

including washers shall be hot dipped galvanized to give a minimum coating weight of 305g/m<sup>2</sup> of galvanized surface. The minimum zinc coating weight of all other galvanized coatings shall be 610g/m<sup>2</sup> of galvanized surface.

- B. Hot dip galvanizing shall be carried out after completion of all welding, drilling, grinding and other fabrication activities associated with the items to be galvanized. In particular welding of galvanized items after galvanizing is not permitted. The zinc coating shall be uniform, clean and smooth.
- C. All galvanized surfaces to receive coatings shall have corrosion products removed by non-metallic inert abrasives and shall be thoroughly cleaned. The surfaces shall be chemically etched with an approved mordant solution. The etched surface shall uniformly darken to confirm etching has taken place.
- D. Coating shall be an approved epoxy suitable for over coating galvanizing with a minimum dry film thickness of 100 microns. For steelwork exposed to sunlight a polyurethane acrylic finish coat with a minimum dry film thickness of 40 microns shall be applied.
- E. Drying and over coating times shall conform to the coating manufacturer's recommendations. Sequential coatings shall be of contrasting colours so that it can be readily identified when each stage of the work is completed.
- F. Generally, all liquid applied coatings shall be applied by airless spray. Brush application of a stripe coat shall be used to ensure adequate film thickness at corners, edges and welds etc.

### **1.3.7 Coating General Requirements**

- A. Prior to the application of coatings and periodically as work progresses the services of the manufacturer's technical representative must be provided at the work site as often as deemed necessary by the Engineer to advise on all phases of the work. This service shall be provided at no cost.
- B. The Contractor shall follow the manufacturer's recommendations for specific procedures and details not specified herein at no additional cost.
- C. The following conditions shall apply wherever coating work is being carried out:
  - 1. Sufficient lighting to the approval of the Engineer shall be provided and used whenever work is in progress.
  - 2. Forced draught ventilation to the approval of the Engineer shall be provided and used whenever work is in progress.