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Continuous hot-dip zinc-coated twin-roll cast steel sheet of commercial quality

Tôles coulées entre cylindres et galvanisées en continu par immersion à chaud, en acier de qualité commerciale

Reference number
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Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 12, *Continuous mill flat rolled products*.

This second edition cancels and replaces the first edition (ISO 15208:2012), which has been technically revised.

The main changes are as follows:

— editorial update;

— update of Clause 3;

— modification of the title of Clause 4.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

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Continuous hot-dip zinc-coated twin-roll cast steel sheet of commercial quality

1 Scope

This document specifies the requirements for steel sheet, in coils and cut length, metallic-coated by the continuous hot-dip zinc-coated twin-roll cast process of commercial quality.

The steel sheet is intended for applications requiring corrosion resistance, formability and paintability.

The steel sheet is produced in a number of grades, coating masses, surface treatments and ordering conditions.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1460, *Metallic coatings — Hot dip galvanized coatings on ferrous materials — Gravimetric determination of the mass per unit area*

ISO 2178, *Non-magnetic coatings on magnetic substrates — Measurement of coating thickness — Magnetic method*

ISO 3497, *Metallic coatings — Measurement of coating thickness — X-ray spectrometric methods*

ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature*

ISO 7438, *Metallic materials — Bend test*

ISO 16163, *Continuously hot-dipped coated steel sheet products — Dimensional and shape tolerances*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at https://www.electropedia.org/

3.1
commercial quality
base-metal quality intended for general fabricating purposes where sheet is used in the flat condition, or for bending or moderate forming

3.2
continuous hot-dip zinc-coated steel sheet
product in coils or cut lengths manufactured on a continuous coating line with a hot-dip zinc coating on base-metal of cold-reduced or hot-rolled descaled steel

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3.3
normal spangle
finish obtained as a result of unrestricted growth of zinc crystals during normal solidification

Note 1 to entry: This coating has a metallic lustre and is the type normally furnished for a wide variety of applications. It can be furnished S (normal spangle with skin pass) or N (normal spangle, no skin pass), however, it can be variable in appearance and not suitable for decorative paintings.

3.4
minimized spangle
finish obtained by restricting normal spangle formation during the solidification of the zinc

Note 1 to entry: This product can have some lack of uniformity in surface appearance within a coil or from coil to coil.

3.5
differential coating
coating deliberately produced to have a different coating mass on each surface

3.6
skin pass
light cold rolling of the product

Note 1 to entry: The purpose of the skin passing is one or more of the following: to minimize the appearance of coil breaks, stretcher strains and fluting; to control the shape or to obtain the required surface finish.

Note 2 to entry: Some increase in hardness and some loss in ductility will result from skin passing.

3.7
twin-roll cast steel sheet
steel sheet produced by casting to near final thickness directly from the liquid metal with minimal hot-rolling to achieve the final thickness

3.8
lot
up to a specified quantity of steel sheet of the same designation rolled to the same thickness and coating condition

3.9
coating mass
total amount of zinc on both surfaces of the sheet, expressed in grams per square meter (g/m^2) of sheet

4 Dimensions

4.1 Zinc-coated commercial quality twin-roll cast steel sheet is produced in thicknesses up to 2,0 mm, inclusive, after zinc coating, and in widths up to 2 000 mm in coils and cut lengths. Zinc-coated twin-roll cast steel sheet less than 600 mm wide, slit from wide sheet, is considered as sheet.

4.2 The thickness of zinc-coated twin-roll cast steel sheet may be specified as a combination of the base-metal and metallic coating or base-metal alone. The purchaser shall indicate on the order which method of specifying thickness is required. If the purchaser does not indicate any preference, the thickness as a combination of the base-metal and coating shall be provided. Annex A describes the requirements for specifying the thickness as base-metal alone.

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