

For example:

The standard plus/minus tolerance for a 0.022" nominal thickness order is ± 0.003 "

The standard plus tolerance for a 0.019" minimum thickness order is $+ 0.006$ " with no minus tolerance.

For detailed and specific assistance on Dofasco minimum gauge thickness ordering practice, set points, tolerances, and pricing, please consult with your Dofasco Account Manager or Account Representative.

2.0 COATING EXTRAS AND DEDUCTS

Product Description

Dofasco "Premier" Galvanized is produced on continuous hot dip galvanizing lines by passing suitably prepared coils through a bath of molten zinc. Most commonly specified as Z275 (Commercial Coating), it is also available in other coating weights as detailed in Sections 2.1, 2.2 and 2.3. Unless otherwise specified, it is supplied chemically treated (passivated) to help retard the formation of zinc oxide, commonly referred to as storage stain.

The coating consists of a layer of zinc on top of a very thin layer of a mixture of intermetallic compounds containing iron, aluminum and zinc. It is normally characterized by the regular "spangle", zinc crystal appearance and is intended for both internal and external use. Temper rolling will alter the surface appearance.

"Premier" Galvanized Minimized Spangle is treated before solidification of the zinc to restrict the normal zinc spangle formation. It is developed for use on painted, and semi-exposed products where the regular spangle would be objectionable.

Dofasco "Satincoat" is manufactured by the Galvanneal process. As the strip emerges from the coating bath, the zinc coating thickness is controlled by the use of air knives. From here, the strip enters a furnace and the heat converts the zinc coating to the zinc-iron alloy coating of Galvanneal. There is no spangle but a grey matte appearance, and it is intended for automotive applications and non-automotive internal and painted end uses.

"Premier" Galvanized Corrugated Steel Pipe (CSP) Sheet is produced with a heavy zinc coating for increased corrosion resistance.

Dofasco "Dualcoat" has most of the zinc removed from one surface of the sheet. The result is a differentially coated steel with a full coating on one side and a Z001 coating on the other side.

2.1 Standard Commercial ASTM Coatings

Galvanized Steel Sheet is manufactured to meet the General Requirements of ASTM A525 according to a specified coating designation. Test limits for the available coatings are shown below.

The coating designation should be included in the description of material in the order.

The weight of coating shall conform to ASTM A525 requirements for triple and single spot minimum checks for the specific coating designation. The weight of coating is the total amount on both sides of a sheet, expressed in ounces per square foot of sheet, except in the case of differential coating.

Coating Test Limits

Metric - grams per square metre, total both sides

Imperial - ounces per square foot, total both sides

METRIC COATING DESIGNATION	IMPERIAL COATING DESIGNATION	MINIMUM CHECK LIMIT BY TRIPLE SPOT TEST		MINIMUM CHECK LIMIT BY SINGLE SPOT TEST	
		METRIC	IMPERIAL	METRIC	IMPERIAL
Z700		700	-	595	-
Z600		600	-	510	-
Z450		450	-	385	-
Z350	G115	350	1.15	300	1.00
Z275	G90 Commercial	275	0.90	235	0.80
Z180	G60	180	0.60	150	0.50
Z120	G40	120	0.40	90	0.30
Z001	G01	No Minimum		No Minimum	
ZF001	A01 Galvanneal	No Minimum		No Minimum	
ZF75	A25 Galvanneal	75	0.25	60	0.20