



Designation: A 780 – 001

Standard Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings¹

This standard is issued under the fixed designation A 780; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This practice describes methods which may be used to repair damaged hot-dip galvanized coatings on hardware, structural shapes, and other products fabricated prior to hot-dip galvanizing, and uncoated areas remaining after initial hot-dip galvanizing. The damage may be the result of welding or cutting (flame), in which case the coating will be damaged predominantly by burning. This practice can also be used to repair hot-dip galvanized coatings damaged by excessively rough handling during shipping or erection. Requirements concerning the renovation of uncoated areas remaining after initial hot-dip galvanizing are contained within the applicable material specification.

1.2 This practice describes the use of low melting point zinc alloy repair rods or powders made specifically for this purpose, the use of paints containing zinc dust, and the use of sprayed zinc (metallizing).

1.3 The extent of repair shall be limited to an area mutually agreeable to the contracting parties. Similarly, contracting parties shall agree to the repair method to be used.

1.4 *This standard does not purport to address the safety problems, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

1.5 The values stated in inch-pound units are to be regarded as the standard. The values given in parentheses are for information only.

2. Referenced Documents

2.1 ASTM Standards:

A 902 Terminology Relating to Metallic Coated Steel Products²

¹ This practice is under the jurisdiction of ASTM Committee A05 on Metallic Coated Iron and Steel Products and is the direct responsibility of Subcommittee A05.13 on Structural Shapes and Hardware Specifications.

Current edition approved ~~June~~ April 10, 20001. Published ~~August 2000~~ June 2001. Originally published as A 780 – 80. Last previous edition A 780 – 93a00.