

EDS

Engineering,
GM DAEWOO Auto & Technology.
Standards

LEAD-TIN ALLOY COATED STEEL SHEETS, STRIPS AND WELDED PIPES

EDS-M-1310

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VERSION: 2

1. SCOPE

This standard specifies the lead-tin alloy coated steel sheets and strips and welded pipes used by **GM DAEWOO Auto & Technology Company** (hereinafter referred to as the "GMDAT").

2. MANUFACTURING METHOD

These shall be manufactured by dipping properly pretreated cold rolled steel sheets with lead-tin alloy or electrolytic plating.

3. TYPE AND USE

Table 1. Type and Use

Type		Use	Applications
ZP	Equal plating	Gasoline fuel series required corrosion resistance	Fuel tank

4. QUALITY

4.1. Base metal

4.1.1. The chemical composition and mechanical properties of the base metal shall conform to the standard for each base metal. Mainly used base metals are as shown in Table 2 and other base metals may be used.

Table 2. Types of Base Metals

Base metals	Standard
Cold rolled steel sheets and strip	EDS-M-1101

4.1.2. The base metal shall be properly surface-finished for plating and free from impurities and surface defects that may have harmful effect on the plating process or corrosion resistance or appearance after plating.

4.2. Plating layer

4.2.1. Plating layer is composed of lead-tin alloy, and the components of plating layer in accordance with the manufacturing method shall conform to Table 3.

Table 3. Components of Plating Layer

Manufacturing method	Unit wt %		
	Sn	Sb	Pb
Electrolytic plating	5 10	Minute amount	Rest
Dipping	8 15	3 max.	Rest