

## 3394 GALVANIZED STRUCTURAL SHAPES

### 3394.1 SCOPE

Provide galvanized structural shapes, plates, bars, and castings for pipes and structures.

### 3394.2 REQUIREMENTS

Blast clean all items in accordance with SSPC SP6/NACE No. 3 – Commercial Blast Cleaning before galvanizing.

Provide structural shapes, plates, bars, and castings galvanized meeting the requirements of ASTM A 123. Provide castings that have been pickled before galvanizing.

For galvanized items that are warped or distorted, straighten to tolerance no greater than  $\frac{1}{8}$  in [3 mm] in 10 ft [3,000 mm], or as directed by the Engineer.

For galvanized surfaces that have handling marks or minor chips that no greater than  $\frac{1}{2}$  in [12.5 mm] at the narrowest dimension, repair in accordance with ASTM A 780, Annex 1 or Annex 2 (brush applied paint only). Ensure the dry film thickness (DFT) of the coating repair is in accordance with ASTM A 123. Perform repairs in accordance with the supplier's quality procedures. Obtain an approved non-conformance report (NCR) for each repair.

### 3394.3 SAMPLING AND TESTING — (BLANK)