

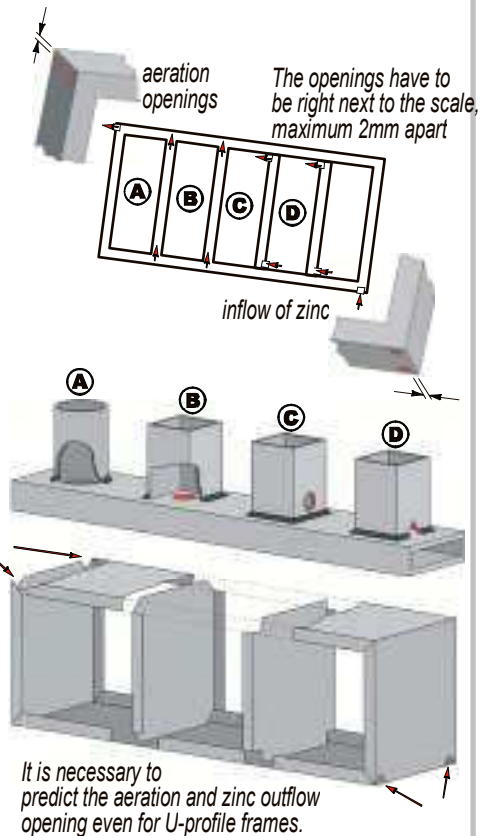
PROPER CONSTRUCTION FOR HOT DIP GALVANIZING

Openings for aeration and the outflow of zinc

Demand according to necessary openings			
Pipes - measures in mm			The smallest of their openings according to their number
1	2	4	
15	15	20 x 10	6
20	20	30 x 15	8
30	30	40 x 20	10 8
40	40	50 x 30	12 10
50	50	60 x 40	16 12 10
60	60	80 x 40	20 16 10
80	80	100 x 60	20 20 12
100	100	120 x 80	25 20 12
120	120	160 x 80	25 20 16
160	160	200 x 120	32 20 16
200	200	260 x 140	32 20 16

It is not possible to perform hot dip galvanizing without the openings as there is a danger of explosion.

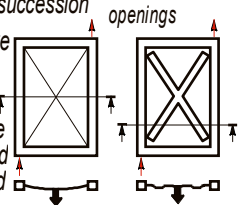
The size and position of the openings can be a condition to quality galvanizing.



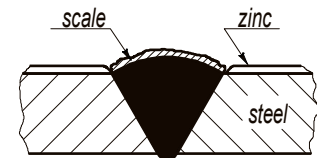
It is necessary to predict the aeration and zinc outflow opening even for U-profile frames.

Reducing thermal deformations

1. Weld in proper succession
2. If possible, make symmetrical welding seams
3. If possible make cross or pyramid impressions and curve the sheet metal – bombard
4. If possible do not use materials of different thickness



Removing the welding scale



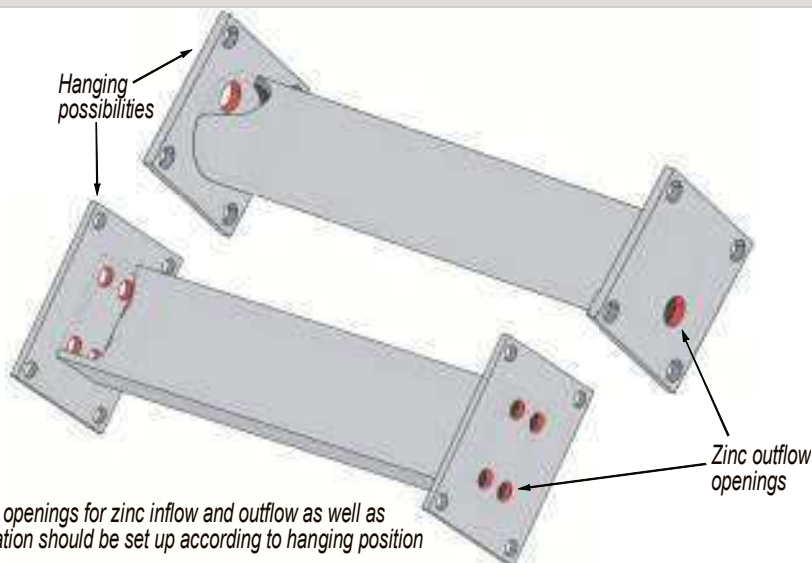
The welding scale causes parts not to be galvanized, therefore it is necessary to remove it. The welding seams must not be porous.

Preventing the formation of dead angles and closed pockets

In order to prevent subsequent work, predict 2mm larger openings. Cut of the inner corners of the triangle supports.



Enabling hanging



The openings for zinc inflow and outflow as well as aeration should be set up according to hanging position

Welding and aeration of double surfaces

Even surfaces must be entirely welded. Double surfaces larger than 5x5cm should be aerated with an opening due to danger of explosion. Larger double surfaces must be aerated with two boreholes at maximum distance. Flexible parts, e.g. poles must be dismantled and have an at least 1-2mm larger opening for galvanizing.

