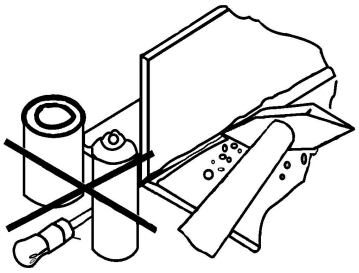
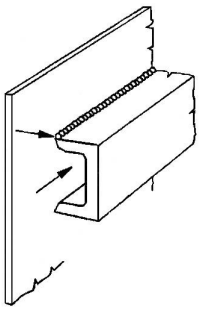
FOR ASSURING THE BEST ANTI-CORROSION PROTECTION

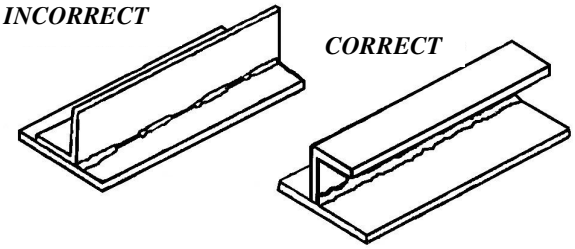
- ***Do not bring parts with paint, Vaseline or welding silt residues.***



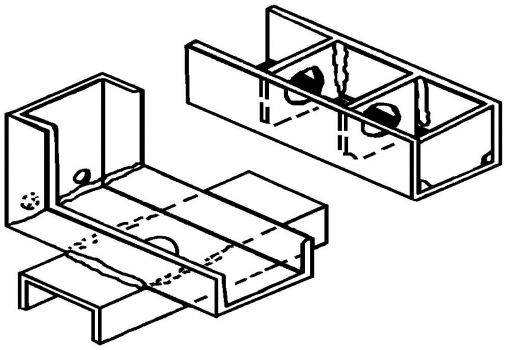


- ***Welding seams must be continuous, with no pores and perfectly deburred***

INCORRECT ***CORRECT***

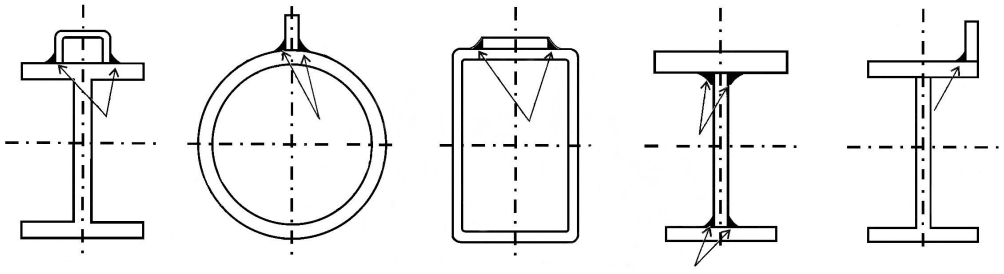


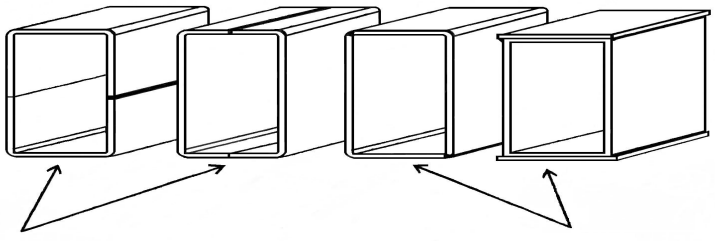
- ***Profiles should not be assembled in their sides***



- ***Parts should not have closed corners and dead angles***

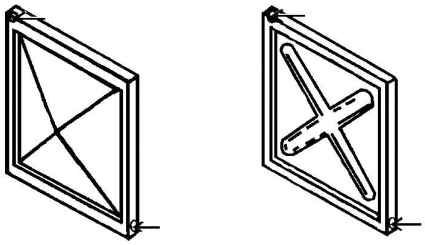
- ***Welds in the enclosed drawings may cause deformations during hot dip galvanizing.***





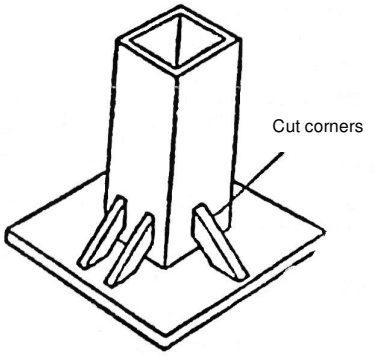
CORRECT ***INCORRECT***

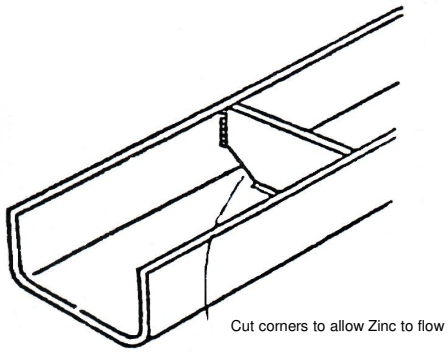
- ***To avoid deformation upon immersion into the melted Zn bath, it is recommended:***
  - ***Welds in the axes of the weight center or symmetrically located from them.***



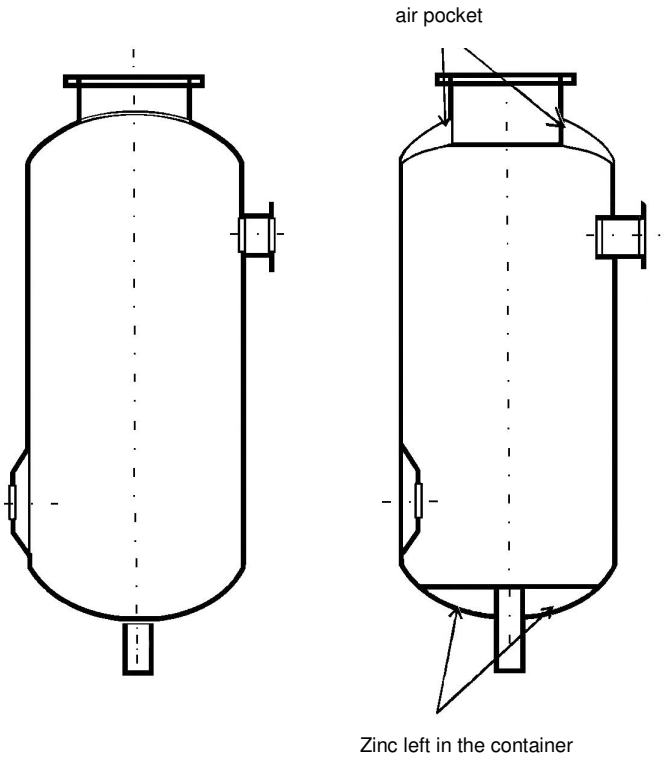
- ***Flat surfaces (steel sheet) should be allowed dilation by nervure, radial or pyramid cambers, etc.***

- ***Welded constructions should have the corners cut out to allow Zinc flow***



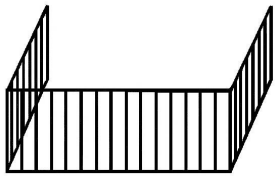


- ***Joints to containers should be placed correctly, so as to allow full protection of the inner surface, as well as the flow of Zinc***

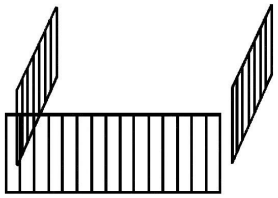


CORRECT ***INCORRECT***

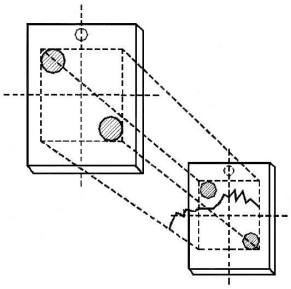
- ***Modular design***

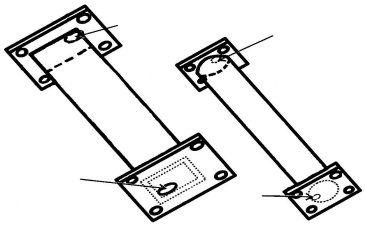


Incorrect



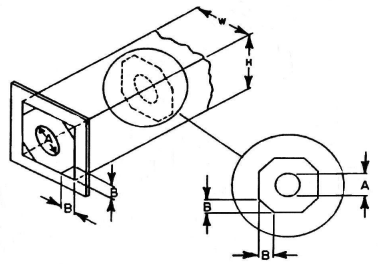
Correct

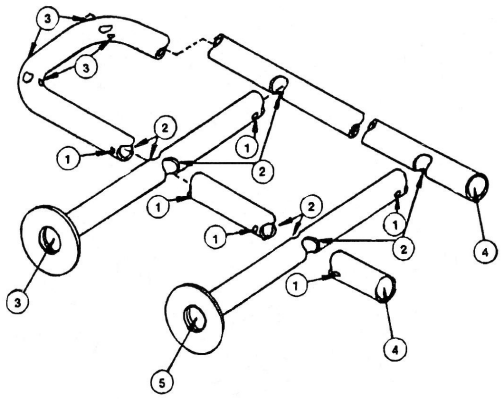


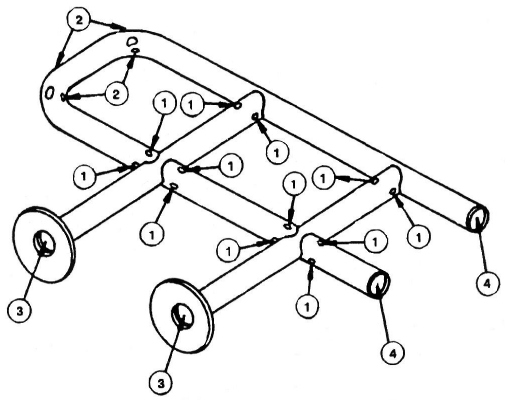


- ***It is recommended that even since design the technological holes be provided to allow easy, free flow of the melted Zinc***

Profiles Dimensions (mm)			*Minimum Diameter (mm) for number of holes:*		
○	□	▭	*1*	*2*	*4*
15	*15*	*20 x 10*	*8*		
20	*20*	*30 x 15*	*10*		
30	*30*	*40 x 20*	*12*	*10*	
40	*40*	*50 x 30*	*14*	*12*	
50	*50*	*60 x 40*	*16*	*12*	*10*
60	*60*	*80 x 40*	*20*	*12*	*10*
80	*80*	*100 x 60*	*20*	*16*	*12*
100	*100*	*120 x 80*	*25*	*20*	*12*
120	*120*	*160 x 80*	*30*	*25*	*16*
160	*160*	*200 x 120*	*40*	*25*	*16*
200	*200*	*260 x 140*	*50*	*30*	*16*

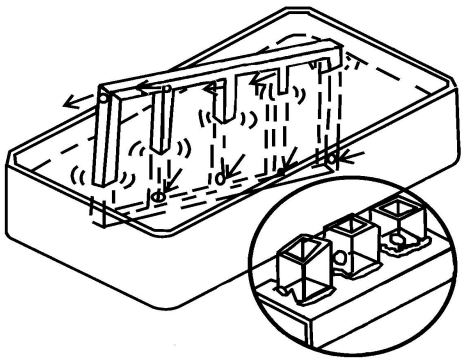




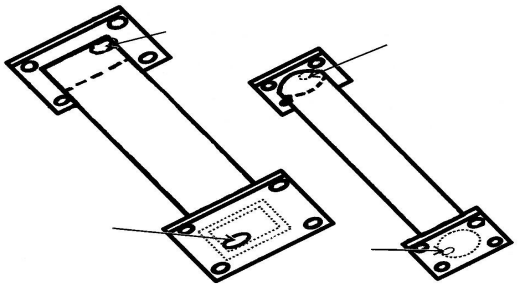


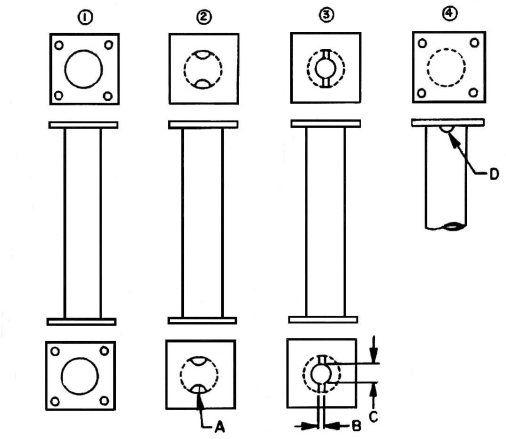
① Vent holes should be placed closest to the welding seam and sized min. 9.5 mm in diameter
② Inner holes should have same diameter as inner tube diameter
③ Vent holes at the ends should be min. 12.7 mm in diameter
④ and ⑤ Any handling device that obturates the ends of the structures being galvanized must be mounted after galvanizing. Vent holes must be visible from the outside for each tube forming the ensemble of the part to be galvanized.

① Each of the vent holes should be placed closest to the welding seam and sized min. 25% of the tube's inner cross-section, but not less than 9.5 mm.
② Vent holes at the ends should be min. 12.7 mm in diameter
③ and ④ Any handling device that obturates the ends of the structures being galvanized must be mounted after galvanizing. Vent holes must be visible from the outside for each tube forming the ensemble of the part to be galvanized.



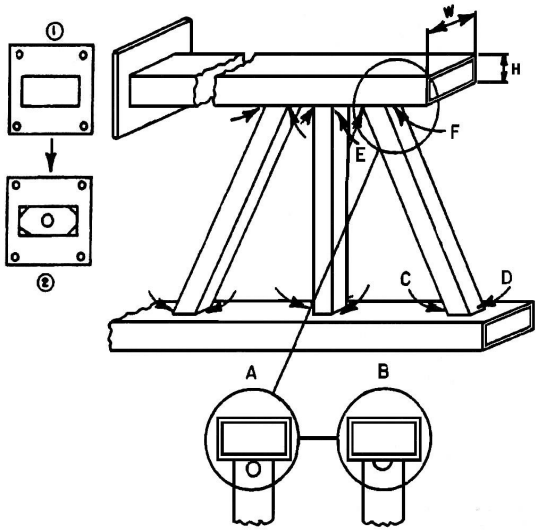
- ***Access holes should allow the melted Zinc in and out of the part being galvanized***

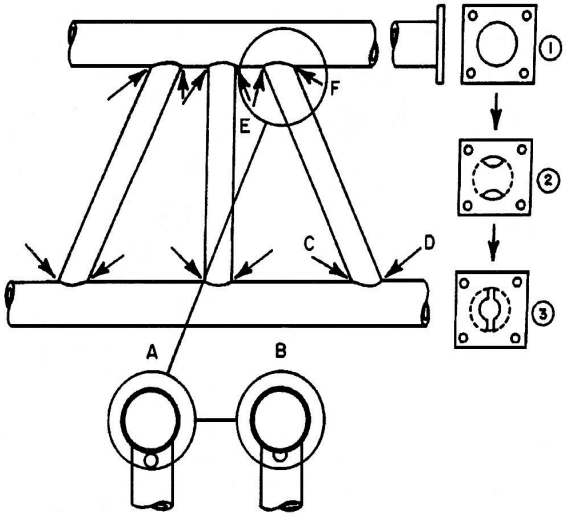




- ***For pipe columns, lighting poles and transmission masts with base plate, with or without steel sheet support***

Location of openings
① preferably openings should have same diameter both at entry and exit
② and ③ If complete openings cannot be made, then the existing ones should have the maximum possible diameter
Openings should be at least 30% of the tubes' cross-section surface (for diameters over 76 mm) and 45% of the tubes' cross-section surface (for diameters under 76 mm).
In the case shown, the tube has a 152 mm diameter and the opening should be minim 30% of the surface at each end.
② Semicircle with radius A = 44 mm
③ Canal B = 19 mm.. Central hole C = 76 mm
④ Semicircle with radius D = 41 mm





For parts made of profiles

Location of holes should be as shown in sections A or B. Each vertical and horizontal section should have 2 holes at the top and bottom at 180° from one another. The size of the holes should be equal and at least 30% of the tube's cross-section (for zone C and D, or zone E and F)
End plate – Horizontal
① Preferably complete opening
② If H+W = 610 mm or more, surface of hole plus cut corners should be at least 25% of the tube's cross-section (HxW)
If 406 mm < H +W < 610 mm --- use 30%
If 203 mm < H + W < 406 mm --- use 40%
If H + W < 203 mm ---will be left free

For parts made of tubes

Location of holes should be as shown in sections A or B. Each vertical and horizontal section should have 2 holes at the top and bottom at 180° from one another. The size of the holes should be equal and at least 30% of the tube's cross-section (for zone C and D, or zone E and F)
End plate – Horizontal
① Preferably complete opening
② Equal openings – minimum 30% of the tube's cross-section