

# The Dr. GALV Problem Solving Clinic

## The Question and Answer Forum

### 1. Has ASTM A780 actually been changed?

YES! Although it has been talked about in Galvanizing Monthly for over a year, the changes are now official. According to ASTM, the changes were officially approved on September 15, 1993 and are currently being printed. The new printed versions should be ready by November 15th. The primary change is the amount of zinc required in the dry film of the repair paint. Previously the requirement was 94% and the revised version is 65%. Any remaining material at the 94% level may still be used as it does meet the new standard.

### 2. Can the new solder touch-up materials be used under the revised version of A780?

The new solders containing

49% zinc, 1% copper and 50% tin meet the requirements of A780. In fact, A780 does not describe the composition of the solder repair material. The new material may become a defined part of A780 sometime in the future. Until then, it can still be used as a good repair if solder is to be used.

### 3. Why are there three touch-up methods in A780?

Each material has unique properties that occasionally make it the choice. For example, the new Army specification calls for repair by metalizing if the material is to be E-Coated. The reason is that E-Coat requires a 20 minute bake at 375 degrees, and both paint and solders will not hold up at that temperature. A careful look at the end use of the galvanizing will assist in making a good choice for repair.

### 4. Are the new touch-up materials going to be available right away?

The two new materials for repair of damaged galvanized surfaces are now available from multiple sources. The solder alloy was shown by three different vendors during the recent AGA Tech Forum in Denver. Minerals Research, Zaclon and Cominco all provided samples and specification sheets for the products they currently have for sale. The paint materials are available from some vendors now and most will have versions on the market this winter. Remember, the old paint repair materials are still acceptable. The paint requirements were eased, so the older 94% zinc materials can still be used.