

DIN EN 10152:2017-06 (E)

Electrolytically zinc coated cold rolled steel flat products for cold forming - Technical delivery conditions

Contents		Page
European foreword		4
1	Scope	5
2	Normative references	5
3	Terms and definitions	6
4	Classification and designation	6
4.1	Classification	6
4.2	Designation	6
5	Information to be supplied by the purchaser	7
5.1	Mandatory information	7
5.2	Options	8
6	Requirements	8
6.1	General	8
6.2	Steelmaking and manufacturing processes	9
6.3	Deoxidation	9
6.4	Chemical composition	9
6.5	Delivery condition	9
6.6	Choice of properties	9
6.7	Mechanical properties	9
Table 1 -- Chemical composition and mechanical properties of electrolytically zinc coated mild steel flat products a		10
6.8	Stretcher strain marks	12
6.9	Coatings	12
Table 2 -- Electrolytic zinc coatings (see also 6.9.4 and 6.9.5)		13
6.10	Surface characteristics	13
6.10.1	General	13
6.10.2	Surface quality	13
6.10.3	Surface finish	13
6.11	Surface treatment (surface protection)	14
Table 3 -- Surface treatment		14
6.12	Applications	15
6.12.1	Welding	15
6.12.2	Painting	15
6.12.3	Forming	15
6.13	Mass, tolerances on dimensions and shape	15
7	Inspection	15
7.1	Types of inspection and inspection documents	15
7.2	Test units	16
7.3	Tests to be carried out	16
7.4	Sampling	16
7.5	Test methods	16
7.5.1	Tensile test	16

7.5.2	Plastic strain ratio and hardening exponent	16
7.5.3	Coating mass	16
7.6	Retests	17
8	Marking	17
9	Packing	17
10	Storage and transportation	17
Annex A (normative) Reference method for determination of the zinc coating mass		18
A.1	Principle	18
A.2	Reagent and preparation of the solution	18
A.2.1	Reagent	18
A.2.2	Preparation of the solution	18
A.3	Apparatus	18
A.4	Procedure	18
Bibliography		19