

Fasteners — Hot dip galvanized coatings

ICS 21.060.01; 25.220.40

Confirmed
May 2008

National foreword

This British Standard is the UK implementation of EN ISO 10684:2004. It is identical with ISO 10684:2004, incorporating corrigendum July 2008.

The UK participation in its preparation was entrusted by Technical Committee FME/9, Nuts, bolts and accessories/Steering committee, to Subcommittee FME/9/1, Material.

A list of organizations represented on this subcommittee can be obtained on request to its secretary.

The UK as a member of CEN, is obliged to publish EN ISO 10684:2004 as a British Standard. However, attention is drawn to the fact that during the development of this European Standard, the UK consistently voted against its approval as a European Standard for the following reasons:

1. Clause 4.1 gives a silicon and phosphorous composition range (0.03 % to 0.13 %) where galvanizing at high temperature is recommended. The UK committee believe that galvanizing at normal temperature can also be applied to this range if adequate precautions are taken.
2. The UK committee disagree with the specified bath temperature range (455 to 480 °C) in clause 5.5. The operating temperature of galvanizing baths in the UK is feasible at 440 to 465 °C.
3. Currently, there is no widely accepted adhesion test available at national or international level due to a lack of reproducibility. The issue regarding reproducibility would also apply to the test in Annex E.
4. The committee believe that the maximum coating thicknesses in Tables 1 and 2 are too restrictive. It is quite possible that for any particular batch of material, coating thicknesses outside the ranges allowed can be produced.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

Compliance with a British Standard cannot confer immunity from legal obligations.

Amendments/corrigenda issued since publication

Date	Comments
30 November 2009	Implementation of ISO corrigendum July 2008. Table 1, column 12, for Pitch 5,5, 398 changed to 298

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EUROPEAN STANDARD

EN ISO 10684

NORME EUROPÉENNE

EUROPÄISCHE NORM

July 2004

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English version

Fasteners - Hot dip galvanized coatings (ISO 10684:2004)

Éléments de fixation - Revêtements de galvanisation à chaud (ISO 10684:2004)

Verbindungselemente - Feuerverzinkung (ISO 10684:2004)

This European Standard was approved by CEN on 17 June 2004.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

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