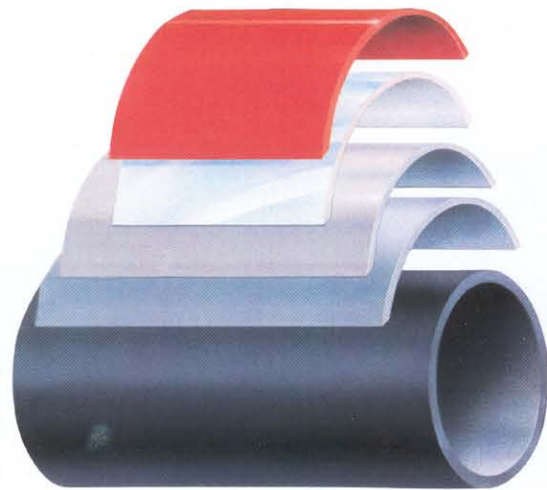


Restoring Corrosion Resistance to Welds and Powder Coating



Restoring Corrosion Protection After Welding

The heat generated from the welding process vaporizes the protective zinc coating near the weld. Even though the remaining zinc continues to provide some protection to the zinc-free areas, the appearance is poor and the zinc-free area will rust when exposed to the environment. The same applies to the interior (ID) of the tube, except exposure to the environment is minimal.

There are several zinc rich paints and cold galvanizing compounds available which will restore corrosion protection to the weld areas on both the ID and OD, with varied application methods. It should be noted that it is necessary to take the proper steps in cleaning the surface of weld slag and oil to insure a strong mechanical bond. These are dealt with in detail in a booklet available from Allied titled "Restoring Corrosion Protection".

Heat-Resistant Cold Galvanizing for Powder Coating Applications

Salt spray tests have shown that painting or powder coating over zinc increases the rust-free product life up to 5 times. For customers who powder coat, and are concerned about additional corrosion protection in the weld zones, cold galvanizing compounds are available that are heat resistant, and act as a primer for powder coating. The following heat-resistant products will withstand the continuous 360-400°F heat cycle for 10-14 minutes that is common to most powder coating systems. They can also withstand up to 750°F for a limited amount of time.

Galvilite by ZRC*

ZRC Products Co.
145 Enterprise Drive
Marshfield, MA 02050
(800) 831-3275
www.zrcworldwide.com

Rustolastic #24-A-120 Kalcor

M.A. Bruder & Sons
600 Reed Road
Broomall, PA 19008
(800) 622-1899
www.mabpaints.com

75% Zinc Dust Epoxy Primer #61-2373

Kalcor Coatings
37721 Stevens Blvd
Willoughby, OH 44094
(440) 946-4700
www.kalcor.com

*Galvilite is also available directly from Allied Tube & Conduit.

For more information on restoring corrosion resistance after welding galvanized tubing, contact your local Allied Tube sales representative, or call Allied's Mechanical Tube Division at (800) 882-5543.

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