

HOT DIP GALVANIZED PROCESS
MINIMUM ZINC WEIGHT / COMPARISON ON VARIOUS STANDARDS

STANDARD	PRODUCTS TO BE GALVANIZED		MINIMUM ZINC WEIGHT ON SAMPLE		MINIMUM ZINC WEIGHT ON EACH SPECIMEN OF THE SAMPLE	
	Nature	Thickness (mm)	g/m ²	Thickness (µm)	g/m ²	Thickness (µm)
FRANCE NFA 91-121	Steel	e<1	350	49	300	42
		1≤e<3	400	56	350	49
		3≤e<5	450	63	400	56
		e≥5	500	70	450	63
INTERNATIONAL STANDARD ISO 1461	Steel	e<1,5	325	45	250	35
		1,5≤e≤3	395	55	325	45
		3<e≤6	505	70	395	55
		e>6	610	85	505	70
EUROPEAN STANDARD CEN	Steel	e<1,5	325	45	250	35
		1,5≤e≤3	395	55	325	45
		3<e≤6	505	70	395	55
		e>6	610	85	505	70
UNITED STATES ASTM A-123	Steel	0,76≤e<1,6	336	47	259	37
		1,6≤e<3,2	458	65	381	54
		3,2≤e<6,4	610	86	549	77
		e≥6,4	702	99	610	86
UNITED KINGDOM BS 729	Steel	1≤e<2	335	48	-	-
		2≤e<5	460	66	-	-
		e≥5	610	87	-	-
GERMANY DIN 50976	Steel	e<1	360	50	325	45
		1≤e<3	400	55	360	50
		3≤e<6	500	70	430	60
		e≥6	610	85	540	75
CANADA G 164	Steel	1≤e<2	260	37	-	-
		2≤e<3	400	57	-	-
		3≤e<4	500	71	-	-
		4≤e<5	560	80	-	-
		e≥5	610	87	-	-
AUSTRALIA AS 1650	Steel	e<2	300	43	-	-
		2≤e<5	450	63	-	-
		e≥5	600	85	-	-
SINGAPORE SS 117	Steel	e<1	350	50	300	43
		1≤e<5	Upon agreement between parties			
		e>5	500	71	450	64
SWEEDEN SS 3583	Steel	1<e≤3	630	60	360	50
		3<e≤6	610	85	500	70
		e>6	685	95	610	85
SPAIN UNE 37-508	Steel	e<1	360	50	306	43
		1≤e<3	400	55	340	47
		3≤e<6	500	70	425	59
		e≥6	610	85	550	76
BELGIUM NBN I 07-002?	Steel	e<1	275	39	240	34
		1≤e<3	350	50	300	43
		3≤e<5	450	64	400	57
		e≥5	600	86	550	79
NETHERLANDS NEN 1275	Steel	e≤1	350	50	300	45
		1<e<5	350	50	300	45
		e≥5	500	70	450	65
		Ø≥12				
ITALY UNI 5744	Steel	1≤e≤3	430	60	360	50
		3<e≤6	540	75	470	65
		e≥6	610	85	540	75