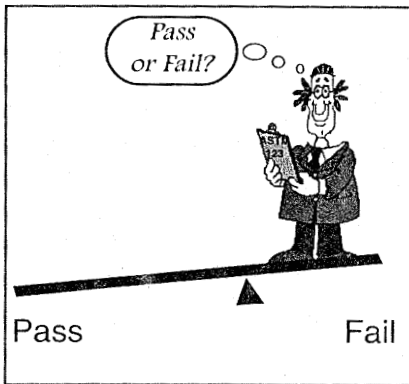


DR. GALV: I have heard that the specification for galvanizing, A 123 will be revised and available near the end of this year.



What are the changes and how will they affect the galvanizing business?

The ASTM Specification, A 123, has been revised and a new version will be printed as a separate document before the end of 1997. There are a few changes to help clarify measurements and a new section on terminology, but the basic thickness numbers and the requirements for the finished product have not changed.

The changes have been introduced to help clarify the measurements for coating thickness, especially on large assemblies. In order to explain the new sampling procedures and to keep up to date with ASTM guidelines, a new section was introduced into the specification that defines terminology that will be used throughout the specification. The sampling sizes and the separation of large samples into smaller specimen have been clarified and defined. The major portion of the terminology is defined in the newly referenced ASTM Standard A 902 and only the particular terms that are needed to measure galvanized steel coating thickness have been included in the updated A 123.

The paragraph on coating thickness has been rewritten to include the new terminology and to clarify the coating thickness requirements for pieces that include more than one material thickness and/or material category. For such pieces the material thickness and the material category must be measured separately and compared to the correct values in Table 1. of the specification. A new flow chart has

been added to the specification to aid in the determination of how the coating thickness sampling should proceed.

See the FLOW CHART on the facing page

The new version of the specification requires that individual measurements must be widely separated and no cluster of measurements can be used to reject the material.

The Coating Thickness Tables remain basically the same with the exception of Table 2, which converts the coating thickness grade to thickness values. The values in Table 2 are conversions from the micrometer values, so there are some slight changes in the table due to rounding and conversion. The conversion factors are given in a note attached to the table.

The section on sampling has been rewritten to include the new terminology and to clarify the determination of coating thickness based upon measurements. Two new figures have been introduced to help understand the sampling terminology and how it applies to all different types of galvanized articles. The differences between Lot, Sample, and Specimen have been explained through the visual medium of the new Figure 1. The other figure shows an article made up of many components which is large enough to require three separate specimen and three sets of measurements for each material category and material thickness.

Another change that has been introduced in this latest version of A 123 is the inclusion of an Optical Microscopy test to determine the coating thickness of a particular specimen. The Optical Microscopy test is a destructive test similar to strip and weigh so it is only appropriate for certain samples. It is probably most appropriate as a referee method if two parties cannot agree on a different type of coating thickness measurement.

All of these changes to A 123 are intended to clarify the sampling procedures and thickness testing of galvanized steel articles. Look for the updated version of A 123 around the end of November.

FLOW CHART COATING THICKNESS INSPECTION STEPS

