AMENDMENT NO. 1

AMENDMENT TO ISRAEL STANDARD	HOT-DIP ZINC COATINGS ON STEEL AND CAST IRON PRODUCTS	SI 918 December 1979

This is a true translation of the Hebrew original. In any case of discrepancy between the original Hebrew text and the English translation, the Hebrew version shall prevail.

This Amendment Sheet updates Israel Standard SI 918 of April 1975

Clause 102. Definitions

Clause 102.2 – Coated surface

The text in the first sentence shall be deleted and replaced by the following:

The coated surface on one face of the product, as determined by the Israel Standard applicable to the product;

Clause 102.4 – Measuring surface

The text in the first sentence shall be deleted and replaced by the following:

Part of the principal surface on which one thickness measurement is taken.

Clause 108. Special instructions

The first paragraph in the clause shall be deleted and replaced by the following:

Due to the special nature of the galvanizing process, the customer shall provide the coater with complete details of the composition of the base metal and its properties, specifically if the steel is killed steel[8] or semikilled steel[9]. When coating steel with a silicon content greater than 0.3 %, the zinc coating process is much faster than on steel whose silicon content is less than 0.3 %. Therefore, during the coating of such a steel, the requirements shall be coordinated between the coater and the customer.

Clause 204. Coating thickness

At the end of the first sentence, the words, "on one face" shall be added.

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[8] Not relevant to the translation.
[9] Not relevant to the translation.

Table 1 –

Table 1 shall be deleted and replaced by the following table:

Table 1

The product	Average of number of agreed items		On one item	
	Coating weight per unit area, coated on one side, min. (g/m^2)	**Approximate coating thickness**[10] (micrometer)	**Coating weight per unit area, coated on one side, min.** (g/m^2)	**Approximate coating thickness**[10] (micrometer)
Steel, 8 mm thick or greater	600	85	500	70
Steel, 5 mm thick or greater but less than 8 mm	500	70	450	65
Steel, 3 mm thick or greater but less than 5 mm	400	55	350	50
Steel, less than 3 mm thick	350	50	300	40
Bolts and nuts whose thread diameter is greater than 9 mm	375	55	300	40
Cast iron or steel castings	600	85	500	70

Clause 301. Coating thickness measurement

Clause 301.1.1 – Preparation of the reactant

The words, "20 g", shall be deleted and replaced by "2 g".

Clause 301.1.2 – Test procedure

The following paragraph shall be added at the end of the clause:

When measuring the coating thickness of a stored product, it is recommended that an accepted chemical method be used to determine the amount of zinc dissolved and transferred from the product to the dissolving reactant solution (m_3 g).

Clause 301.1.3 – The calculation

The following paragraph shall be added at the end of the clause:

When determining the amount of zinc in the dissolving reactant solution, the weight per unit area of coating (W g/m^2) shall be calculated according to the formula:

$$W = \frac{m_3 \cdot 10^6}{A}$$

The thickness of the coating layer (t micrometers) may also be calculated by the formula:

$$t = \frac{141 \cdot 10^3 \cdot m_3}{A}$$

Clause 301.6 – Calculation of the coating weight according to the thickness

The last paragraph in the clause shall be deleted.

Table 2

Table 2 shall be deleted.

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[10] In order to convert the coating weight per unit area coated (g/m^2) to coating thickness (micrometers), divide the coating weight per unit area by 7.1.