

Canadian Sheet Steel Building Institute

CRESTVIEW PLAZA, SOUTH SERVICE RD.
MISSISSAUGA, ONTARIO

April, 1973

ORDER PROCEDURE FOR ASTM A446 ZINC-COATED SHEET STEEL FOR STRUCTURAL BUILDING PRODUCTS

As of 13 March 1973 the Institute Member Companies agreed to an order procedure based on 3 decimals in accordance with the following Tables and Notes.

TABLE 1

ORDER THICKNESS AND TOLERANCE: ASTM A446 ZINC-COATED STEEL SHEETS, COILS AND CUT LENGTHS

CORE NOMINAL THICKNESS (Mils) (1)	ORDER THICKNESS (Inches) (2)		TOLERANCE ON ORDER THICKNESS Over & Under (Inches) (3)	FORMER CORE GAUGE EQUIVALENT (4)
	Wiped Coat (5)	G90 (6)		
105	0.105	0.107	0.008	12
75	.075	.077	.007	14
60	.060	.062	.005	16
48	.048	.050	.005	18
36	.036	.038	.004	20
30	.030	.032	.004	22
24	.024	.026	.004	24
18	.018	.020	.003	26

Notes:

- 1) Core Nominal Thickness is used to establish section properties of members and in design calculations but is not part of ordering procedure. Core nominal thickness is expressed in mils as a convenient terminology in lieu of gauge equivalent.
- 2) Order Thickness is the combined thickness of steel core and zinc coating (expressed in inches to three decimal places) to be ordered by the Purchaser; and supplied by the Mill within the stated tolerances.
- 3) Tolerance on Order Thickness includes allowance for variation in both steel core thickness and coating thickness.
- 4) Former Core Gauge Equivalent is for correlation only, with previous practice.

(over)

- 5) Wiped Coat sheet has a zinc alloy coating guaranteed to weigh not less than 0.25 ounces per square foot, total both sides, by triple spot test. The order thickness and core nominal thickness are shown as the same because the thickness increment for wiped coat can be disregarded for all practical purposes when ordering to three decimal places.
- 6) G90 sheet has a zinc coating with a nominal thickness of 0.002 inches (2 mils), total both sides. Order thickness for sheet required to have a zinc coating designation greater than G90 is obtained by adding to the G90 order thickness the applicable increment from Table 2.

TABLE 2

ADDITIONAL THICKNESS INCREMENTS FOR HEAVIER ZINC COATINGS

Specified Zinc Coating Designation	Add to G90 Order Thickness (Table 1)
G115	Nil
G140	0.001 inches
G165	.001
G185	.001
G210	.002
G235	.002

TENSILE PROPERTIES

Tensile strengths are calculated from the actual base metal thickness after stripping of the coating. The nominal core and zinc coating thicknesses indicated above are for order procedure, product design and general information purposes only.

TYPICAL ORDER DESCRIPTION

"20,000 lbs. maximum, Galvanized coil, ASTM A446 Grade A, Coating G90, Passivated, Oiled, 0.032 x 48 inches, 20 inches ID, for Cladding"