



Standard Specification for Zinc-Coated (Galvanized) Steel Bars for Concrete Reinforcement¹

This standard is issued under the fixed designation A 767/A 767M; 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 specification covers steel reinforcing bars with protective zinc coatings applied by dipping the properly prepared reinforcing bars into a molten bath of zinc.

1.2 This specification is applicable for orders in either inch-pound units (as Specification A 767) or SI units (as Specification A 767M).

1.3 The values stated in either SI or inch-pound units are to be regarded as standard. Within the text, the inch-pound units are shown in brackets. The values stated in each system are not exact equivalents. Therefore, each system must be used independently of the other. Combining values from the two systems may result in nonconformance with this specification.

2. Referenced Documents

2.1 ASTM Standards:

A 90 Test Method for Weight (Mass) of Coating on Zinc-Coated (Galvanized) Iron or Steel Articles²

A 615/A 615M Specification for Deformed and Plain Billet-Steel Bars for Concrete Reinforcement³

A 706/A 706M Specification for Low-Alloy Steel Deformed and Plain Bars for Concrete Reinforcement³

A 780/A 780M Practice for Repair of Hot Dip Galvanized Coatings²

A 996/A 996M Specification for Rail-Steel and Axle-Steel Deformed Bars for Concrete Reinforcement³

B 6 Specification for Zinc (Slab Zinc)⁴

E 376 Practice for Measuring Coating Thickness by Magnetic-Field or Eddy-Current (Electromagnetic) Test Methods⁵

2.2 American Concrete Institute Specification:⁶ ACI 301 Specifications for Structural Concrete

3. Ordering Information

3.1 It shall be the responsibility of the purchaser to specify all requirements that are necessary for material ordered to this specification. Such requirements shall include, but are not limited to the following:

3.1.1 Quantity of bars,

3.1.2 Size of bars,

3.1.3 Reinforcing bar specification (ASTM designation and year of issue) and grade,

3.1.4 Class of coating,

3.1.5 Galvanization before or after fabrication, and

NOTE 1—A typical ordering description is as follows: Deformed Grade 420 bars to ASTM A 615M-____; 1600 m, No. 19, 8 m long in secured lifts; zinc-coated (galvanized) to ASTM A 767M-____; including Class 1 coating, and galvanization after fabrication.

[Deformed Grade 60 bars to ASTM A 615-____; 4000 linear ft, No. 6, 20 ft, 0 in. long in secured lifts; zinc-coated (galvanized) to ASTM A 767-____, including Class 1 coating, and galvanization after fabrication.]

4. Galvanizing

4.1 Handling:

4.1.1 The galvanizer shall be permitted to subject the newly coated steel reinforcing bars to air or steam wiping to remove excess zinc from the bars. After the wiping, the coated steel reinforcing bars shall meet the minimum coating mass [weight].

NOTE 2—During the wiping process care should be taken to maintain a uniformly thick coating around the perimeter of the bar.

4.1.2 It shall be the responsibility of the galvanizer to maintain identity of the reinforcing bars throughout the galvanizing process and to the point of shipment.

4.2 Mass [Weight] of Coating and Test:

¹ This specification is under the jurisdiction of ASTM Committee A-1 on Steel, Stainless Steel, and Related Alloys and is the direct responsibility of Subcommittee A01.05 on Steel Reinforcement.

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² Annual Book of ASTM Standards, Vol 01.06.

³ Annual Book of ASTM Standards, Vol 01.04.

⁴ Annual Book of ASTM Standards, Vol 02.04.

⁵ Annual Book of ASTM Standards, Vol 03.03.

⁶ Available from American Concrete Institute, P.O. Box 9094, Farmington Hills, MI 48333-9094.