



**NSAI**  
Standards

Irish Standard  
I.S. EN 13438:2013

Paints and varnishes - Powder organic coatings for hot dip galvanised or sherardised steel products for construction purposes

## I.S. EN 13438:2013

*Incorporating amendments/corrigenda/National Annexes issued since publication:*

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English Version

## Paints and varnishes - Powder organic coatings for hot dip galvanised or sherardised steel products for construction purposes

Peintures et vernis - Revêtements de poudre organique pour produits en acier galvanisé à chaud ou shéardisé utilisés dans la construction

Beschichtungsstoffe - Pulverbeschichtungen für feuerverzinkte oder sherardisierte Stahlerzeugnisse für Bauzwecke

This European Standard was approved by CEN on 19 July 2013.

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 CEN-CENELEC Management Centre or to any CEN member.

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## Foreword

This document (EN 13438:2013) has been prepared by Technical Committee CEN/TC 139 "Paints and varnishes", the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by March 2014, and conflicting national standards shall be withdrawn at the latest by March 2014.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 13438:2005.

In relation to EN 13438:2005, the following main amendments have been made:

- a) the term defined as "test sample" has been removed;
- b) a new term "substrate" has been introduced;
- c) a paragraph in Clause 4 includes references to EN ISO 14713-2 and EN ISO 14713-3 to optimise design of articles sent for processing to this standard;
- d) tolerance limits on gloss requirements has been tightened slightly for gloss levels over 50 units (reduced from  $\pm 10$  units to  $\pm 7$  units) and "Table 1 — Gloss requirements" removed;
- e) Clause 6 has been edited to clarify references to "cleaning" as distinct from "preparation" or "pretreatment";
- f) reference to (old) Table 1 in 6.5.5 "Gloss" has been removed;
- g) an adhesion test on the finished powder coated article is now not mandatory (see revised 6.5.6) and if required should be specified;
- h) a new "Table 1 — Summary of tests" has been included for ease of reference, after Clause 7;
- i) the minimum thickness of coated test panels used for tests for mechanical properties has been increased from 0,3 mm to 1,0 mm (see A.3.1);
- j) reference to updated standards have been included, e.g. replacement of ISO 7724-3 with EN ISO 11664-4 (see A.4.2) and replacement of ISO 1518 with EN ISO 1518-1 (see A.4.5);
- k) Annex B has been edited to clarify references to "cleaning" and "pretreatment" and the content reduced;
- l) the possibility of an adhesion test on finished article now included in Annex D (see D.3.5);
- m) the content of Annex E has been reduced – reference has been made to EN 15773 for further information.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

## Introduction

This European Standard has been produced as a result of the growing demand for products made of powder coated hot dip galvanised or sherardised steel. These products offer a combination of corrosion resistance and decorative appearance.

It is assumed in the drafting of this standard that the specified test methods will be applied by those who are suitably trained and supervised.

This European Standard has been written from a coating performance perspective and does not seek to set out one method of powder coating hot dip galvanised or sherardised steel products. Nevertheless, in order to facilitate production of the best quality powder coated hot dip galvanised or sherardised articles, experience has shown how important it is that sufficient dialogue between the client, specifier, designer, fabricator, galvaniser or sherardiser and powder coating applicator takes place at the earliest stages of the project and that, where possible, timescales set out for processing of the work are practical and adhered to.

It is strongly recommended that the guidance document for supply of duplex coatings, EN 15773, *Industrial application of powder organic coatings to hot dip galvanized or sherardized steel articles [duplex systems] — Specifications, recommendations and guidelines*, is used in combination with this standard when specifying for duplex systems.

## 1 Scope

This European Standard specifies performance requirements for organic coating powders and powder organic coatings as applied to finished articles (hot dip galvanised or sherardised steel products) for construction purposes. Hot dip galvanised steel products can be articles that have been batch hot dip galvanised (hot dip galvanised after fabrication) or articles consisting of continuously hot dip galvanised sheet which is then subsequently fabricated.

This European Standard does not set out any performance requirements for the powder coating process itself. Guidance on cleaning and pretreatment of the hot dip galvanised or sherardised steel products prior to powder coating is provided.

This European Standard does not apply to articles with zinc-aluminium coatings or aluminium-zinc coatings, or to continuously hot dip galvanised wire. This standard does not apply to organic coating powders and powder organic coatings as applied to hot dip galvanised or sherardised steel products (i.e. duplex coated articles) for which there are specific standards, which might include additional requirements or requirements which are different from those of this standard.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 10346, *Continuously hot-dip coated steel flat products — Technical delivery conditions*

EN 13811, *Sherardizing — Zinc diffusion coatings on ferrous products — Specification*

EN ISO 1461, *Hot dip galvanized coatings on fabricated iron and steel articles — Specifications and test methods (ISO 1461)*

EN ISO 1518-1, *Paints and varnishes — Determination of scratch resistance — Part 1: Constant loading method (ISO 1518-1)*

EN ISO 1519, *Paints and varnishes — Bend test (cylindrical mandrel) (ISO 1519)*

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

EN ISO 2409, *Paints and varnishes — Cross-cut test (ISO 2409)*

EN ISO 2808, *Paints and varnishes — Determination of film thickness (ISO 2808)*

EN ISO 2810, *Paints and varnishes — Natural weathering of coatings — Exposure and assessment (ISO 2810)*

EN ISO 2813, *Paints and varnishes — Determination of specular gloss of non-metallic paint films at 20°, 60° and 85° (ISO 2813)*

EN ISO 3231, *Paints and varnishes — Determination of resistance to humid atmospheres containing sulfur dioxide (ISO 3231)*

EN ISO 3668, *Paints and varnishes — Visual comparison of the colour of paints (ISO 3668)*

EN ISO 4618:2006, *Paints and varnishes — Terms and definitions (ISO 4618:2006)*



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