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Zinc-Aluminum Alloy Coated Section Steel

锌铝合金镀层型钢

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Zinc-Aluminum Alloy Coated Section Steel

1 Scope

This Standard specifies the terms and definitions, codes, models and examples, ordering contents, technical requirements, test methods, inspection rules, package, marking, quality certificate, handling, stacking and storage of zinc-aluminum alloy coated section steel.

This Standard is applicable to the zinc-aluminum alloy coated section steel of hot-rolled section steel (hereinafter referred to as section steel) by the continuous hot dip plating mode.

2 Normative References

The following documents are essential to the application of this document. For the dated documents, only the versions with the dates indicated are applicable to this document; for the undated documents, only the latest version (including all the amendments) are applicable to this document.

GB/T 470 Zinc Ingots

GB/T 706 Hot-Rolled Section Steel

GB/T 2101 General Requirements of Acceptance, Packaging, Marking, and Certification for Section Steel

GB/T 3082-2008 Galvanized or Zinc-5% Aluminum-Mixed Mischmetal Alloy-Coated Low Carbon Steel Wire for Armouring Cables

GB/T 4956 Non-Magnetic Coatings on Magnetic Substrates - Measurement of Coating Thickness - Magnetic Method

GB/T 6462 Metallic and Oxide Coatings - Measurement of Coating Thickness - Microscopical Method

GB/T 9793 Thermal Spraying - Metallic and Other Inorganic Coatings - Zinc, Aluminum and Their Alloys

GB/T 11263 Hot-Rolled H and cut T Section Steel

4.3 Example

The zinc-aluminum alloy coated H-shaped section steel with specification of 300mm×300mm×10mm×15mm shall be expressed as follows:

ZAHM300×300×10×15

5 Ordering Contents

The contract that orders products according to this Standard shall contain the following main contents:

- a) Product name;
- b) Standard number;
- c) Section steel specifications;
- d) Weight or quantity;
- e) Special requirements.

6 Technical Requirements

6.1 Materials

6.1.1 Base metal of section steel

The base metal of section steel shall conform to the provisions of GB/T 706 or GB/T 11263, etc.

6.1.2 Zinc-aluminum alloy ingot

The chemical composition of zinc-aluminum alloy ingot shall conform to the provisions of YS/T 310.

6.1.3 Zinc ingot

The zinc ingot shall conform to the provisions of GB/T 470.

6.2 Coating

6.2.1 Appearance

6.2.1.1 The coating surface shall be smooth, and free of the following defects, such as peeling, uncoated area, zinc thorn, dripping and slagging.

7.2.2.3 Cross-section method

It shall be performed as per the requirements of GB/T 6462.

7.2.3 Aluminum content in the coating

It shall be inspected as per the provisions in Appendix A of GB/T 3082-2008.

7.2.4 Adhesion test

As long as the adhesion between coating and substrate can meet the requirements of the part under normal use and general operating conditions; generally, it is not necessary to specifically test the bonding force between the coating and the substrate. If the purchaser has special requirements, the supplier and the purchaser can negotiate to determine the test methods of adhesion.

8 Inspection rules

8.1 Inspection and acceptance

The inspection and acceptance of the section steel shall be carried out by the quality supervision department of the supplier. The purchaser reserves the right to check and accept any inspection items specified in this Standard or contract.

8.2 Batching rules

The section steels shall be accepted in batches. Each batch consists of the section steels with the same furnace number, the same size, and same specification. Each batch is no more than 60t.

8.3 Sampling Locations and Sampling Quantities

The sampling locations and sampling quantities of each batch of section steels shall conform to the provisions of Table 2.

8.4 Reinspection and judgment

The reinspection and judgment of the section steel shall conform to the provisions of GB/T 2101.

8.5 Numerical rounding off

The numerical rounding off shall conform to the provisions of YB/T 081.

9 Package, Marking, Quality Certificate, Handling,

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