DIN EN 15773:2018-03 (E)

Industrial application of powder organic coatings to hot dip galvanized or sherardized steel articles [duplex systems] - Specifications, recommendations and guidelines

Contents		Page
Europ	pean foreword	4
Introd	luction	5
1	Scope	7
2	Normative references	7
3	Terms and definitions	8
4	Ordering	9
4.1	General	
4.2	Request for quotation	
4.3	Information provision	
4.3 4.4	Delivery of product prepared for coating	
5	Fabrication	12
5.1	Surface condition of the steel	
5.2	Nature and composition of the raw material	
5.3	Welds, markings, labels	
5.4	Deviations of edges and sides	
6	Zinc coating and zinc surface	13
6.1	Cooling	
6.2	Quality and inspection of the zinc coating	
6.3	Surface preparation prior to pre-treatment for application of powder organic coatings	14
6.4	Storage, packaging and transport after galvanizing or sherardizing	14
6.5	Acceptance check	
7	Pre-treatment of the zinc surface	14
7.1	General	14
7.2	Chemical pre-treatment	15
7.3	Mechanical pre-treatment (sweep blasting)	15
8	Powder organic coating layers	
8.1	General	
8.2	Specification of powder organic coating	
8.3	Repair of the coating system	17
9	Packaging, storage and further movement of finished products	17
10	Installation	17
11	Inspection of finished products	17
12	Health and safety	17
Annex	x A (normative) Considerations when designing and fabricating items for galvanizing or	
	sherardizing and subsequent application of powder organic coatings	18

Annex	B (informative) Guidance on the influence of steel surface chemistry on the surface condition and pre-treatment of galvanized or sherardized articles prior to application of powder organic coatings	. 19
Annex	C (informative) Guidance on treatment of hot dip galvanized or sherardized articles prior to pre-treatment for application of powder organic coatings	
C.1	Cooling	. 21
C.2	Prominent welds and sharp points on the zinc coating	
C.3	Avoidance of condensation during storage, packaging and transport after galvanizing or sherardizing	
Annex	D (informative) Guidance on pre-treatment of hot dip galvanized or sherardized articles prior to the application of powder organic coatings	. 22
D.1	General	. 22
D.2	Mechanical pre-treatment	
Bibliography		23