

ZRC Worldwide

Recommended specifications for repair of welds and damaged hot dip galvanizing

Visible repair of welds and damaged hot dip galvanizing:

1. SSPC Paint Specification 20 – Zinc-Rich Coating: Type II – Organic; Level 1 – equal to or greater than 85% zinc dust by weight present in the dried film.
2. Zinc Dust Content - ASTM D 520 Type III Zinc Dust - .002% maximum lead by weight
3. Weight per gallon – not less than 24 lbs.
4. VOC Content - ASTM D 3960, 385 g/l (3.3 lbs per gallon) maximum
5. Color and Gloss – Silver with gloss matching appearance of new hot dip Galvanizing
6. Manufacturers: Subject to compliance with requirements, provide weld/galvanizing repair compound by one of the following:
 - a. Galvilite Galvanizing Repair Compound, ZRC Worldwide (www.zrcworldwide.com, (800 831-3275))
 - b. No known equal.
7. Follow manufacturer’s application instructions.

Manufacturer to provide Certificate of Conformance to above criteria.

Options:

a. LEED Projects – make following substitutions:

4. VOC Content - ASTM D 3960, 221 g/l (1.8 lbs per gallon) maximum
5. Color and Gloss – Matte grey “battleship grey” color
6. Manufacturers: Subject to compliance with requirements, provide weld/galvanizing repair compound by one of the following:
 - a. ZRC 221 Galvanizing Repair Compound, ZRC Worldwide (www.zrcworldwide.com, (800 831-3275))
 - b. No known equal.
 - c. known equal.

b. Repair of welds and damaged hot dip galvanizing not visible (e.g. concrete. Rebar repair) – make following substitutions:

- 5 .Delete
- 6.Manufacturers: Subject to compliance with requirements, provide weld/galvanizing repair compound by one of the following:
 - a. ZRC Galvanizing Compound, ZRC Worldwide (www.zrcworldwide.com, (800) 831-3275)
 - b. No known equal.

Specification Sections Where Repair of Welds and Damaged Hot Dip Galvanizing is Commonly Required:

Division 3

- Architectural Concrete
- Architectural Precast Concrete
- Structural Concrete
- Structural Precast Concrete
- Concrete Framework
- Concrete Reinforcement

Division 5

- Cold Formed Metal Framing
- Expansion Joints
- Metal Decking
- Metal Fabrications
- Metal Joists
- Metal Railings
- Metal Stairs
- Ornamental Metals
- Ornamental Stairs
- Structural Steel

Division 8

- Curtain Walls
- Entrances and Storefronts
- Metal Windows

Division 15

- Air Handling
- Cooling Towers
- Ductwork
- Fire Protection Systems
- Hydronic Piping

Division 16

- Electrical Conduit