

DIN 50962:2020-02 (E)

Electrodeposited coatings - Chromated coatings of zinc and zinc alloys on iron and steel

| Contents | Page |
|---|------|
| Foreword | 4 |
| Introduction | 5 |
| 1 Scope | 6 |
| 2 Normative references | 6 |
| 3 Terms and definitions..... | 6 |
| 4 Designation | 7 |
| 5 Service condition numbers | 7 |
| 6 Ordering details..... | 8 |
| 7 Material and surface condition..... | 8 |
| 8 Coatings | 9 |
| 8.1 General | 9 |
| 8.1.1 Surface quality and coating adhesion..... | 9 |
| 8.1.2 Zinc-nickel alloy coatings | 9 |
| 8.1.3 Zinc-iron alloy coatings | 9 |
| 8.2 Chromate conversion coatings..... | 9 |
| 8.2.1 General | 9 |
| 8.2.2 Process groups and post-treatment..... | 10 |
| 8.3 Heat treatment..... | 11 |
| 9 Testing of coatings | 11 |
| 9.1 Coating thickness | 11 |
| 9.1.1 General | 11 |
| 9.1.2 Thickness measurement..... | 11 |
| 9.2 Alloy content..... | 12 |
| 9.3 Adhesion | 12 |
| 9.4 Corrosion resistance | 12 |
| 9.4.1 General | 12 |
| 9.4.2 Testing procedure and evaluation..... | 13 |
| 9.4.3 Minimum corrosion resistance achieved by post-treated zinc and zinc-alloy coatings..... | 13 |
| 10 Test report..... | 18 |
| 10.1 General information..... | 18 |
| 10.2 Special information when coating high-strength materials with a tensile strength $\geq 1\,000 \text{ N/mm}^2$ | 18 |
| 10.3 Test results..... | 18 |
| Annex A (informative) Effects of heat exposure on chromated zinc and zinc-alloy coatings..... | 19 |
| Bibliography | 21 |

Tables

| | |
|---|-----------|
| Table 1 — Service condition numbers for chromated zinc and zinc-alloy coatings (as in DIN EN ISO 27830)..... | 8 |
| Table 2 — Shades of chromate conversion coatings on zinc coatings | 10 |
| Table 3 — Shades of chromate conversion coatings on zinc alloy coatings..... | 11 |
| Table 4 — Other additional treatments..... | 11 |
| Table 5 — Minimum local coating thicknesses and corrosion resistance time of chromated zinc coatings subjected to the NSS test (rating number 10/10 as in DIN EN ISO 10289:2001-04)..... | 14 |
| Table 6 — Minimum local coating thicknesses and corrosion resistance time of untreated zinc coatings (rating number 10/10 as in DIN EN ISO 10289:2001-04) | 15 |
| Table 7 — Minimum local coating thicknesses and corrosion resistance time of chromated zinc coatings subjected to Test DIN 50018-AHT 2,0 S (rating number 10/10 as in DIN EN ISO 10289:2001-04) | 15 |
| Table 8 — Minimum corrosion resistance time of chromate conversion coatings on zinc coatings subjected to the NSS test (rating number 10/10 as in DIN EN ISO 10289:2001-04) | 16 |
| Table 9 — Minimum local coating thicknesses and corrosion resistance time of chromated zinc alloy coatings subjected to the NSS test (rating number 10/10 as in DIN EN ISO 10289:2001-04)..... | 16 |
| Table 10 — Minimum local coating thicknesses and corrosion resistance time of chromated zinc alloy coatings subjected to Test DIN 50018-AHT 2,0 S (rating number 10/10 as in DIN EN ISO 10289:2001-04) | 17 |
| Table 11 — Minimum corrosion resistance time of chromate conversion coatings on zinc alloy coatings subjected to the NSS test (rating number 10/10 as in DIN EN ISO 10289:2001-04) | 17 |
| Table A.1 — Minimum local coating thicknesses and corrosion resistance time of heat-stressed, chromated zinc alloy coatings (heating for 24 h at (120 ± 5) °C) subjected to the NSS test (rating number 10/10 as in DIN EN ISO 10289:2001-04) | 19 |
| Table A.2 — Minimum corrosion resistance time of heat-stressed chromate conversion coatings on zinc alloy subjected to the NSS test (rating number 10/10 as in DIN EN ISO 10289:2001-04) | 20 |