

JIS

JAPANESE
INDUSTRIAL
STANDARD

Translated and Published by
Japanese Standards Association

JIS G 3323 : 2019

(JISF)

**Hot-dip zinc-aluminium-magnesium
alloy-coated steel sheet and strip**

ICS 77.140.50

Reference number : JIS G 3323 : 2019 (E)

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5 Coating

5.1 Plating bath composition

Plating bath shall be tested for composition in accordance with **13.2** and shall be as given in Table 6.

NOTE In the hot-dip coating process, the base metal is immersed in a molten metal bath at a high temperature, and then cooled to form a coating on the base metal surface. This molten metal bath is called plating bath.

Table 6 Plating bath composition

Unit: %			
Al	Mg	Elements other than Al, Mg and Zn	Zn
5.0 or over up to and incl. 13.0	2.0 or over up to and incl. 4.0	1.0 max. ^{a)}	Remainder ^{b)}
Notes ^{a)} The figure indicates the total amount of elements which are added intentionally.			
^{b)} The remainder may include elements which are mixed unavoidably.			

5.2 Coating mass

5.2.1 Symbol for coating mass

The coating applied shall be of equivalent thickness on both surfaces. The symbols for coating mass shall be as given in Table 7.

5.2.2 Coating mass

The sheets, coils and corrugated sheets shall be tested for coating mass in accordance with **13.3.2** and shall satisfy the following requirements.

- a) The coating mass of sheets, coils and corrugated sheets shall be expressed by the total mass on both surfaces and shall meet the minimum triple-spot average coating mass value and the minimum single-spot coating mass value given in Table 7. The minimum triple-spot average coating mass shall apply to the average of the measured values of three test pieces taken from the sample, and the minimum single-spot coating mass shall apply to the smallest value among the measured values of the three test pieces of which the average value is obtained. When coating mass is measured in accordance with Annex D, the minimum coating mass values in the table shall apply to the average coating mass and minimum coating mass obtained according to **D.6.5**.

NOTE It is desirable that the coating mass on one side be not less than 40 % of the required value for the minimum single-spot coating mass (total mass on both surfaces).