

Section 645—Repair of Galvanized Coatings

645.1 General Description

This work includes field repairing damaged galvanized coatings, except coatings on wire and chain-link wire fence.

When galvanized materials are welded, the work applies to the welded area and to the damaged areas adjacent to the weld. It does not apply to new materials deficient in coating.

645.1.01 Definitions

General Provisions 101 through 150.

645.1.02 Related References

A. Standard Specifications

[Section 870—Paint](#)

B. Referenced Documents

General Provisions 101 through 150.

645.1.03 Submittals

General Provisions 101 through 150.

645.2 Materials

Use material for repairing galvanized coatings that conforms to the following:

Material	Section
Galvanizing Repair Compound	870.2.05

645.2.01 Delivery, Storage, and Handling

General Provisions 101 through 150.

645.3 Construction Requirements

645.3.01 Personnel

General Provisions 101 through 150.

645.3.02 Equipment

General Provisions 101 through 150.

645.3.03 Preparation

Before applying repair compounds:

1. Clean the area of grease using an approved solvent recommended by the producer of the galvanizing repair compound.
2. Thoroughly brush the area with a stiff wire brush to remove dirt, loose galvanizing, welding slag, or other foreign material.

645.3.04 Fabrication

General Provisions 101 through 150.

645.3.05 Construction

Apply the repair compound smoothly and evenly with a moderately filled paint brush when the temperature of the steel, compound, and surrounding air is above 45 °F (7 °C). On smooth surfaces, ensure that the minimum dry film thickness is 2 mils (0.05 mm).

On rough and pitted surfaces, the Engineer may require more than one coat. When additional coats are required, allow a drying time of at least four hours between coats. Do not brush over partly dried applications.

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645.3.06 Quality Acceptance

General Provisions 101 through 150.

645.3.07 Contractor Warranty and Maintenance

General Provisions 101 through 150.

645.4 Measurement

This work will not be measured separately for payment.

645.4.01 Adjustments

General Provisions 101 through 150.

645.5 Payment

This work shall be performed at the Contractor's expense.

645.5.01 Adjustments

General Provisions 101 through 150.