









SC	DESCRIPTION	CAUSE	EFFECT / REMEDY RESPONSIBILITY	A/R/N C/REP	EXAMPLE
23	REMOVAL OF ZINC COATING BY EXCESSIVE CLEANING Unless otherwise agreed, the galvanizer will limit cleaning of the final coating by mechanical means to that required in the specification.	Excessive cleaning of the coating, particularly the edges, by mechanical methods, can result in uncoated areas.	The affected areas usually only appear after the component is installed. Care should be exercised by the galvanizer to avoid over cleaning.	R	
				G / B	
24	ROLLING DEFECTS IN STEEL These defects may be broadly classified as surface discontinuities in the steel that have been elongated during rolling.	Steel may occasionally include laminations, laps, folds and non-metallic impurities, which result in slivers rolled into the metal surface. Defects of this type are sometimes detected before or after pickling, but may only become apparent after hot dip galvanizing.	Surface flaws in the base material may be removed by local grinding after hot dip galvanizing followed by repair of the affected surface. Minor surface defects will not adversely influence coating life.	A	
				S	
25	ROUGH COATINGS, CAUSED BY STEEL SURFACE CONDITIONS	Rough surfaces, typical of coatings on corroded steel surfaces, can be hot dip galvanized satisfactorily. The coating will, however, reflect the texture of the substrate. Other causes of rough surfaces include uneven cold working, overpickling, a high galvanizing temperature and / or extended immersion in the molten zinc.	The rougher surface will produce a thicker coating and result in a longer service life.	A	
26	ROUGH HEAVY COATINGS, CAUSED BY A ROUGH SURFACE AND / OR THE CHEMICAL COMPOSITION OF THE STEEL. "TREE BARK EFFECT"	Rough, heavy coatings refer to hot dip galvanized components showing markedly rough surfaces. This can include coatings that have a generally rough surface and, in some cases, groove type surface configurations, "tree bark effect" caused by variations in surface steel analysis.	The thicker coating produced will provide greater corrosion protection. Except when the coating tends to flake off or delaminate see SC 15.	A / R	
27	ROUGH HEAVY COATINGS CAUSED BY INSUFFICIENT CENTRIFUGING	Efficient centrifuging, will generally remove excess zinc and provide a smooth and attractive exterior.	Provided the steel / casting surface is reasonably smooth, correctly centrifuged articles will provide an acceptable finish.	R	
				G	
28	STAINS CAUSED BY WEEPING.	The salts from acid or flux that have penetrated porous welding or between contact surfaces during pickling can weep after hot dip galvanizing and water quenching, producing a stained area.	The stains can be easily removed by means of bristle brushing. Should the component be destined for a corrosive area, the crevice should be sealed with a sealant after cleaning.	A	
				D/B	