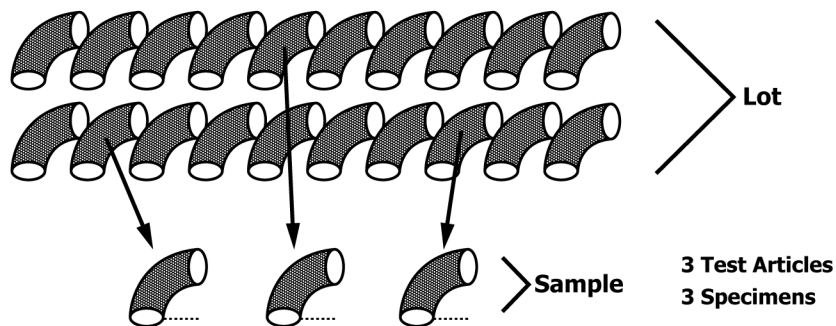
Multi-Specimen Articles

Articles whose Surface Area is greater than 160 sq. in. (100,000 sq. mm)



Single-specimen Articles

Articles whose Surface Area is equal to or less than 160 sq. in. (100,000 sq. mm)



Each Specimen (5 or more measurements widely dispersed) must have Minimum Average Coating Thickness of (Table 1) -1 grade

All Test Articles (Specimens) Together must have Minimum Average Coating Thickness of (Table 1)

FIG. 1 Single- and Multi-Specimen Articles

machining, threading, etc.) that can be expected to result in surface conditions not representative of the general surface condition of the test article, or is disqualified by the measurement method. The minimum average coating thickness grade for any specimen shall be one coating grade below that required for the appropriate material category and thickness in Table 1, which is based on the order of thickness grade values in Table 2. For a unit of product whose surface area is equal to or less than 160 in.² [100 000 mm²], the entire surface area of each test article constitutes a specimen. In the case of an article

containing more than one material category or steel thickness range as delineated in Table 1, that article will contain more than one specimen, as appropriate (see Fig. 1).

3.2.12 *specimen coating thickness, n*—the average thickness from no less than five test measurements on a specimen, when each measurement location is selected to provide the widest dispersion (in all applicable directions) of locations for the steel category of the test article within the confines of the specimen volume.

TABLE 2 Coating Thickness Grade^A

Coating Grade	mils	oz/ft ²	μm	g/m ²
35	1.4	0.8	35	245
45	1.8	1.0	45	320
50	2.0	1.2	50	355
55	2.2	1.3	55	390
60	2.4	1.4	60	425
65	2.6	1.5	65	460
75	3.0	1.7	75	530
80	3.1	1.9	80	565
85	3.3	2.0	85	600
100	3.9	2.3	100	705

^A The values in micrometres (μm) are based on the Coating Grade. The other values are based on conversions using the following formulas: mils = μm × 0.03937; oz/ft² = μm × 0.02316; g/m² = μm × 7.067.

3.2.13 *test article, n*—an individual unit of product that is a member of the sample and that is examined for conformance to a part of this specification.

4. Ordering Information

4.1 Orders for coatings provided under this specification shall include the following:

- 4.1.1 Quantity (number of pieces to be galvanized) and total weight.
- 4.1.2 Description (type and size of products) and weight.
- 4.1.3 ASTM specification designation and year of issue.
- 4.1.4 Material identification (see 5.1) and surface condition or contamination.
- 4.1.5 Sampling plan, if different from 7.3.
- 4.1.6 Special test requirements (see 8.1).
- 4.1.7 Special requirements (special stacking, heavier coating weight, etc.).
- 4.1.8 Tagging or piece identification method.

5. Materials and Manufacture

5.1 *Steel or Iron*—The specification, grade, or designation and type and degree of surface contamination of the iron or steel in articles to be galvanized shall be supplied by the purchaser to the hot-dip galvanizer prior to galvanizing.

NOTE 2—The presence in steels and weld metal, in certain percentages, of some elements such as silicon, carbon, and phosphorus tends to accelerate the growth of the zinc-iron alloy layer so that the coating may have a matte finish with little or no outer zinc layer. The galvanizer has only limited control over this condition. The mass, shape, and amount of cold working of the product being galvanized may also affect this condition. Practice A385/A385M provides guidance on steel selection and discusses the effects of various elements in steel compositions (for example, silicon), that influence coating weight and appearance.

5.2 *Fabrication*—The design and fabrication of the product to be galvanized are the responsibilities of the designer and the fabricator. Practices A143/A143M, A384/A384M, and A385/A385M provide guidance for steel fabrication for optimum hot dip galvanizing and shall be complied with in both design and fabrication. Consultation between the designer, fabricator, and galvanizer at appropriate stages in the design and fabrication process will reduce future problems.

5.3 *Castings*—The composition and heat treatment of iron and steel castings shall conform to specifications designated by the purchaser. Some types of castings have been known to

show potential problems with predisposition to being embrittled during the normal thermal cycle of hot-dip galvanizing. It is the responsibility of the purchaser to heat treat or otherwise allow for the possibility of such embrittling phenomena. The requirements for malleable iron castings to be galvanized shall be as stated in Specification A47/A47M.

5.4 *Zinc*—The zinc used in the galvanizing bath shall conform to Specification B6, or Specification B960, or both. If a zinc alloy is used as the primary feed to the galvanizing bath, then the base material used to make that alloy shall conform to Specification B6, or Specification B960, or both.

5.5 *Bath Composition*—The molten metal in the working volume of the galvanizing bath shall contain not less than an average value of 98.0 % zinc by weight.

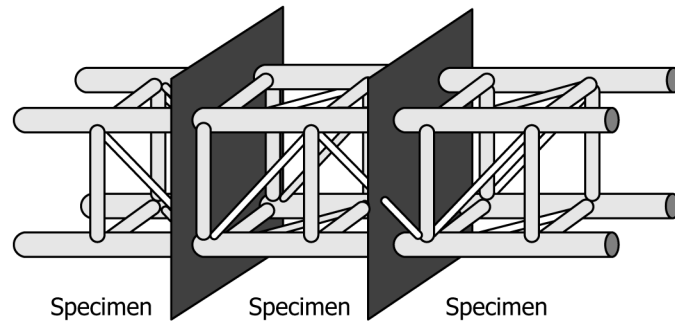
NOTE 3—The galvanizer may choose to add trace amounts of certain elements (for example, aluminum, nickel, and tin) to the zinc bath to help in the processing of certain reactive steels or to enhance the cosmetic appearance of the finished product. The use of these trace elements is permitted provided that the bulk chemistry of the galvanizing bath is at least 98.0 % zinc by weight. The elements can be added to the galvanizing bath as part of a pre-alloyed zinc feed, or they can be added to the bath by the galvanizer using a master feed alloy.

6. Coating Properties

6.1 *Coating Thickness*—The average thickness of coating for all specimens tested shall conform to the requirements of Table 1 for the categories and thicknesses of the material being galvanized. Minimum average thickness of coating for any individual specimen is one coating grade less than that required in Table 1, which is based on the order of thickness grade values in Table 2. Where products consisting of various material thicknesses or categories are galvanized, the coating thickness grades for each thickness range and material category of material shall be as shown in Table 1. In the case of orders in SI units, the values in Table 1, shall be applicable as metric units in micrometres. In the case of orders in inch-pound units, the measured value shall be converted to coating grade units by the use of Table 2. The specification of coating thicknesses heavier than those required by Table 1 shall be subject to mutual agreement between the galvanizer and the purchaser. (Fig. 2 is a graphic representation of the sampling and specimen delineation steps, and Fig. 3 is a graphic representation of the coating thickness inspection steps.)

6.1.1 For articles whose surface area is greater than 160 in.² [100 000 mm²] (multi-specimen articles), each test article in the sample must meet the appropriate minimum average coating thickness grade requirements of Table 1, and each specimen coating thickness grade comprising that overall average for each test article shall average not less than one coating grade below that required in Table 1, which is based on the order of thickness grade values in Table 2.

6.1.2 For articles whose surface area is equal to or less than 160 in.² [100 000 mm²] (single-specimen articles), the average of all test articles in the sample must meet the appropriate minimum average coating thickness grade requirements of Table 1, and for each test article, its specimen coating thickness shall be not less than one coating grade below that required in Table 1, which is based on the order of thickness grade values in Table 2.



NOTE 1—Each specimen comprises nominally one third of the total surface area of the article. A minimum of five measurements should be made within the volume of each specimen, as widely dispersed within that volume as is practical, so as to represent as much as possible, the general coating thickness within that specimen volume.

FIG. 2 Articles Made of Many Components

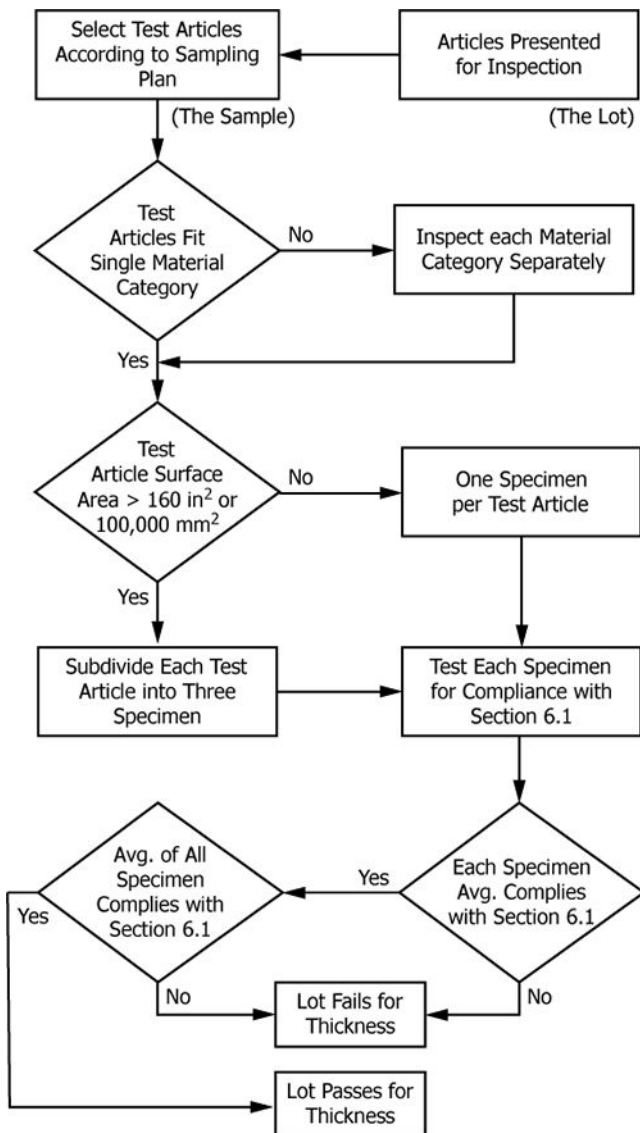


FIG. 3 Coating Thickness Inspection Steps

this specification provided that when those measurements are averaged with the other dispersed measurements to determine the specimen coating thickness grade for that specimen, the requirements of 6.1.1 or 6.1.2, as appropriate are met.

NOTE 4—The coating thickness grades in Table 1 represent the minimum value obtainable with a high level of confidence for the ranges typically found in each material category. While most coating thicknesses will be in excess of those values, some materials in each category may be less reactive (for example, because of chemistry or surface condition) than other materials of the steel category spectrum. Therefore, some articles may have a coating grade at or close to the minimum requirement shown in Table 1. In such cases, the precision and accuracy of the coating thickness measuring technique should be taken into consideration when rejecting such articles for coating thickness below that required by this specification. Purchasers desiring a guarantee of heavier coatings than the minimum thicknesses shown herein should use the special requirements (see 4.1.6) to specify coating thickness grades higher than those shown in Table 1. In addition, the purchaser should anticipate the need for test batches or extra preparation steps, or both, such as blasting before galvanizing or other methods, to attempt to reach the higher requirements with consistency. Some higher-than-standard thicknesses may be impractical or unattainable.

6.2 Finish—The coating shall be continuous (except as provided below), and as reasonably smooth and uniform in thickness as the weight, size, shape of the item, and necessary handling of the item during the dipping and draining operations at the galvanizing kettle will permit. Except for local excess coating thickness which would interfere with the use of the product, prevent surfaces from mating properly, or make it dangerous to handle (edge tears or spikes), rejection for nonuniform coating shall be made only for plainly visible excess coating not related to design factors such as holes, joints, or special drainage problems (see Note 7). Since surface smoothness is a relative term, minor roughness that does not interfere with the intended use of the product such as particulates of dross (Fe/Zn solid particles) in the coating that appear like pimples, or roughness that is related to the as-received (un-galvanized) surface condition, steel chemistry, or steel reactivity to zinc shall not be grounds for rejection (see Note 8). Zinc skimmings (zinc oxide and zinc chloride particulates from the top surface of the zinc bath) may cling to the coating surface after the part is removed from the zinc bath. These zinc skimmings are not cause for rejection as the coating beneath these skimmings is intact and will provide the anticipated corrosion protection. Some zinc skimmings can be brushed off

6.1.3 No individual measurement, or cluster of measurements at the same general location, on a test specimen shall be cause for rejection under the coating thickness requirements of

the surface or will be washed off in the rain or condensation that gathers on the part as it weathers in the atmosphere. Other zinc skimmings may need to be ground off the surface of the coating by the galvanizer without removing zinc to the point that the coating no longer meets the minimum thickness requirement. Surface roughness of articles to be painted or powder coated and the smoothing of the galvanized coating before painting or powder coating shall be mutually determined by the galvanizer and the purchaser. Further preparation of galvanized coatings for painting or powder coating including cleaning, profiling, and outgassing shall be in accordance with Practice D6386 for painting and Practice D7803 for powder coating and are the responsibility of the paint or powder coating applicator. Surface conditions related to deficiencies related to design, detailing, or fabrication as addressed by Practice A385/A385M shall not be grounds for rejection. Surface conditions resulting from the practice of masking shall not be grounds for rejection and are not subject to the requirements of Section 6. The use of masking materials and responsibilities for masking material application and removal shall be subject to mutual agreement between the galvanizer and the purchaser. The zinc coating on threaded components of articles galvanized under this specification shall conform to that required in Specification A153/A153M. Surfaces that remain uncoated after galvanizing shall be renovated in accordance with the methods in Practice A780/A780M unless directed by the purchaser to leave the uncoated areas untreated for subsequent renovation by the purchaser.

6.2.1 Each uncoated area subject to renovation by one of the methods in A780/A780M shall be limited in size. The length and width of the uncoated area shall be allowed to exceed 1 in. [25 mm] in only one of the two dimensions. The figure below depicts the allowable size of uncoated area that can be renovated.

6.2.2 The total of the uncoated areas subject to renovation by one of the methods in A780/A780M on each steel article shall not exceed half of 1 % of the accessible surface area to be hot-dip galvanized on that steel article. The total of the uncoated areas subject to renovation by one of the methods of A780/A780M shall also not exceed 36 in.² per short ton [256 cm² per metric ton] of piece weight. The size of the uncoated area subject to renovation shall only be applicable at the galvanizing facility. Once the parts have left the galvanizing facility there shall be no limit on the size of the area subject to renovation.

NOTE 5—Inaccessible surface areas are those which cannot be reached for appropriate surface preparation and application of repair materials as described in Practice A780/A780M. Such inaccessible areas, for example, would be the internal surfaces of certain tanks, poles, pipes, tubes, and so forth.

NOTE 6—Areas with masking applied before galvanizing are not considered accessible surface areas to be hot-dip galvanized.

6.2.3 The minimum thickness of renovation in the uncoated areas for repairs using zinc metallizing or zinc solder shall be the class required by the thickness grade for the appropriate steel material category in Table 1 in accordance with the requirements of 6.1. The minimum thickness of the renovation in the uncoated areas using paints containing zinc dust shall be 3.0 mils [75 microns] and the maximum thickness of the renovation using paints containing zinc dust shall be 4.0 mils [100 microns].

6.2.4 When uncoated areas requiring renovation exceed the criteria provided in subsection 6.2.1 or 6.2.2, the part shall be rejected and may be stripped of coating and recoated, then re-inspected for uncoated areas. When uncoated areas requiring renovation are inaccessible for repair, the part shall be rejected and may be stripped of coating and recoated then re-inspected for uncoated areas.

NOTE 7—The requirements for the finish of a galvanized product address themselves to a visual type of inspection. They do not address the matter of measured coating thickness variations that can be encountered because of different steels or different thicknesses of a given steel being used in an assembly.

NOTE 8—Items which are prepared for galvanizing by abrasive cleaning will generally develop a thicker coating with a moderately rougher surface.

NOTE 9—The practice of stripping and recoating (6.2.4) is unlikely to remedy uncoated areas resulting from deficiencies related to design, detailing, or fabrication as addressed in 5.2.

6.3 *Threaded Components in Assemblies*—The zinc coating on external threads shall not be subjected to a cutting, rolling, or finishing tool operation, unless specifically authorized by the purchaser. Internal threads are not prohibited from being tapped or retapped after galvanizing. Coatings shall conform to the requirements of Specification A153/A153M.

6.4 *Appearance*—Upon shipment from the galvanizing facility, galvanized articles shall be free from uncoated areas, blisters, flux deposits, and gross gross inclusions. Lumps, projections, globules, or heavy deposits of zinc which will interfere with the intended use of the material will not be permitted. Surface roughness of articles to be painted or

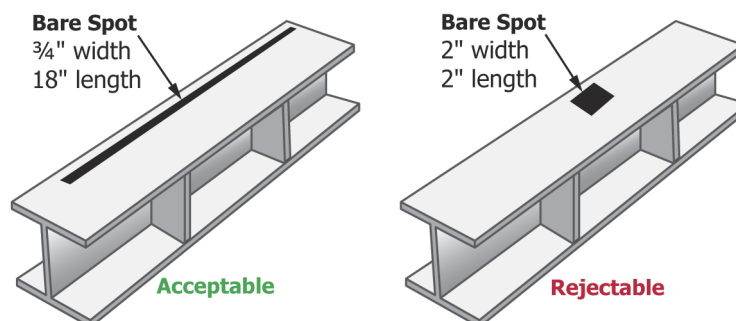


FIG. 4 Uncoated Area Subject to Renovation



powder coated and the smoothing of the galvanized coating before painting or powder coating shall be mutually determined by the galvanizer and the purchaser. Further preparation of galvanized coatings for painting or powder coating including cleaning, profiling, and outgassing shall be in accordance with Practice D6386 for painting and Practice D7803 for powder coating and are the responsibility of the paint or powder coating applicator. Plain holes of 1/2-in. [12.5-mm] diameter or more shall be clean and reasonably free from excess zinc. Marks in the zinc coating caused by tongs or other items used in handling the article during the galvanizing operation shall not be cause for rejection unless such marks have exposed the base metal and the bare metal areas exceed allowable maximums from 6.2.1 and 6.2.2. The pieces shall be handled so that after galvanizing they will not freeze together on cooling.

NOTE 10—Depending upon product design or material thickness, or both, filming or excess zinc buildup in plain holes of less than 1/2-in. [12.5-mm] diameter may occur that requires additional work to make the holes usable as intended.

6.4.1 Subject to mutual agreement between the galvanizer and the purchaser, the purchaser may establish final appearance criteria for Architecturally Exposed Structural Steel (AESS) or any other project-specific aesthetic requirements beyond the requirements of 6.4. These requirements should be clearly defined using project specifications and communicated to the galvanizer in the purchase order.

6.5 *Adherence*—The zinc coating shall withstand handling consistent with the nature and thickness of the coating and the normal use of the article, without peeling or flaking.

NOTE 11—Although some material may be formed after galvanizing, in general the zinc coating on the articles covered by this specification is too heavy to permit severe bending without damaging the coating.

7. Sampling

7.1 Sampling of each lot shall be performed for conformance with the requirements of this specification.

7.2 A lot is a unit of production or shipment from which a sample is taken for testing. Unless otherwise agreed upon between the galvanizer and the purchaser, or established within this specification, the lot shall be as follows: For testing at a galvanizer's facility, a lot is one or more articles of the same type and size comprising a single order or a single delivery load, whichever is the smaller, or any number of articles identified as a lot by the galvanizer, when these have been galvanized within a single production shift and in the same bath. For test by the purchaser after delivery, the lot consists of the single order or the single delivery load, whichever is the smaller, unless the lot identity, established in accordance with the above, is maintained and clearly indicated in the shipment by the galvanizer.

7.3 The method of selection and number of test articles shall be agreed upon between the galvanizer and the purchaser. Otherwise, the test articles shall be selected at random from each lot. In this case, the minimum number of test articles from each lot shall be as follows:

Number of Pieces in Lot	Number of Test Articles
3 or less	all
4 to 500	3
501 to 1 200	5
1 201 to 3 200	8
3 201 to 10 000	13
10 001 and over	20

NOTE 12—Where a number of identical items are to be galvanized, a statistical sampling plan may be desired. Such a plan is contained in Test Method B602 which addresses sampling procedures for the inspection of electrodeposited metallic coatings and related finishes. If Test Method B602 is used, the level of sampling shall be agreed upon between the galvanizer and the purchaser at the time the coating order is placed.

7.4 A test article which fails to conform to a requirement of this specification shall not be used to determine the conformance to other requirements.

8. Test Methods

8.1 *Test Requirements*—The following tests shall be conducted to ensure that the zinc coating is being furnished in accordance with this specification. The specifying of tests for adhesion and embrittlement shall be subject to mutual agreement between the galvanizer and purchaser. Visual inspection of the coating shall be made for compliance with the requirements.

8.2 *Thickness of Coating Test*—The thickness of coating is determined by one or more of the three methods described as follows.

8.2.1 *Magnetic Thickness Measurements*—The thickness of the coating shall be determined by magnetic thickness gauge measurements in accordance with Practice E376 unless the methods described in 8.2.2, 8.2.3, or 8.2.4 are used. For each specimen (as described in 3.2.11) five or more measurements shall be made at points widely dispersed throughout the volume occupied by the specimen so as to represent as much as practical, the entire surface area of the test specimen. The average of the five or more measurements thus made for each specimen is the specimen coating thickness.

NOTE 13—Specimens containing a mixture of initial surface conditions before galvanizing such as roughness, pitting, cast surfaces, or newly machined surfaces are likely to result in areas of varying coating thickness after galvanizing despite identical steel chemistry. Consider these expected variations when obtaining dispersed measurements to accurately represent the specimen. For example, castings machined to remove extraneous material before galvanizing are likely to experience thinner coatings in the machined area.

NOTE 14—Fabrications containing a mixture of steel compositions within the same material category and thickness range can present a challenge in developing a galvanized coating that meets the thickness requirements of 6.1 for steels of a non-reactive composition when attempting to avoid excessively thick coatings on steels with a reactive steel composition. In these cases, the galvanizer and the purchaser should agree on a plan of action. Practice A385/A385M provides guidance on steel selection and discusses the effects of various elements in steel compositions (for example, silicon), that influence coating thickness.

8.2.1.1 For articles whose surface area is greater than 160 in.² [100 000 mm²] (multi-specimen articles as described in 3.2.8), the average of the three specimen coating thickness grades comprising each test article is the average coating thickness for that test article. A specimen must be evaluated for



each steel category and material thickness within the requirements for each specimen of the test article.

8.2.1.2 For articles whose surface area is equal to or less than 160 in.² [100 000 mm²] (single-specimen articles as described in 3.2.10), the average of all specimen coating thickness grades is the average coating thickness for the sample.

8.2.1.3 In the case of threaded components, the thickness of coating shall be made on a portion of the article that does not include any threads.

8.2.1.4 The use of magnetic measurement methods is appropriate for larger articles, and is appropriate for smaller articles when there is sufficient flat surface area for the probe tip to sit flat on the surface using Practice E376.

8.2.2 *Stripping Method*—The average weight of coating shall be determined by stripping a test article, a specimen removed from a test article, or group of test articles in the case of very small items such as nails, etc., in accordance with Test Method A90/A90M unless the methods described in 8.2.1, 8.2.3, or 8.2.4 are used. The weight of coating per unit area thus determined is converted to equivalent coating thickness values in accordance with Table 2 (rounding up or down as appropriate). The thickness of coating thus obtained is the test article coating thickness, or in the case of a specimen removed from a test article, is the specimen average coating thickness.

8.2.2.1 The stripping method is a destructive test and is appropriate for single specimen articles, but is not practical for multi-specimen articles.

8.2.3 *Weighing Before and After Galvanizing*—The average weight of coating shall be determined by weighing articles before and after galvanizing, subtracting the first weight from the second and dividing the result by the surface area unless the methods described in 8.2.1, 8.2.2, or 8.2.4 are used. The first weight shall be determined after pickling and drying and the second after cooling to ambient temperature. The weight of coating per unit area thus determined is converted to equivalent coating thickness values according to Table 2 (rounding up or down as appropriate). The thickness of coating thus obtained is the test article coating thickness.

8.2.3.1 The weighing before and after method is appropriate for single-specimen articles, but is not practical for multi-specimen articles.

NOTE 15—Both the stripping method and the weighing before and after method do not take into account the weight of iron reacted from the article that is incorporated into the coating. Thus, the methods may underestimate coating weight (and therefore the calculated thickness) by up to 10 %. The accuracy of both methods will be influenced by the accuracy to which the surface area of the articles tested can be determined.

8.2.4 *Microscopy*—The thickness of coating shall be determined by cross-sectional and optical measurement in accordance with Test Method B487 unless the methods described in 8.2.1, 8.2.2, or 8.2.3 are used. The thickness thus determined is a point value. No less than five such measurements shall be made at locations on the test article which are as widely dispersed as practical, so as to be representative of the whole surface of the test article. The average of no less than five such measurements is the specimen coating thickness.

8.2.4.1 The microscopy method is a destructive test and is appropriate for single-specimen articles, but is not practical for multi-specimen articles.

8.2.5 *Referee Method*—In the event of a dispute over thickness of coating measurements, the dispute shall be resolved as follows:

8.2.5.1 For multi-specimen articles, a new sample shall be taken randomly from the lot of material, which has twice the number of test articles as the sample which failed to conform to this specification. If the lot size is such that the sample size cannot be doubled, then the sample size shall be as previous, but the number of widely dispersed sites at which measurements were made shall be doubled, and these sites will constitute the new sample. This new sample shall be measured using magnetic thickness gauges which have been calibrated for accuracy against reference material thickness standards. If the lot is found to be nonconforming by the new sample, the galvanizer has the right to sort the lot for conforming articles by individual test, to re-galvanize non-conforming articles, or to renovate the nonconforming articles in accordance with 6.2.

8.2.5.2 For single-specimen articles, a new sample shall be taken randomly from the lot of material, which has twice the number of test articles as the sample which failed to conform to this specification. The test method for the new sample shall be selected by mutual agreement between the purchaser and galvanizer. If the lot is found to be nonconforming by the new sample, the galvanizer has the right to sort the lot for conforming articles by individual test, to re-galvanize non-conforming articles, or to renovate the nonconforming articles in accordance with 6.2.

8.3 *Adhesion*—Determine adhesion of the zinc coating to the surface of the base metal by cutting or prying with the point of a stout knife, applied with considerable pressure in a manner tending to remove a portion of the coating. The adhesion shall be considered inadequate if the coating flakes off in the form of a layer of the coating so as to expose the base metal in advance of the knife point. Do not use testing carried out at edges or corners (points of lowest coating adhesion) to determine adhesion of the coating. Likewise, do not use removal of small particles of the coating by paring or whittling to determine failure.

8.4 *Embrittlement*—Test for embrittlement shall be made in accordance with Practice A143/A143M. These tests shall not be required unless strong evidence of embrittlement is present.

9. Inspection, Rejection, and Retest

9.1 *Inspection by the Galvanizer*—It is the responsibility of the galvanizer to ensure compliance with this specification. This shall be achieved by an in-plant inspection program designed to maintain the coating thickness, finish, and appearance within the requirements of this specification unless the inspection is performed in accordance with 9.2.

9.2 *Inspection By the Purchaser*—The purchaser shall accept or reject material by inspection either through the galvanizer's inspector, the purchaser's inspector, or an independent inspector. The inspector representing the purchaser shall have access at all times to those areas of the galvanizer's facility



which concern the application of the zinc coating to the material ordered while work on the contract of the purchaser is being performed. The galvanizer shall afford the inspector all reasonable facilities to satisfy him that the zinc coating is being furnished in accordance with this specification.

9.3 Location—The material shall be inspected at the galvanizer's plant prior to shipment. However, by agreement the purchaser is not prohibited from making tests which govern the acceptance or rejection of the materials in his own laboratory or elsewhere.

9.4 Reinspection—When inspection of materials to determine conformity with the visual requirements of 6.2 warrants rejection of a lot, the galvanizer is not prohibited from sorting the lot and submit it once again for acceptance after he has removed any nonconforming articles and replaced them with conforming articles.

9.5 The sampling plan that was used when the lot was first inspected shall be used for resampling of a sorted lot. By mutual agreement, the galvanizer is not prohibited from submitting the lot remaining after sorting and removing non-

conforming articles without replacement of the nonconforming articles. In such case, the now-smaller lot shall be treated as a new lot for purposes of inspection and acceptance.

9.6 Materials that have been rejected for reasons other than embrittlement are not prohibited from being stripped and regalvanized and again submitted for inspection and test at which time they shall conform to the requirements of this specification.

10. Certification

10.1 When specified in the purchase order or contract, the purchaser shall be furnished certification that samples representing each lot have been either tested or inspected as directed by this specification and the requirements have been met. When specified in the purchase order or contract, a report of the test results shall be furnished.

11. Keywords

11.1 coatings—zinc; galvanized coatings; steel products—metallic coated; zinc coatings—steel products

APPENDIX

(Nonmandatory Information)

X1. DETERMINATION OF MATERIAL CATEGORIES AND STEEL THICKNESS

X1.1 Examples of Material Category Classifications for Common Fabrications:

X1.1.1 Bar grating belongs to the category “strip and bar”.

X1.1.2 Handrail belongs to the category “pipe and tubing,” etc.

X1.1.3 Poles made from bent plate are not “structural shapes” but belong to the category “plate”.

X1.1.4 Rolled beams belong to the category “structural shapes” while beams fabricated from plate (for example, plate girders) belong to the category “plate”.

X1.1.5 Rolled angles belong to the category “structural shapes” while angles fabricated from welded plate belong to the category “plate”.

X1.2 Steel Thickness:

X1.2.1 Steel thickness is determined using measured steel thickness as stated in Table 1. The use of nominal steel thickness for pipe, tube and plate can sometimes result in

incorrect identification of the average coating thickness requirement in 6.1 due to relatively significant differences between the measured and nominal steel thickness.

X1.2.2 If the measured thickness before galvanizing is unavailable or otherwise impractical, one alternative method is to measure the part thickness after galvanizing to closely approximate the steel thickness. For specimens inaccessible for steel thickness measurement, an alternative method is to refer to the nominal steel thickness or dimensions from project drawings to approximate the steel thickness.

X1.2.3 For tapered designs, it is intended the steel thickness measurement is obtained from the location of the thinnest steel section.

X1.2.4 For structural shapes containing variations in steel thickness among flanges, webs, or legs, it is intended the steel thickness measurement is obtained from the location of the thinnest steel section.

X1.2.5 For expanded metal, steel thickness is determined using the measured sheet thickness value.



SUMMARY OF CHANGES

Committee A05 has identified the location of selected changes to this standard since the last issue (A123/A123M – 17) that may impact the use of this standard. (Approved May 1, 2024.)

- (1) All instances of “gage” changed to “gauge”.
- (2) Added missing metric designations to ASTM Specifications.
- (3) Corrected arrow direction for “lot passes thickness” in Fig. 3.
- (4) Table 1 was revised.
- (5) Added Note 9.
- (6) Note 13 and Note 14 added to 8.2.1. Subsequent numbers for notes updated.
- (7) Added 3.2.6 to Section 3.
- (8) Clarified the calculation of max area subject to renovation in 6.2 and Note 6.
- (9) Added 3.2.5 to Section 3.
- (10) Added 6.4.1, and added additional verbiage to 6.2.
- (11) Additional verbiage added to 3.2.11, 6.1, 6.1.1, and 6.1.2.
- (12) Added Appendix X1.

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