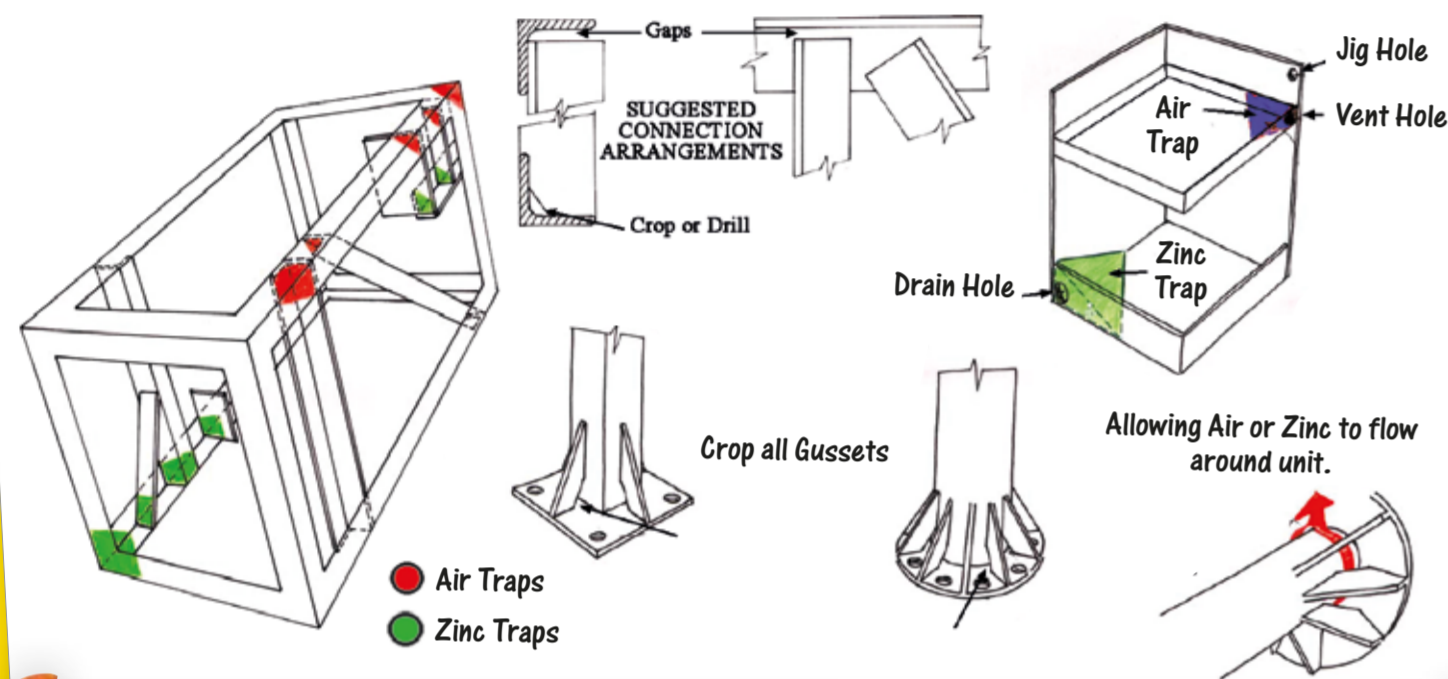


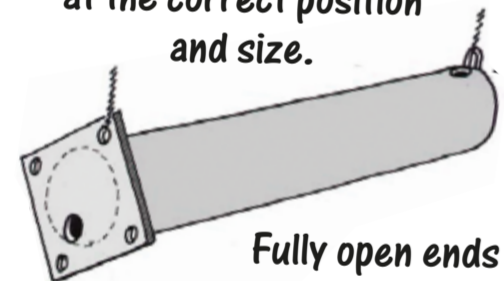
# “DO'S AND DON'TS”

Webforge has put together this list of “Do's and Don'ts” for successful hot dip galvanising as a quick and easy-to-read reference to help you achieve the best results. We invite you to call us with any queries not covered here, and to also view the extensive information we have on our Website.

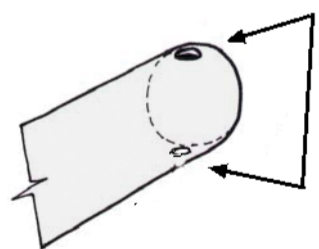
## DRAINING AND VENTING



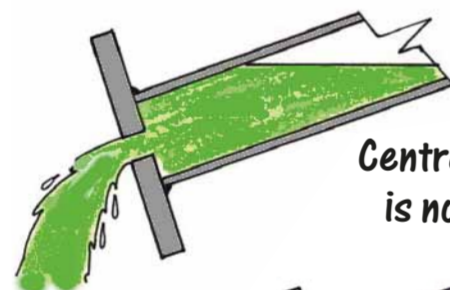
Open end or Drain hole at the correct position and size.



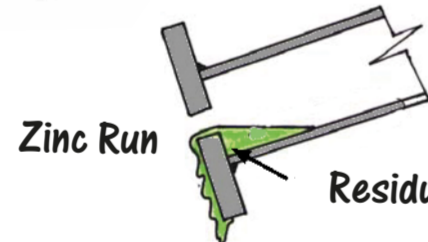
Fully open ends or vent hole with lifting lug.



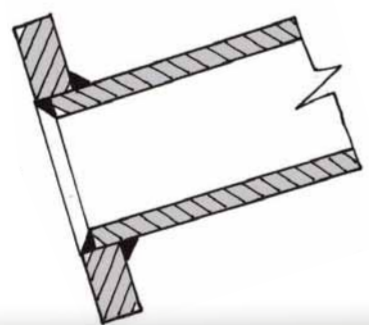
If no lug is possible, opposite holes will be required for jiggling (rigging)



Centre hole for drainage is not recommended.



Zinc Run Residual Zinc



Suggested design for flanged hollow sections

## SANDBLASTING

The following items will require sandblasting prior to being Hot Dip Galvanized!

- Items that have paint on them.
- Steel piping that is coated with a lacquer
- Cast Iron products (consult with Galv Office First)
- Items that are made of high strength alloy steels
- Items that require coating thicknesses over and above AS/NZS 4680 (2006) Standards

If you are unsure please talk to our representatives for further information.

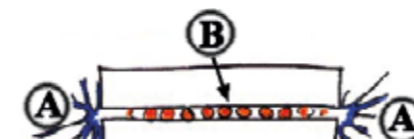
## OVERLAPPING SURFACES



Liquid flux penetrates between surfaces during the precleaning process.



The flux salts absorb moisture from the atmosphere and weep out, staining the adjacent galvanizing coating. A wire brush off will usually solve the problem.

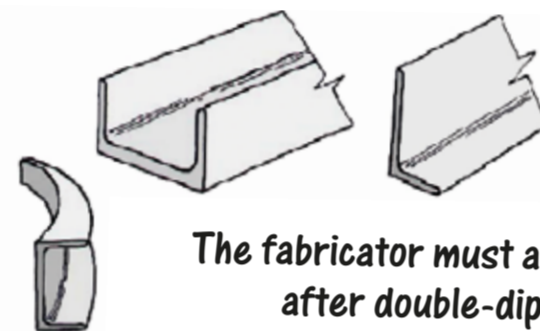


Heat of the galvanising bath will: A. Cause rapid expulsion (steam) of the liquid flux, resulting in “spoil” around the joint and B. Leaves dry anhydrous (moisture absorbing) flux salts in the cavity.



Induced corrosion may take place in some larger entrapments.

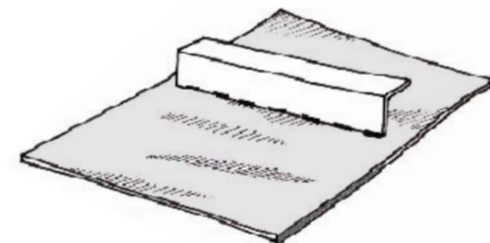
## DISTORTION



Unsymmetrical sections tend to deform, especially long unsupported sections.

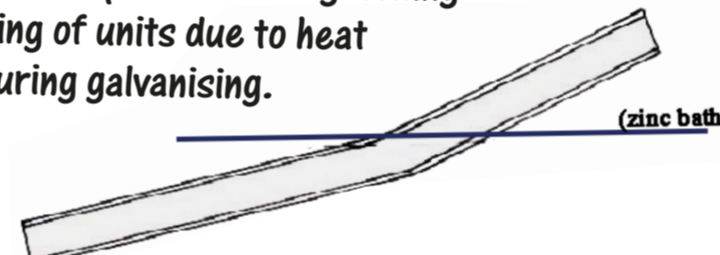
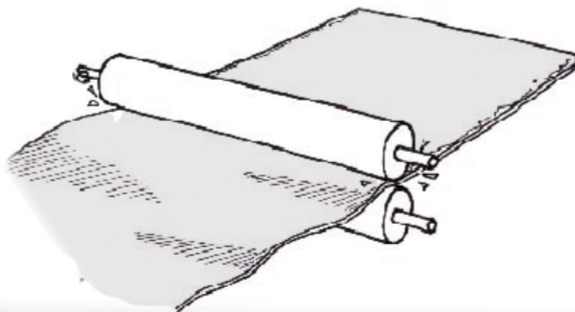
The fabricator must allow for possible straightening after double-dipping of units due to heat expansion during galvanising.

Buckling and Twisting of Plate

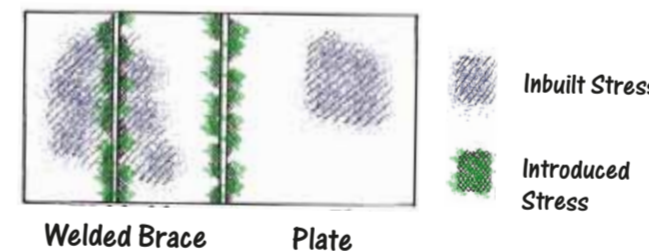


1. Unbraced flat plate can be worked on the shop floor

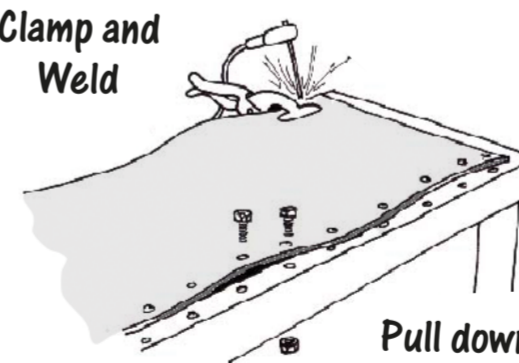
2. Can be put through rollers after HDG .. BUT, this method could damage the coating



Heat distortion in plain and chequer plate due to the relieving of stress during the galvanizing process.

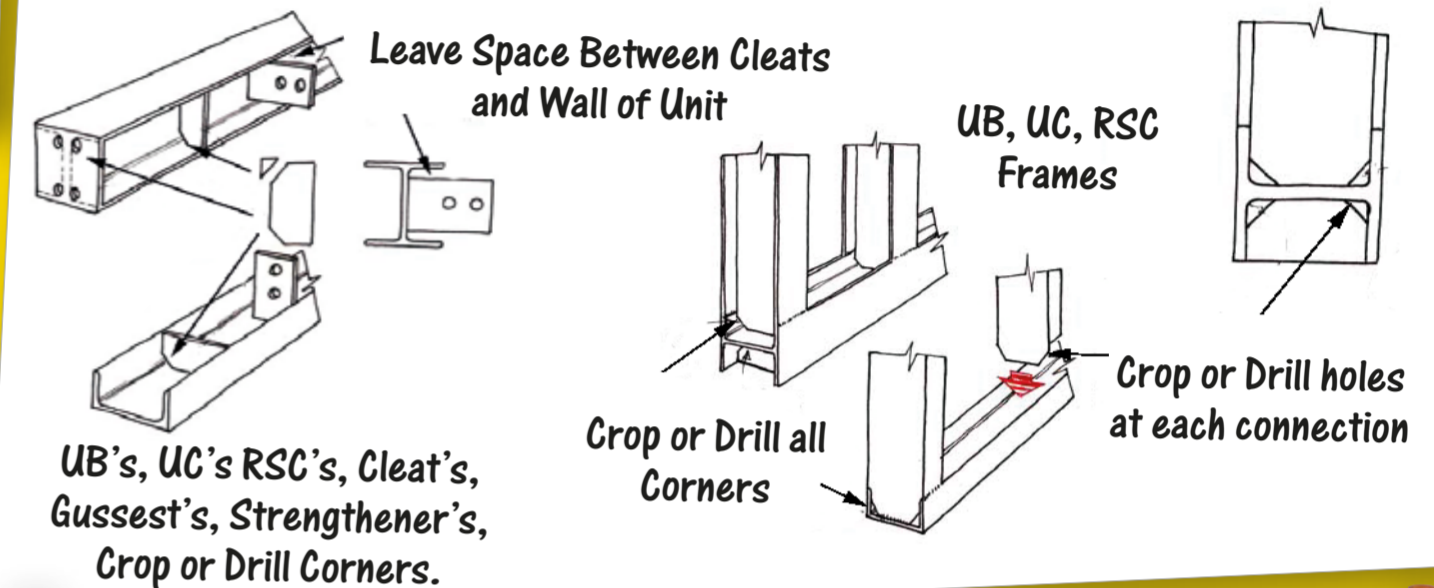


Clamp and Weld



Pull down with bolts

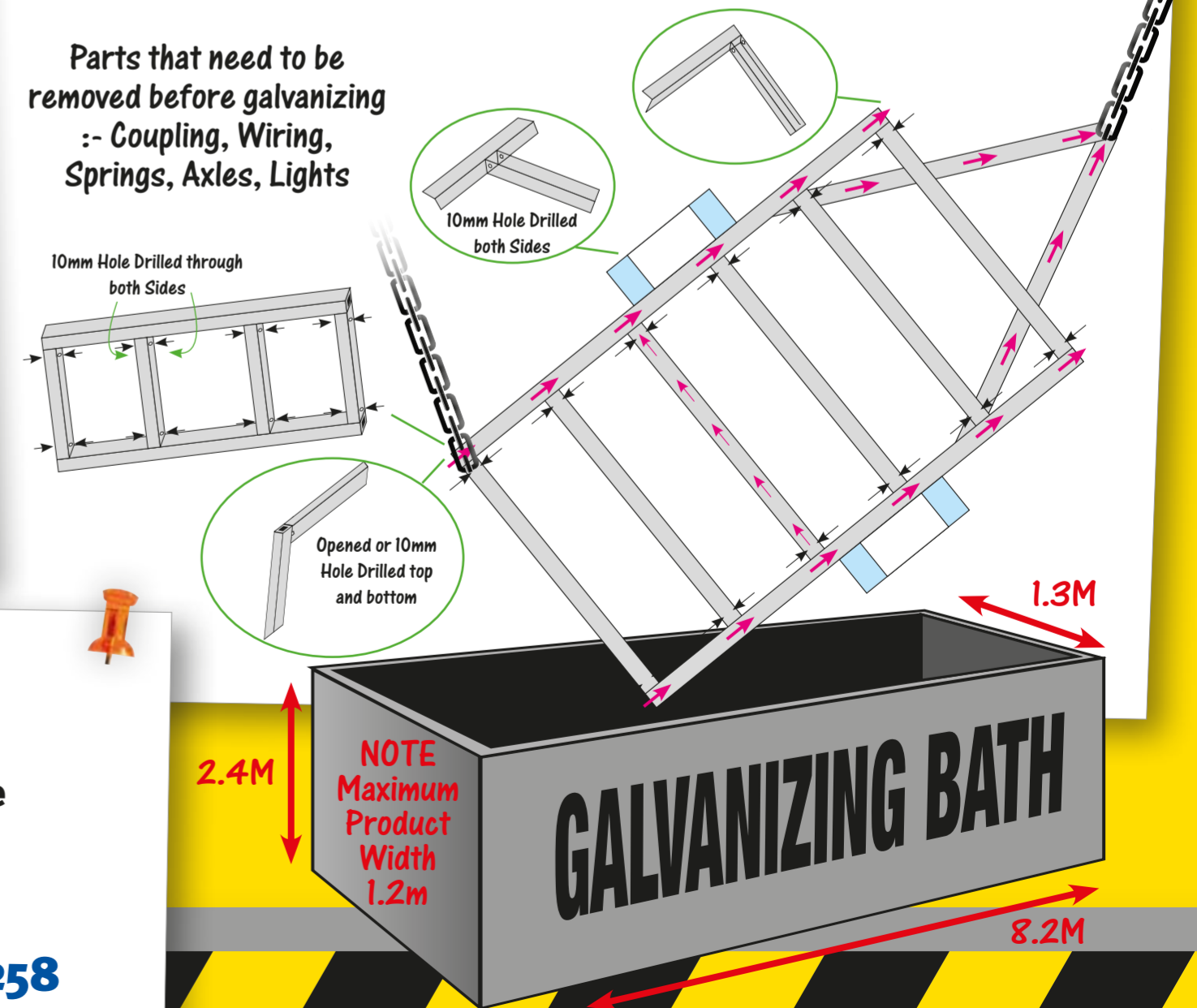
## GUSSETS AND WEBS



## TRAILERS AND UTE DECKS

The diagram shows the drilling pattern for trailers and ute decks. All hollow sections must have a vent or drain hole drilled close to the end of each section. Cross members should be drilled through both sides to allow free flow of Zinc.

Parts that need to be removed before galvanizing :- Coupling, Wiring, Springs, Axles, Lights



## WEBFORGE

For Hot Dip Galvanizing • Quotation • Service • Technical Advice  
 23 Kelvin Grove Rd, Palmerston North  
 Email [nz\\_galv@webforge.co.nz](mailto:nz_galv@webforge.co.nz) Web [www.webforge.co.nz](http://www.webforge.co.nz)  
**FREEPHONE 0800 932 425** **FREEFAX 0800 934 258**