

TECHNICAL REQUIREMENTS FOR GALVANIZING

	name and surname	Date	Signature
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1. Ze-Steel Galvano offers galvanizing services according to ISO 2081 and DIN 50961 standards.
2. The engineer and contractors should collaborate with the technical support of Ze-Steel Galvano, in order to fulfill construction and technological requirements:
 - The dimensions of products and construction elements have to be in line with the dimensions of the baths, in order to avoid double dipping.
 - Materials used for product and construction elements such as surface quality and chemical compositions: Mistakes due to the choice of those materials by the client cannot be subject to reclamations.
 - Dimensioning and placement of drainage and venting openings: In case of hidden air spaces and hidden openings, the customer must submit a product design and a certified statement as a guarantee that the openings in question were made in accordance with ISO 2081 and DIN 50961. Otherwise, the customer must successively make openings or Ze-Steel Galvano will do the service and calculate costs in accordance with the price list of services.
3. Cold forming and unevenly distributed welding sequence are the most common causes of creation of internal stresses. This is most often seen in products made of thinner sheet metals of larger dimensions, cold-formed and welded frames, various sheet metal covers, etc. Thermal deformations cannot be affected by galvanization, and therefore they cannot be the subject of a complaint.
4. For special requests that go beyond the standards, especially those related to the quality and thickness of zinc coating and post-processing, the customer has to notify Ze-Steel Galvano in a timely manner and specific arrangements should be regulated in writing and signed. If this is not done, the service will be performed according to ISO 2081 and DIN 50961 standards
5. Welds must be anti-corrosive, compact, well-sealed without finishing craters, free of slag residues and drops of welding spray (welding spray must not be silicone-based). It is recommended to use electrodes with a lower silicon content. Galvanization cannot affect the quality of welds, so complaints due to poor quality of zinc coating in the weld zone will not be accepted.
6. The surface of structural elements and products in general that come to galvanization must not be contaminated with residues of oil and other waterproof paints, greases, various resins, residues of welding sprays, residues of previous protective coatings or old zinc coating. Any such case means poor quality zinc coating, and if such residues have to be removed by Ze-Steel Galvano costs will be calculated in accordance with the price list of services.

7. Once galvanized, it is not allowed to weld or otherwise reshape products or construction parts as there is a great chance of damaging the zinc coating.
8. Threaded elements, various sliding and rotating elements made in accordance with the provided tolerances and galvanization recommendations, will be galvanized in accordance with ISO 2081 and DIN 50961.
9. Products and structural elements brought for galvanizing must be properly palletized or packed so as to prevent in advance any mechanical damage during transport or unloading and storage. Otherwise, Zee-Steel Galvano will not be responsible for the damage caused, ie it has the right to give up unloading and performing the service in severe cases. *Mechanical damage noticed by the input control and reported to the sender cannot be the subject of a complaint.*
10. Deadline for complaints is 8 days from the date of delivery i.e. Claim of galvanized goods.