



Employee owned. Family founded. Made in the USA.

## Hot Dipped Galvanized Steel

### **Corrosion Resistance**

Durable zinc coating provides both barrier and sacrificial protection. Service life depends on coating thickness and environment. It is typically ordered as G40/G60/G90 coating weights, but other weights are available.

### **Surface Appearance**

Available in bright, matte, passivated/chromated, and oiled/uncoiled finishes. Spangle options include large, medium, minimized, and zero. Hercules Industries supplies a minimized spangle, smooth, bright finish as standard.

### **Formability**

Produced to ASTM A653. CS Type B is standard (moderate forming, lock-forming quality). Other grades include DS (drawing steel) and DDS (deep drawing steel).

### **Paintability**

Not naturally paintable. Surface treatment or cleaning is required for adhesion. For painting, order without chromate and with light oil.

### **Weldability**

Compatible with spot, MIG, TIG, stick, and resistance welding. Proper ventilation is essential due to zinc oxide fumes. Expect more spatter and porosity vs. bare steel. Pre-cleaning and post-weld touch-up recommended.

### **Coating Characteristics**

Uniform zinc coating with a thin zinc-iron alloy layer improves adhesion and durability during forming. Various coating weights available—contact Hercules for non-standard options.

### **Surface Protection & Lubrication**

Options include:

- Chemically Treated – Dry: Protects in transit; not for painting.
- Light Oil – No Chem Treat: Ideal for downstream painting/coating.

Specify surface treatment based on intended end-use.