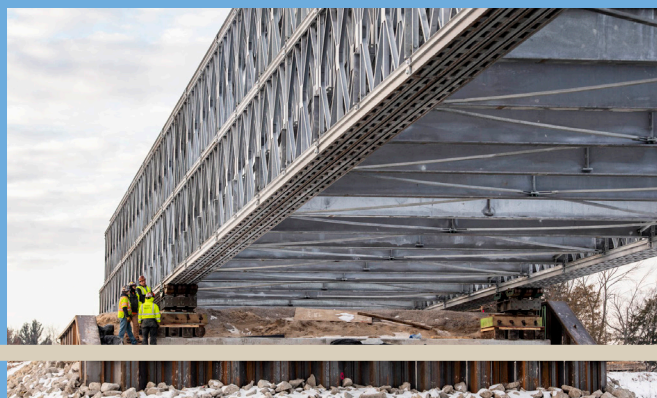




Hot-Dip Galvanizing Specification S8.3—2022



AMERICAN ASSOCIATION
OF STATE HIGHWAY AND
TRANSPORTATION OFFICIALS
AASHTO



AASHTO/NSBA STEEL BRIDGE COLLABORATION

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Preface

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It is intended that owners adopt and implement Collaboration documents in their entirety to facilitate the achievement of standardization. It is understood, however, that local statutes or preferences may prevent full adoption of the document. In such cases owners should adopt these documents with the exceptions they feel are necessary.

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HOT-DIP GALVANIZING SPECIFICATION

Introduction

These Specifications are intended for adoption by owners for galvanizing bridges and other highway structures. Unless otherwise noted, all references to galvanizing in these Specifications refer to the hot-dip galvanizing process. Other zinc coating processes include mechanical galvanizing (a mechanical process commonly used for fasteners), electroplating (which is an electrical process), and metalizing (thermal spray).

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SECTION 1:
SCOPE AND RESPONSIBILITIES

1.1—SCOPE AND RESPONSIBILITIES

C1.1

This Specification covers bridge members and other transportation structures, including expansion joints; drains and scuppers; camera, light, sign, and signal support structures; bridge railing; stairs; walkways; bearings; and ballast plates. The Specification does not cover fasteners or reinforcing steel.

The owner, general contractor, fabricator, and galvanizer must communicate to ensure a shared understanding of the project requirements before the project starts, which may include having a prefabrication meeting.

The fabricator of the component to be galvanized is responsible for preparing the project for galvanizing in accordance with this Specification. This preparation is distinct from the surface preparation steps done by the galvanizer in the hot-dip process.

The entity contracting the galvanizer (usually the fabricator) shall convey project requirements for maintaining traceability, coating thickness limitations superseding this Specification or ASTM A123/A123M, and any special treatments required by the contract.

The galvanizer shall have a documented and implemented quality management system that is internally audited on a regular basis.

One key to providing the best design for the hot-dip galvanizing process is communication among the owner, general contractor, fabricator, and galvanizer. Opening the lines of communication early in the development of design details can eliminate potential costly pitfalls later in the process.

The fabricator or owner may choose to call a prefabrication meeting after award to discuss any questions and ensure common understanding of acceptance criteria, special provisions, hold points, venting needs, and notification for inspections. The meeting typically includes the owner, general contractor, and fabricator. Other subcontractors, such as the galvanizer or duplex coating applicator, may be included. It can be very helpful to address coating issues at the prefabrication meeting, or hold a separate prefabrication meeting to address coatings topics.

Special treatments may include non-galvanized areas, aesthetic appearance, and smoothness. Also, if any other coatings will be applied on the galvanizing, this can affect other choices made in the galvanizing process.

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