

ISO 14713-3:2017-04 (E)

Zinc coatings - Guidelines and recommendations for the protection against corrosion of iron and steel in structures - Part 3: Sherardizing

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Design for sherardizing	2
4.1	General	2
4.2	Surface preparation	2
4.3	Design considerations	3
4.4	Clearances of threaded components	3
5	Storage and transport	4
5.1	General	4
5.2	Recommendations for storage and transport	4
6	Effects of article condition on quality of sherardizing	4
6.1	Composition	4
6.2	Surface condition	4
6.3	Influence of steel surface roughness on the sherardized coating thickness	5
6.4	Internal stresses in the base material	5
6.4.1	General	5
6.4.2	Distortion cracking	5
6.4.3	Hydrogen embrittlement	6
6.5	Large objects and thick steels	6
7	Effect of sherardizing process on the article	6
7.1	Processing circumstances	6
7.2	Coating properties influenced by the sherardizing process	6
7.2.1	Sherardizing practice	6
7.2.2	Surface properties of the finished article	6
8	After-treatments	7
Bibliography		8