
**Metallic and other inorganic
coatings — Electroplated coatings of
zinc with supplementary treatments
on iron or steel**

*Revêtements métalliques et autres revêtements inorganiques —
Dépôts électrolytiques de zinc avec traitements supplémentaires sur
fer ou acier*





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Contents

	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms, definitions, abbreviated terms and symbols	2
3.1 Terms and definitions.....	2
3.2 Abbreviated terms.....	2
3.3 Symbols.....	2
4 Information to be supplied by the purchaser to the electroplater	2
4.1 Essential information.....	2
4.2 Additional information.....	3
5 Designation	3
5.1 General.....	3
5.2 Designation specification.....	3
5.3 Designation of the basis material.....	4
5.4 Designation of heat treatment requirements.....	4
6 Requirements	5
6.1 Appearance.....	5
6.2 Thickness.....	5
6.3 Trivalent chromium conversion coatings and other supplementary treatments.....	5
6.4 Adhesion of zinc and trivalent chromium conversion coatings.....	5
6.5 Accelerated corrosion testing.....	6
6.5.1 Neutral salt spray test.....	6
6.5.2 Corrosion rating.....	6
6.6 Stress relief heat treatments before cleaning and metal deposition.....	6
6.7 Hydrogen-embrittlement-relief heat treatments after electroplating.....	7
7 Sampling	7
Annex A (normative) Designation of supplementary treatments	8
Annex B (normative) Measurement of average thickness of coating on small articles	10
Bibliography	11

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by the European Committee for Standardization (CEN) Technical Committee CEN/TC 262, *Metallic and other inorganic coatings*, in collaboration with ISO Technical Committee TC 107, *Metallic and other inorganic coatings*, Subcommittee SC 3, *Electrodeposited coatings and related finishes*, in accordance with the agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This fourth edition cancels and replaces the third edition (ISO 2081:2008), which has been technically revised. The following main changes have been made:

- the number of normative references has been reduced;
- reference to ASTM B117 has been replaced with ISO 9227;
- some abbreviated terms have been removed;
- coating designations have been modified;
- reference to ISO 1463 for thickness measurement has been increased;
- reference to use of trivalent chromium has been increased
- reference to use of hexavalent chromium has been reduced;
- reference to ISO 19598 in relation to supplementary Cr(VI)-free treatment has been added;
- Tables 1 and 2 have been replaced with a revised [Table 1](#) on neutral salt spray corrosion resistance;
- reference to ISO 15330 in relation to hydrogen embrittlement testing has been added;
- supplementary treatment designations have been modified;
- Annex C has been removed.

Introduction

Zinc coatings are applied to iron or steel articles for protective and decorative purposes by electrodeposition from acid zinc chloride, alkaline non-cyanide zinc, and alkaline zinc cyanide solutions. Electroplated, bright zinc coatings are popular and the processes for preparing bright zinc coatings are widely used.

The ability of a zinc coating to prevent corrosion is a function of its thickness and the type of service conditions to which it is exposed. For example, the rate of corrosion of zinc will generally be greater in industrial exposures than in rural ones. The type of service condition should, therefore, be taken into consideration when specifying the minimum coating thickness. Trivalent chromate conversion coatings and other supplementary treatments enhance the corrosion resistance of electrodeposited zinc coatings and are commonly applied after electroplating.

Because the appearance and serviceability of zinc coatings depends on the surface condition of the basis metal, agreement should be reached between the interested parties that the surface finish of the basis metal is satisfactory for electroplating.

Trivalent chromate conversion coatings are omitted, or replaced by other conversion coatings, at the specific request of the purchaser. This document provides the codes for all types of chromate conversion and other supplementary coatings.

With reference to Cr(VI)-free conversion coatings, attention is drawn to ISO 19598. ISO 19598 is applicable to zinc, zinc-iron and zinc-nickel plating, where only trivalent systems are required.

Due to the REACH Regulations the use of hexavalent chromium compounds will be banned in Europe from September 2017 except where specifically authorized. Alternative conversion coatings or substitutes, can be used and are required to satisfy the corrosion requirements given in this document.

Standard designations for metals and alloys can be found in References [12] to [16].

Metallic and other inorganic coatings — Electroplated coatings of zinc with supplementary treatments on iron or steel

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1 Scope

This document specifies requirements for electroplated coatings of zinc with supplementary treatments on iron or steel. It includes information to be supplied by the purchaser to the electroplater, and the requirements for heat treatment before and after electroplating.

It is not applicable to zinc coatings applied

- to sheet, strip or wire in the non-fabricated form,
- to close-coiled springs, or
- for purposes other than protective or decorative.

This document does not specify requirements for the surface condition of the basis metal prior to electroplating with zinc. However, defects in the surface of the basis metal can adversely affect the appearance and performance of the coating.

The coating thickness that can be applied to threaded components can be limited by dimensional requirements, including class or fit.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1463, *Metallic and oxide coatings — Measurement of coating thickness — Microscopical method*

ISO 2064, *Metallic and other inorganic coatings — Definitions and conventions concerning the measurement of thickness*

ISO 2080, *Metallic and other inorganic coatings — Surface treatment, metallic and other inorganic coatings — Vocabulary*

ISO 2819, *Metallic coatings on metallic substrates — Electrodeposited and chemically deposited coatings — Review of methods available for testing adhesion*

ISO 3613, *Metallic and other inorganic coatings — Chromate conversion coatings on zinc, cadmium, aluminium-zinc alloys and zinc-aluminium alloys — Test methods*

ISO 4519, *Electrodeposited metallic coatings and related finishes — Sampling procedures for inspection by attributes*

ISO 9227, *Corrosion tests in artificial atmospheres — Salt spray tests*