

DIN EN ISO 14713-3:2010-05 (E)

Zinc coatings - Guidelines and recommendations for the protection against corrosion of iron and steel in structures - Part 3: Sherardizing (ISO 14713-3:2009)

Contents		Page
Foreword		3
Introduction		4
1	Scope	5
2	Normative references	5
3	Terms and definitions	6
4	Design for sherardizing	6
4.1	General	6
4.2	Surface preparation	6
4.3	Design considerations	7
4.4	Clearances of threaded components	7
5	Storage and transport	8
5.1	General	8
5.2	Recommendations for storage and transport	8
6	Effects of article condition on quality of sherardizing	8
6.1	Composition	8
6.2	Surface condition	9
6.3	Influence of steel surface roughness on the sherardized coating thickness	9
6.4	Internal stresses in the base material	9
6.5	Large objects and thick steels	10
7	Effect of sherardizing process on the article	10
7.1	Processing circumstances	10
7.2	Coating properties influenced by the sherardizing process	11
8	After-treatments	11
Bibliography		12