

## **Galvanizing Guidelines**

Harsco Industrial IKG (IKG) recommends that galvanizing for Mebac® coated products be provided by us or contracted directly with Industrial Galvanizers Birmingham in Steele, AL. If the Mebac surface is galvanized by a third party the following guidelines should be observed. IKG is not liable for damage to the Mebac surface by third parties.

- \* Pickling time should not exceed ten (10) minutes in ambient temperature hydrochloric acid solutions. Ideal concentration of these hydrochloric solutions would be 10%. Heated sulfuric acid solutions and not recommended, and, if used, should not exceed one (1) minute immersion.
- \* Care should be taken that rack loading allows for sufficient space between items so that the heat of the pickling process does not create “hot spots” within the pickling tanks and damage to the Mebac surface.
- \* IKG further recommends any additional steel, such as stringers, support angles, stiffeners, etc., be shot or sand blasted prior to attachment to Mebac surfaced materials. These pieces should be de-scaled and rust free prior to submission to the galvanizer.
- \* IKG also strongly recommends that all material be protected from humidity and must be protected from the elements. Surface rust will require sufficient acid pickling to allow for proper galvanizing, and excess acid exposure will result in damage to the Mebac surface. Keep material inside and wrapped to prevent surface rust from forming.
- \* Care must be taken in the pickling portion of the hot dipped galvanizing process as the Mebac surface may lift off if pickling times exceed recommendations. This care should also be exercised in taking the Mebac surfaced items out of the zinc bath, by ‘walking’ the material back and forth in the bath as it is removed – this prevents any puddling and caking of zinc.

IKG strongly recommends galvanizing of Mebac items be galvanized by us or contracted directly with :

**Valmont Industries**  
**475 Dietrich Road**  
**Steele, AL 35987**  
**Phone : (205) 594-5555**  
**Fax : (205) 594-3500**

<http://www.valmont.com/valmont/products/hot-dip-galvanizing-and-coatings>

**Contact : Mr. John Wilcox**