



WELDING ON ZINGA AND ZINGA ON WELDS

Information given in this document should be used in complement with technical specifications given in the technical data sheet of ZINGA.

WELDING ON ZINGA

The welding of steel coated with ZINGA (max. **60 µm DFT**) is possible without excessive zinc fumes because the heat of the approaching weld bead burns off the organic binder well below the melting point of zinc. The remaining zinc dust is removed from the weld zone by convection leaving the weld-area free from contamination.

If the applied DFT is more than 60 µm, the excessive coating must be removed with a wire brush.

The zingained steelwork must be **free of oil, grease and any chemicals that are flammable**.

Dust and debris should be removed by air gun or by vacuuming.

Do not use silicone based anti-spatter spray on ZINGA because this will cause adhesion failure of any subsequent coatings that will be applied on the ZINGA.

Please ensure that adequate ventilation and extraction is used at all times. When welding zingained steel, the operator must wear a mask that conforms to the regulations.

ZINGA ON WELDING

Before accepting the job, please verify that the welds are in good condition. Holes, undercuts or cracks should be remedied by welding or grinding until a uniform surface is obtained.

The surface should be degreased and cleaned to cleanliness degree St 2. Weld spatters must be removed.

Eliminate all slag and other surface imperfections with a mechanical needle hammer.

Before the application of ZINGA, the welding seams and the surrounding surface must be roughened: preferably by grit-blasting, or otherwise with a needle hammer or with rough sand paper (60 to 80). Be careful not to polish the surface!

After roughening of the surface, a thorough dedusting of the areas to be treated is vital.

Apply the ZINGA by brush in overlap of minimum 5 cm, in one or more layers in order to obtain the specified DFT.