

1 M × 7.25 M BATH

# Hot & Cold Dip Galvanizing

Hot dip galvanizing at 2,500 tonnes a month in a bath up to 1 m × 7.25 m, plus a cold dip line at 50 tonnes a month — to IS 4759 or ISO 1461, and open to external fabricators.

HOT DIP

**2,500 tonnes a month**

COLD DIP

**50 tonnes a month**

STANDARD

**IS 4759 · ISO 1461**



Members leaving the zinc bath

## Coating we control.

Galvanizing was added to the campus for a specific reason: coating was the step that most often delayed tower and structure delivery when it sat with a third party.

Keeping it in-house lets us control coating quality and turnaround on our own structural output — and we sell the same capacity as job work to external fabricators who face the queues we used to.

### Bath 1 m × 7.25 m

The first question every fabricator asks, answered up front.

### 2,500 ton / month

Hot dip capacity. Cold dip line at 50 tonnes a month.

### Job work accepted

External fabricators welcome alongside our own output.

#### OWN OUTPUT

##### Towers and structures

Every tower, gantry and cross-arm we fabricate.

#### THIRD PARTY

##### External fabricators

Job-work galvanizing for other fabricators and contractors.

#### INFRASTRUCTURE

##### Structural steel

Bridge, building and industrial steelwork.

#### UTILITY

##### Line hardware

Cross-arms, brackets, clamps and pole fittings.

Fields marked "On enquiry" are issued against a specific enquiry. Full specification, reference tables and fittings: [aggarwalglobal.com/products/galvanizing.html](http://aggarwalglobal.com/products/galvanizing.html)

#### FACILITY

|                     |                                                              |
|---------------------|--------------------------------------------------------------|
| Process             | Hot dip galvanizing and cold dip (electro) galvanizing       |
| Hot dip bath size   | Up to 1 m × 7.25 m                                           |
| Hot dip capacity    | 2,500 tonnes per month                                       |
| Cold dip bath size  | Up to 1 m × 3 m                                              |
| Cold dip capacity   | 50 tonnes per month                                          |
| Order size accepted | Job work from small lots upward — ask for current turnaround |
| Turnaround          | On enquiry — by tonnage band                                 |

#### COATING

|                           |                                                              |
|---------------------------|--------------------------------------------------------------|
| Coating standard          | IS 4759:1996; ISO 1461:2009 where specified                  |
| Process standard          | IS 2629:1985                                                 |
| Zinc bath temperature     | 445 to 465 °C                                                |
| Zinc purity               | To IS 209                                                    |
| Pickling                  | Hydrochloric or sulphuric acid, per IS 2629                  |
| Embrittlement precautions | Per IS 6158 for high tensile steel                           |
| Certificate issued        | Coating mass, uniformity and adhesion results with every lot |

#### STANDARDS

|               |                                                                                            |
|---------------|--------------------------------------------------------------------------------------------|
| IS 2629:1985  | Recommended practice for hot dip galvanizing of iron and steel — the process standard      |
| IS 4759:1996  | Hot dip zinc coatings on structural steel and other allied products — the product standard |
| IS 6745:1972  | Determination of mass of zinc coating on zinc coated iron and steel articles               |
| IS 2633:1986  | Methods for testing uniformity of coating of zinc coated articles                          |
| IS 6158:1984  | Precautions against embrittlement of hot dip galvanized structural steel                   |
| IS 209        | Zinc ingot                                                                                 |
| ISO 1461:2009 | Hot dip galvanized coatings on fabricated iron and steel articles                          |
| ASTM A385     | Practice for providing high quality zinc coatings — venting and drainage guidance          |



#### ENQUIRIES

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#### WORKS AND OFFICE

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Delivery as per the client's requirement, confirmed with the quotation. Ex Factory or FOB for export.