









SC	DESCRIPTION	CAUSE	EFFECT / REMEDY RESPONSIBILITY	A/R/N C/REP	EXAMPLE
35	UNGALVANIZED AREA IN THE VICINITY OF A WELD	A localised ungalvanized area near a weld can be caused by weld slag deposit, weld porosity or weld undercut. Oxide deposits and residues from welding are resistant to normal pickling acids and must be removed before the work is pickled and hot dip galvanized.	Weld slag deposits should be removed by the fabricator by means of abrasive blast cleaning. The deposit can also be removed by proper chipping or wire brushing. Shielded arc welding as opposed to stick welding is preferred for components which are to be hot dip galvanized.	R / N	
				REP if necessary B	
36	USE CONVENTIONAL FIXING METHODS SUCH AS BOLTS AND NUTS, OR REPAIR DAMAGED COATINGS CAUSED BY WELDING OR NON-CONVENTIONAL FIXING METHODS.	Conventional drilling and bolting after hot dip galvanizing is preferred. Should welding or a non-conventional method of fixing be used, resulting in damage to the coating, an approved repair method is necessary.	Coating repair can be done by zinc metal spraying or a zinc rich paint or epoxy, providing the product conforms to the requirements of the specification. (See Coating Repair Procedures).	A	
				REP D / B	
37	WELD SPATTER. Weld spatter is oxidised, normally spherical expelled weld metal, that is fused or not onto the surrounding material during welding.	Weld spatter is caused by weld pool explosions when improper welding parameters are used, or if the material is dirty or contaminated.	Loosely adherent weld spatter should be removed prior to hot dip galvanizing. Although not acceptable in terms of the specification the presence of tightly adherent weld spatter after hot dip galvanizing will not affect the corrosion resistant properties of the coating.	A / N B	
38	WET STORAGE STAIN OR WHITE RUST. Wet storage stain or white rust as it is commonly called, is a white voluminous deposit that is occasionally found on the surface of a freshly galvanized coating.	Wet storage stain (zinc hydroxide) is formed on freshly galvanized surfaces which are in close contact in presence of moisture. Freshly galvanized coatings react with the environment until such time as a stable zinc carbonate film is formed on the coating surface.	Wet storage stain ceases when the cause is eliminated. If the coating thickness at the affected area is equal to, or greater than the minimum required in the specification, it is not a cause for rejection, other than for aesthetic reasons. The latter is subject to discussion with the end user. Customer is to exercise caution during transport and storage.	A	
				C if necessary G / B	
39	ZINC METAL SPRAYED REPAIR APPLIED TO INADEQUATELY BLASTED SURFACES OR NOT WIRE BRUSHED AFTER APPLICATION.	In order for zinc metal spraying to adhere on application, the damaged galvanized surface must be adequately blasted. As it is difficult not to overspray, excess zinc metal spray loosely adheres to the surrounding coating.	Prepare surface for repair by adequate blasting. Loosely applied zinc metal sprayed coating at the perimeter of the repair should be removed by wire brushing. If not removed, there is no compromise in the corrosion resistance.	A	
				C G / B	
40	ZINC SPLATTER. Splashes and flakes of loosely adherent zinc, caused by moisture on the steel surface when hot dip galvanizing.	When hot dip galvanizing an unusually deep fabrication by double dipping, moisture on the surface of the steel contacts with the molten zinc causing splashes of zinc to loosely adhere to the already hot dip galvanized surface.	The loosely adherent zinc splashes are easily removed. An experienced galvanizer can ensure the coating overlap on double end dipped surface, is not visible.	A	
				C G	