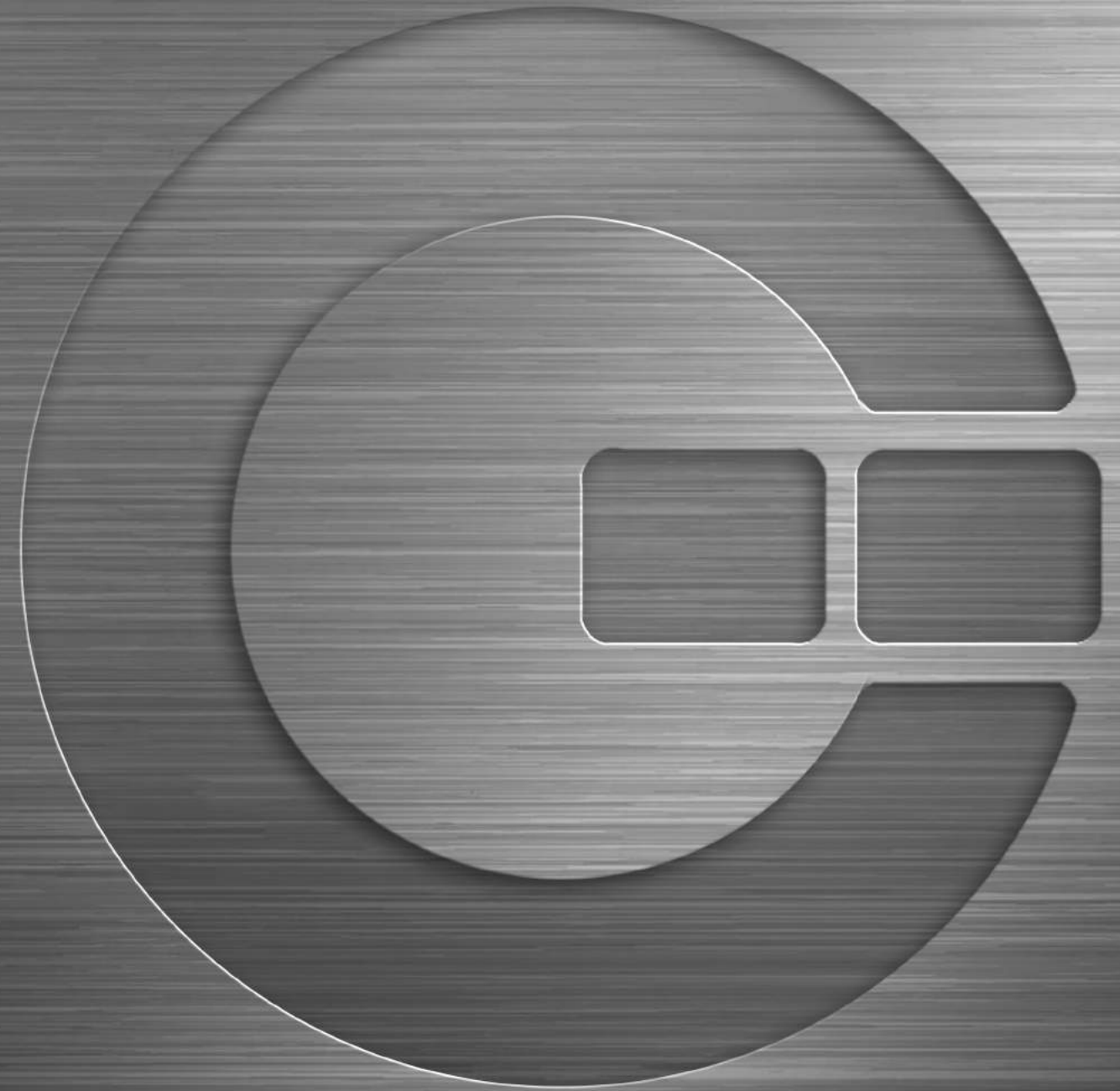


HOT DIP GALVANIZING SERVICES



PT. CITRA GALVANIZING INDONESIA

HEAD OFFICE & FACTORY
Jl. Setia Darma II, RT 004 / RW 003, Dusun II, Desa Setia Darma, Tambun Selatan
Bekasi 17510, Jawa Barat - Indonesia
Phone : +62.21.883.0818 (Hunting) Fax : +62.21.883.0816 / 17
Website : www.cgind.co.id

PT. CITRA GALVANIZING INDONESIA
INDUSTRIAL GALVANIZER



ZINC BATH

Length : 13 meters
 Width : 1.8 meters
 Depth : 2.5 meters
 Capacity : 50,000 tonnes per year

with 9,000 m2 factory building
 in 3,2 Hectare on dedicated land

ABOUT THE PROCESS

Below are the processes to have a perfect layer on Hot Dip Galvanizing :

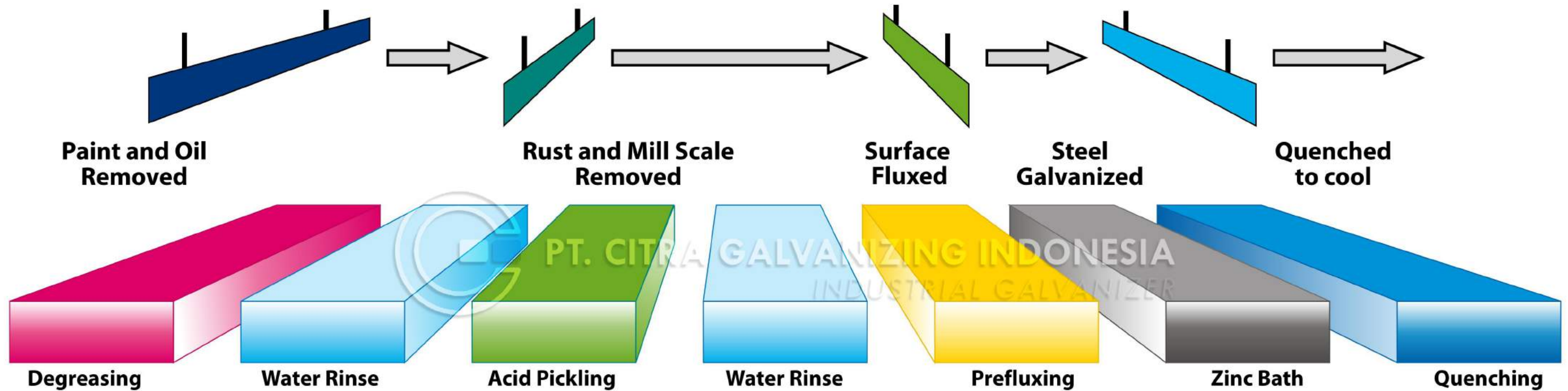
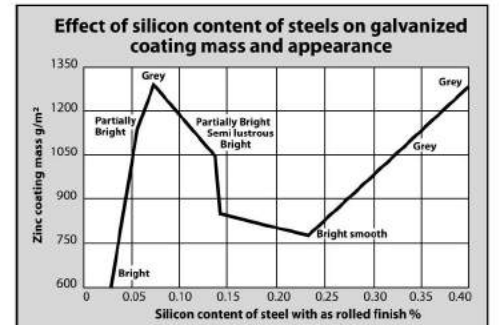
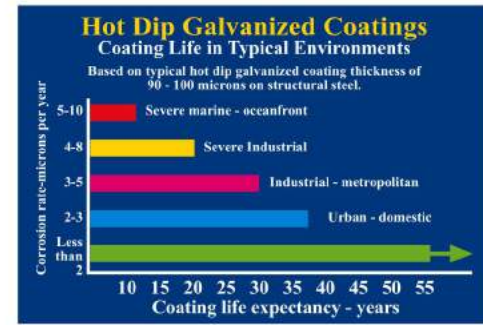
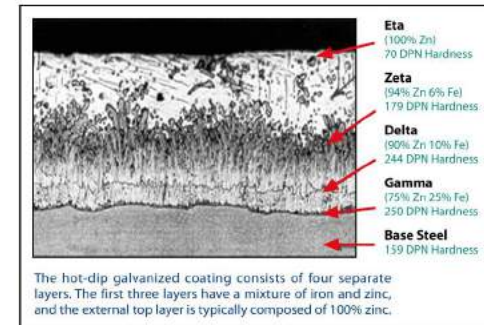
1. Degreasing. Steel products are immersed in a hot alkaline cleaner (Sodium Hydroxide - Caustic Soda) to remove oil, paint or varnish.
2. Water rinsing. Products are water - rinsed before immersion into the pickling acid.
3. Pickling. Steel products are immersed in Hydrogen Chlorides acid to remove rust.
4. Water rinsing. The pickled product is water-rinsed to prevent carrying over of acid into prefluxing.
5. Prefluxing. Cleaning the steel surface with zinc ammonium chloride to form a bonded thick zinc-iron alloy layer.
6. The steel is immersed into a molten zinc bath to get the perfect zinc-iron layer
7. Quenching. Helps to neutralization zinc to avoid oxidation.

FACTORS affecting hot dip galvanized coatings, include :

- the size and shape of the item
- the steel chemistry
- the steel surface condition
- the design of the item with respect to galvanizing
- the metallurgy of the galvanizing process.

Designation : ASTM A123 / A123M - 17
 Standard Specification for
 Zinc (Hot Dip Galvanized) Coating on Iron and Steel Products

Material Category	All Specimens Tested Steel Thickness Range (Measured), in (mm)					
	<1/16 (<1.6)	>1/16 to <1/8 (>1.6 to <3.2)	>1/8 to <3/16 (>3.2 to 4.8)	>3/16 to <1/4 (>4.8 to <6.4)	>1/4 to <5/8 (>6.4 to <16.0)	>5/8 (>16.0)
Structural Shapes	45	65	75	75	100	100
Strip and Bar	45	65	75	75	75	100
Plate	45	65	75	75	75	100
Pipe and Tubing	45	45	75	75	75	75
Wire	35	50	60	65	80	80
Reinforcing Bar	100	100



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