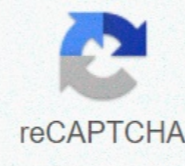


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Astm d6386 pdf

Reading to Free Preview Page 3 is not shown in this preview. Hot galvanized provides excellent corrosion protection in a pH range from 7 to 13, but zinc corrosion increases as pH becomes more acidic (less than 7) or more alkali (more than 13). When galvanized is exposed to lower or higher pH ranges, it should be painted. Regardless of PH, painting should also be done when aesthetics are important. Unfortunately, when painting galvanized, paint failures may occur (Photo 1), but it is easy to avoid with proper surface preparation. Photo 1 - Typical paint failure of galvanized due to lack of surface preparation. Surface preparation is key to ensuring adhesion success and coating performance. The required degree of readiness depends on the answers to these four questions: Was Galvanized passive? Is Galvanized new? Is Galvanized partially old or impaired? Is Galvanized old? Pacifying treatments: Pacification storage is a common practice used during galvanization to reduce the formation of white spots. Unfortunately, galvanized passive treatments (especially chromate treatments) can prevent coating adhesion. If galvanized steel is to be painted, galvanized steel must be informed first in order to remove the passivity phase. Most often, however, the parts have already been galvanized and the user does not know if a treatment has been applied. In case of doubt, the surface should be analyzed. SSPC-SP16 offers a suitable procedure for lightly corrosive jet cleaning of coated and exposed galvanized steel, stainless steels and non-iron metals. Standard 4.3.3. Mark three adjacent areas on the galvanized part, about 6.45 cm 2 (1 inch 2) Leave an area intact, wash the second and third areas with solvent, and also thoroughly and completely clean the third area with sandpaper. Using a single or pipette, saturate a cotton tu cloth with copper sulfate solution and apply it to all three areas, or apply solutions directly to all three areas. If all three areas immediately return to the decision, there will be no pacification on the surface. If the first area does not turn black within 10 seconds, and the second and third fields immediately turn black, There is passivation on the surface with the possible exception of light fat. If the first and second areas do not turn black within 10 seconds, and the third area does so immediately, there is some kind of passiator. If you have mechanical cleaning is usually necessary to remove it, but we recommend that some cleaning solutions described below will also remove some treatments. Before use, it is recommended to apply the cleaner of some areas, then the tests described above to determine whether the passivation treatment has been removed. If the project schedule allows, it is required to eliminate 12 to 18 months of exposure of air before painting, as well as any treatment that may be available. New and partly aged galvanized: If the galvanized period is less than about 48 hours, it may be possible to cover it as it is, but if you are exposed outdoors between a few days and about a year (partially aged or impaired), surface preparation will be necessary. Two commonly used methods for preparing galvanized are cleaning with a mixture of phosphoric acid/detergent and cleaning with abrasive jet. Acid solutions are used to clean, over-direct and rough the surface for proper coating adhesion. The solution is applied to the surface, usually rubbed with synthetic abrasive pad, thoroughly rinsed and dried. Abrasive jet cleaning is carried out in accordance with SSPC-SP16. Excerpts from some standard paragraphs describing the naked galvanized, uncovered cleanliness are repeated below. The prepared sentences meet the criteria for the pictures left on the surface and do not apply to this article. 2.1 The non-iron metal surface cleaned with a slightly corrosive jet must be cleaned of all oil, grease, dirt, dust, metal oxides (corrosion products) and other visible foreign materials when viewed without increase... Bare metal surfaces must have a profile of at least 19 microns (0.75 mils). 2.1.1 The entire surface must be exposed to the abrasive jet to achieve the specified degree of cleaning and to create a dense and smooth surface profile on the bare metal surface. Peaks and valleys on the surface should form a continuous pattern, leaving smooth areas and roughness profile 2.1.2... If the surface profile is not specified in the acquisition documents, the selected abrasive must be rough to the extent required by the coating data sheet to apply the cleaned surface. Paragraph 4.3.1 of the standard, removal of storage stains caused by demyding by means other than coring jet cleaning. The time it takes to remove the jet with cleaning can damage galvanized. Other methods are discussed in a non-mandatory attachment. Additional Section A3, a nylon and water brush of salts from storage stains caused by demyd, or a diluted solution of acetic acid or citrus, lemon juice or white vinegar, shows that a large amount of water can be removed following a rinse. Annex's Section A8.1 shows that jet cleaning is done with relatively low pressure nozzles (A6.2) and a softer abrasive with Mohs hardness of 5 or less to reduce the risk of damage (A8.1.1). Ek's Section A9 recommends that the galvanized thickness be measured again before the jet cleaning and after jet cleaning to confirm that it meets the specified thickness. Thickness requirements can be found in purchase documents or ASTM A123, Standard Specification for Zinc Coatings in Medium and Large Iron and Steel Products (Hot Galvanized) or ASTM A153/153M in Small Iron and Steel Parts and Parts, Zinc Coating Specification (Hot Galvanized). Additional (A9.2) warns that in the presence of im of im, zinc oxides can quickly form on the surface after preparation, so they should remain dry and painted as soon as possible. The same recommendations (where steel temperature is highest) apply to galvanized to maintain a minimum difference of 5oF (3oC) between surface temperature and deer point temperature when steel is being prepared. Aged galvanized : when galvanized is exposed to weather conditions for 12-18 months, the surface will be rusted and can usually be prepared for pressure washing. The key is to remove dirt and debris from the surface, as well as zinc salts, and verify that the surface is opaque (photo 2). Photo 2: Galvanized exterior surfaces are likely to be old and paintable after pressure washing to remove salts, but consider the lack of oxidation (red arrow). A paint test in a patch-shaped area should be carried out to determine whether adhesion is suitable without roughness and opacity on the surface, depending on the steel condition, it may be suitable for a pressure wash of 3,000 psi with a rotating nozzle, but it is better to apply a coating test patch after cleaning skin and check adhesion to make sure. If there is any doubt about coating adhesion, any of the methods described above should be used for partially impaired galvanized (chemical cleaner or SP-16 Brush-Off Blast). Conclusion: Most overlay errors galvanized is the result of poor adhesion of the coating to galvanized. Poor adhesion often causes a lack of proper galvanized roughness, an abundance of zinc salts under the coating film, or the presence of a pacifying treatment that inhibits coating adhesion. When properly prepared, the coatings will adhere well to galvanized and improve the aesthetic and corrosion protection offered with galvanized. This article describes some common methods or preparation of galvanized for painting. Other methods are described in standards: ASTM D6386, zinc coated iron and steel products (hot galvanized) and standard application for surface preparation for hardware painting. ASTM D7396 is the standard guide for the preparation of new, continuous zinc coated surfaces (galvanized steel) for painting. KTA-Tator, Inc. is a member of the Ken Trimmer special collaboration KTA-Tator, Inc. Chairman SSPC Surface Preparation Committee and SSPC Visual Standards Committee, as well as the SSPC and ASTM D01 Standards Review Committee, and is responsible for developing, reviewing and approving the standards described in this article. You can get in touch at this email address, which is protected from spam bots. JavaScript must be enabled to view it. 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