

## Repair of Galvanized Surfaces

### Purpose of this Bulletin

Occasionally it is necessary to repair the surface coating of galvanized chord, web and/or hardware materials. We recommend that you adhere to the following standards when repairing the galvanized surface coating of TrusSteel materials:

- ASTM A780-93a, *“Standard Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings”*,
- Society for Protective Coatings Joint Surface Preparation Standard SSPC-SP10 / NACE No. 2, *“Near-White Blast Cleaning”*.

### Information

The most commonly used method for repairing damaged galvanized surfaces is the application of a zinc-rich paint. A zinc-rich paint contains zinc dust and, when properly applied, can produce an adequate corrosion resistant finish. A suitable zinc-rich paint should provide a dried film that contains not less than 65% zinc dust by weight. One source would be ZRC Products Company, Quincy, MA, 617-328-6700 ([www.zincrich.com](http://www.zincrich.com)).

### Application

A summary of the procedure for repairing damaged galvanized surfaces is as follows:

1. Prepare damaged surface by following SSPC-SP10. It is permissible to use a power disk sander to prepare the surface of areas that require repairing. Sand to bright metal as stated in ASTM A780-93a Annex A2.
2. Clean surfaces with industrial solvent to remove dirt, grease and oils. All surfaces must be dry before priming. Note that bare, cleaned metal is extremely susceptible to rusting. Bare, cleaned parts should be kept dry and should be primed as soon as is possible after cleaning.
3. Prime all bare metal areas with “Cold Galvanizing Compound” as made by the ZRC Products Company.
4. By brush or by spray (on all areas to be repaired), apply two coats of “Cold Galvanizing Compound” (by ZRC) totaling a minimum dry film thickness of 0.003 IN, using the manufacturer’s printed re-coat directions.
5. Measure the coating thickness to ensure that the minimum dry film thickness (see step #4) has been achieved.

### Included Documents

- ASTM A780-93a, *“Standard Practice for Repair of Damaged and Uncoated Areas of Hot-Dip Galvanized Coatings”*,
- Society for Protective Coatings Joint Surface Preparation Standard SSPC-SP10 / NACE No. 2, *“Near-White Blast Cleaning”*.

### Revisions

- This bulletin was revised on 6/5/06.