

greater than the paint's dry film thickness (five-ten mils) interfere with adhesion and can cause voids in the paint coating. To smooth out surface blemishes, hand-file or power-sand the area. Be very careful not to remove any more of the protective zinc coating than absolutely necessary.

**CLEANING THE GALVANIZING**

Newly Galvanized Steel No dirt or grease present. Few zinc oxides and hydroxides formed. No major cleaning necessary.

Partially Weathered Galvanized Steel Remove surface oxide and hydroxide film, as well as dirt and grime.

Fully Weathered Galvanized Steel Requires minimal cleaning, such as a warm water power wash to remove contaminants from the surface. Power wash should not exceed 1450 psi.

NOTE: The goal of surface cleaning is to remove the grease, dirt and oils from the galvanized surface in order to promote paint adhesion. If it is determined the galvanized surface needs to be cleaned, any of the methods listed below can be used. Remember, a cleaning solution is meant to clean the zinc surface, not remove it. Some cleaners may react poorly with certain paint systems. Be sure to consult the paint manufacturer regarding specific cleaning instructions.

Alkaline solutions in the pH range of 11-12, but not greater than 13, (dilute sodium hydroxide, trisodium phosphate or similar solutions) can be sprayed at a temperature ideally between 140°F and 185°F. If the solution is brushed on, use a nylon bristle brush — not copper or steel. After cleaning, thoroughly rinse with hot water and allow to dry completely.

Solvent cleaning (mineral spirits, turpentine, high-flash naphtha, or similar solvents) should be used only if they can be applied with lint-free rags or soft bristled nylon brushes. These rags and brushes must be

changed frequently to avoid the respreading of contaminants. After cleaning, thoroughly rinse the surface with hot water and allow to dry completely.

Ammonia cleaning, which should be used in a solution of one to two percent ammonia, is usually only used when ash residue from the galvanizing process is present. Apply the ammonia solution with a nylon brush. After cleaning, thoroughly rinse the surface with hot water and allow to dry completely.

Thorough rinsing ensures that leftover residue from the cleaning solution will not interfere with paint adhesion.

**SURFACE PROFILING**

Sweep Blasting The most common way of profiling galvanized steel. Particle size for a sweep blast of galvanized steel should range between 200 and 500 microns (8-20 mils). Aluminum/ magnesium silicate can be used to sweep blast, as can many types of natural media like corn cobs, walnut shell, corundum, limestone, and mineral sands with a Mohs hardness of five or less. Conditions for sweep blasting are recommended to be less than 50 percent humidity and a minimum of 70°F. Consult SSPC Surface Preparation Specification 7 for sweep blasting procedures.

Overblasting When the galvanized coating is overblasted, too much zinc is removed. Because the zinc protects the steel from corrosion as the paint wears away, the steel will rust if the zinc isn't there to protect it. If this is the case, then the system will fail. To avoid this problem, be sure to use the correct media for sweep blasting galvanized surfaces, and do not blast in one area for too long.

**USING PRIMERS WITH PREPARED GALVANIZED STEEL**

After cleaning and profiling the galvanized surface, a primer coat is often used to help with paint adhesion. Many types of paints

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react poorly when applied directly on prepared galvanized surface. Primers allow for the successful use of many of these paint types. Priming of galvanized surfaces should be done as soon as possible after cleaning and profiling. Because the zinc in the galvanized steel continually reacts with the environment, zinc oxides and hydroxides begin to build-up right away and can cause paints not to bond. Always apply primers according to the manufacturer's directions and specified paint system.

#### APPLYING THE COATING SYSTEM TO PREPARED GALVANIZED STEEL

The paint manufacturer can provide more thorough information about the compatibility of specific systems with galvanized steel. Always consult the paint manufacturer prior to painting galvanized steel. Different physical and chemical characteristics for the same types of paint may have varied reactions with a galvanized surface.

NOTE: Some manufacturers suggest the following for their primers which are specifically designed to paint galvanizing: Allow to weather a minimum of six months prior to coating. Solvent Clean per SSPC-SPI. When weathering is not possible, or the surface has been treated with chromates or silicates, first Solvent Clean per SSPC-SPI and apply a test patch. Allow paint to dry at least one week before testing adhesion. If adhesion is poor, brush blasting per SSPC-SP7 is necessary to remove these treatments. These primers have been used with inconsistent results. And because of VOC restrictions, many are no longer available.

Paint Thickness When paint is not applied to the manufacturer's recommended thickness, the Architecturally Exposed Structural Steel (AESS) system can fail. Too thin of a coating, and the paint will wear away quickly. Too thick of a coating, and the paint may not cure correctly and cause adhesion problems. Always follow the manufacturer's directions for application.

#### CONCLUSION

Obtaining a successful coating project when applying coatings over hot dipped galvanizing can be challenging. When you compare all of the procedures, inspection, testing, cleaning, profiling, etc., with the application of a shop-applied zinc-rich primer, the choice becomes clear. Unless the galvanizing is not going to be coated, the better choice is to use a zinc-rich primer.

In addition, the welds of galvanized steel (which are the most prone to corrosion) are touched-up with zinc. If the critical areas of galvanized touch-up use zinc, doesn't it make sense to prime with zinc?

Tnemec Company suggests the following:

#### SURFACE MUST BE CLEAN AND DRY

Prior to field painting the shop applied zinc-rich primer, all surfaces to be coated shall be clean, and dry. No additional surface preparation is required.

NOTE: For surface preparation and coating system recommendations when applying coatings over galvanized surfaces, please contact your local Tnemec Representative and also refer to Tnemec Technical Bulletin #10-78.

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shaking ideas.

26. Use the apostrophe in its proper place and omit it when its not needed.

27. Eliminate quotations. As Ralph Waldo Emerson said, "I hate quotations. Tell me what you know."

28. If you've heard it once, you've heard it a thousand times: Resist hyperbole; not one writer in a million can use it correctly.

29. Puns are for children, not groan readers.

30. Go around the barn at high noon to avoid colloquialisms.

31. Even IF a mixed metaphor sings, it should be derailed.

32. Who needs rhetorical questions?

33. Exaggeration is a billion times worse than understatement.

34. The passive voice should never be used.

36. Do not put statements in the negative form.

37. Verbs have to agree with their subjects.

38. A writer must not shift your point of view.

39. Place pronouns as close as possible, especially in long sentences of 10 or more words, to their antecedents.

40. Writing carefully, dangling participles must be avoided.

41. If any word is improper at the end of a sentence, a linking verb is.

42. Take the bull by the hand and avoid mixing metaphors.

43. Avoid trendy locutions that sound flaky.

44. Everyone should be careful to use a singular pronoun with singular nouns in their writing.

45. Always pick on the correct idiom.

46. The adverb always follows the verb.

47. Be careful to use the rite homonym. And Finally...

47. Proofread carefully to see if you any words out.

This was written by our dear brilliant friend, architect, specifier and OCCCSI President John Regener. Hopefully, John is looking down on us from above, laughing and approving that we reprinted this very witty piece. John was a once in a lifetime character!



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**OCCCSI**

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## MEETING SCHEDULE AND INFORMATION

### UPCOMING MEETINGS:

**September 11 OCCCSI Board Meeting (5:00 p.m.)  
Membership Meeting (5:45 p.m.)**

**Elks Lodge  
1751 S Elk Lane  
Santa Ana, California**

**October 2 OCCCSI Board Meeting (5:30 p.m.)  
Membership Meeting (5:45 p.m.)**

**Elks Lodge  
1751 S Elk Lane  
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