

All surface defects in the steel including cracks, surface laminations, laps and folds shall be removed in accordance with EN 10113. All drilling, cutting, welding, forming, unit members and assemblies shall be completed before the items are galvanized. The surface of the steel to be galvanized shall be free from welding slag, paint, oil, grease and similar contaminants.

The additional weight of the items after being galvanized shall be not less than 700 gra per square meter of galvanized surface in line with TS EN 1561 Any kind of galvanized items to be used for the Works shall be met at least this requirement and the Contractor shall submit the relevant certificate to the Engineer for approval.

During off-loading and erection utmost care must be taken in order to avoid any damages to the galvanized surfaces. Galvanized items in stock shall be stacked so as to provide adequate ventilation to avoid wet storage staining.

Small areas of damaged galvanized coating may according to agreement with the Engineer in every case, be restored by:

- Cleaning of the area of any weld slag and thoroughly brushing to provide a clean surface
- Application of two coats of zinc-rich paint or application of a low melting point zinc alloy repair rod or powder to the damaged area, which is heated at 300°C.

Where galvanized steel will be in contact with aggressive solutions and/or atmospheres, the galvanized surfaces shall receive further protection by painting in accordance with the paint specifications given below.

The geometry of galvanized steel parts shall be thoroughly checked after galvanising. Any deformations shall be corrected without damaging the zinc layer.

Inspection and Documentation of Hot Dip Galvanising

The inspection and quality assurance of the hot dip galvanising carried out by the Contractor shall be in conformity with EN ISO 1461. Documentation for this inspection and quality assurance shall be issued and become part of the Quality Assurance documentation. After components have become hot dip galvanised, machining is not allowed.

7.2.3 Painting in particular locations

The painting specifications are applicable to metal surfaces in the below mentioned locations:

A. Indoor location

The surfaces are not liable to liquid splashing or aggressive atmospheres.

B. Outdoor location

The surfaces are liable to rain and/or splashing from non-aggressive liquids. The surfaces are not liable to aggressive atmospheres.

C. Immersed location

The surfaces are below liquid level in aggressive or non-aggressive solutions, or the surfaces are liable to aggressive atmospheres.