American Railway Engineering and Maintenance-of-Way Association
Letter Ballot 15-22-10

Assignment: At the February 2022 meeting, a ballot was proposed and accepted by the subcommittee and general committee members present to revise the commentary article on Galvanizing. This ballot presents the edits of the material for Article 9.3.4.1.4c.

Rationale: With subcommittee work in this article, it was deemed beneficial to incorporate progressive dipping as an option, so the subcommittee voted to bring this material for a letter ballot.

Submitted by: John Sanders, Chair SC8 (Coatings & Special Construction)

Due Date: April 29, 2022

Edit existing Article 9.3.4.1.4c as shown below (additions shown as **underlined bold red**, deletions shown as ~~**bold red strikethrough**~~, comments in brackets [ ] not part of published material).

9.3.4.1 COATING OF NEW STRUCTURAL STEEL (~~**2022**~~**2023**)

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9.3.4.1.4 Galvanizing

a. ASTM A123 is the … [unchanged]

b. Tin is avoided … [proposed by LB 15-22-09, unchanged by this ballot]

c. When considering galvanizing of large structures, size limits, including the available kettle ~~**sizes**~~ **sizes,** should be considered. The American Galvanizers Associations (AGA) publishes information about kettle size limits and kettle availability on their website, www.galvanizeit.org, and states "The average kettle length in North America is 40 feet, and there are many kettles between 50-60 feet."

Components that are longer than kettle lengths can be galvanized by progressive dipping. In progressive dipping, one end of the component is dipped into the molten zinc bath and then withdrawn, and then the other end of the component is dipped and withdrawn. The galvanizer overlaps the dipped areas as needed to ensure full coverage. Usually, the overlap is a few inches wide and results in an innocuous overlap line. For additional information, refer to the online AGA Progressive Dipping Calculator at https://galvanizeit.org or contact a local galvanizer.