

Silver City Galvanizing Inc.

Galvanizing Procedure

This Procedure includes receiving, in-process and final inspection performed by Silver City Galvanizing per CSA G164-M92. It is the Management's responsibility to ensure this Procedure is understood and followed by all employees with direct responsibilities defined in this Procedure.

Material Receipt Inspection

The Shipper or designate will receive and sign bill of lading of incoming material.

The shipper will create a Work Order. The Work Order will include Customer name, PO # and an itemized list provided by customer of materials received

The material will be checked by QC personnel to determine if there are any potential galvanizing problems.
Properly ventilated

No paint or lacquer

Size, if it will fit in the tanks

Excessive rust or mill scale

If there are issues, the Customer will be contacted to resolve the issue.

Steel Cleaning Process

Step #1 Hydronet (phosphoric acid) 8 – 12 %
Removes oil and grease

Step #2 H₂ SO₄ (sulphuric acid) 4 – 8 %
Removes mill scale and rust

Step #3 Rinse Tank (water)
Remove acid residue before next step.

Step #4 Flux (zinc ammonium chloride) 150 deg F
Protects steel from oxidizing and acts as a bonding agent for the galvanizing process

Galvanizing Process

Zinc kettle (molten zinc) 850 deg F Dimensions 31'L x 6'D x 5'-4" W
Immerse cleaned and fluxed steel into the molten zinc until it reaches kettle temperature. The zinc will metalurgically bond with steel. Remove slowly from zinc. Allow to cool

Final Inspection

The QC personnel will conduct visual inspection and will take zinc thickness readings. When everything is acceptable, an inspection report is generated and forwarded to the Customer.

Shipping

The Shipper will create a Bill of Lading for transportation purposes.

The Shipper will ensure that all products are loaded on the Customer-provided truck.

