



**NATIONAL STANDARD OF THE  
PEOPLE'S REPUBLIC OF CHINA**

**GB/T 13912-2020**

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**Metallic coatings--Hot dip galvanized coatings on fabricated  
iron and steel articles--Specifications and test methods**

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### Foreword

This Standard is drafted in accordance with the rules given in GB/T 1.1-2009.

This Standard replaces GB/T 13912-2002 "Metallic coatings - Hot dip galvanized coatings on fabricated iron and steel articles - Specifications and test methods". Compared with GB/T 13912-2002, the main technical changes of this Standard are as follows.

- ADD the terms 3.16 "Zinc melt" and 3.17 "Weld seepage".
- 4.1 "General" incorporates the previous 4.2 "Base metal"; adjust the previous 4.1 "Information to be provided by the purchaser" into Annex A.
- Adjust the previous 6.3 "Uncoating and renovation" into Annex E and make supplements.
- Delete the previous Clause 7 "Test methods". Incorporate the previous 7.1 "Appearance test" and 7.3 "Adhesion test" with the corresponding provisions in Clause 6. Adjust the previous 7.2 "Thickness measurement part" into Annex D.

This Standard uses the redraft law to modify and adopt ISO 1461.2009 "Hot dip galvanized coatings on fabricated iron and steel articles - Specifications and test methods".

Compared with ISO 1461.2009, this Standard has been adjusted in terms of structure. Annex E and Annex C of ISO 1461.2009 have been adjusted to Annex C and Annex E of this Standard, respectively.

The technical differences between this Standard and ISO 1461.2009 and their reasons are as follows.

- As for the normative references, this Standard has made adjustments with technical differences, to adapt to the technical conditions of China. The adjustments are mainly reflected in Clause 2 "Normative references". The specific adjustments are as follows.

? Replace ISO 752 with GB/T 470 which modifies and adopts the international standard (see 4.2);

? Replace ISO 2859-1 with GB/T 2828.1 which is identical to the international standard (see 6.2.3);

? Replace ISO 2859-2 with GB/T 2828.2 which is non-equivalent to the international standard (see 6.2.3);

? Replace ISO 2859-3 with GB/T 2828.3 which is identical to the

international standard (see 6.2.3);

? Replace ISO 2178 with GB/T 4956 which is identical to the international standard (see 6.2.2);

? Replace ISO 3882 with GB/T 6463 which is identical to the international standard (see 6.2.2);

? Replace ISO 2064 with GB/T 12334 which is identical to the international standard (see Clause 3);

? Replace ISO 2808 with GB/T 13452.2 which is identical to the international standard (see 6.2.2);

? Replace ISO 1460 with GB/T 13825 which is identical to the international standard (see 6.2.2);

? Replace ISO 10474 with GB/T 18253 which is identical to the international standard (see Clause 7).

This Standard has made the following editorial changes.

- CHANGE the standard name to "Metallic coatings - Hot dip galvanized coatings on fabricated iron and steel articles - Specifications and test methods";

- According to GB/T 1.1-2009, appropriately supplement and adjust the content of Clause 1 "Scope";

- According to the order mentioned in the standard text, adjust the numbers of Annex C and Annex E.

This Standard was proposed by China Machinery Industry Federation.

This Standard shall be under the jurisdiction of National Technical Committee

## **57 on Metallic and Non-metallic Coating of Standardization Administration of**

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The previous editions of the standard replaced by this Standard were released as follows.

- GB/T 13912-1992, GB/T 13912-2002.

Metallic coatings - Hot dip galvanized coatings on fabricated iron and steel articles - Specifications and test methods

## 1 Scope

This Standard specifies the specifications and test methods for hot dip galvanized coatings on fabricated iron and steel articles. This Standard does not specify the after-treatment and protective coating of hot dip galvanized products.

## 2 Normative references

The following documents are indispensable for the application of this document. For the dated references, only the editions with the dates indicated are applicable to this document. For the undated references, the latest edition (including all the amendments) are applicable to this document.

GB/T 470 Zinc ingots (GB/T 470-2008, ISO 752.2004, MOD)

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in GB/T

### 12334 and the following apply.

Total thickness of coating of zinc and/or zinc iron alloys on iron and steel surface,