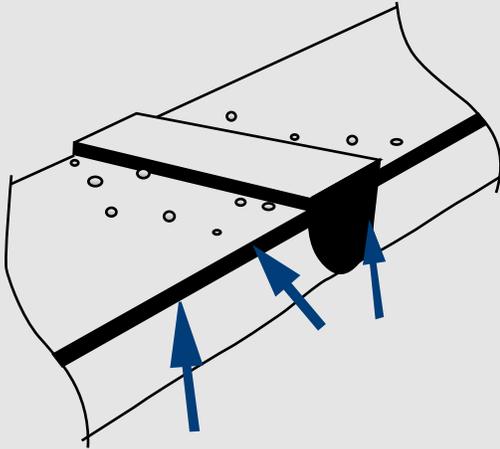


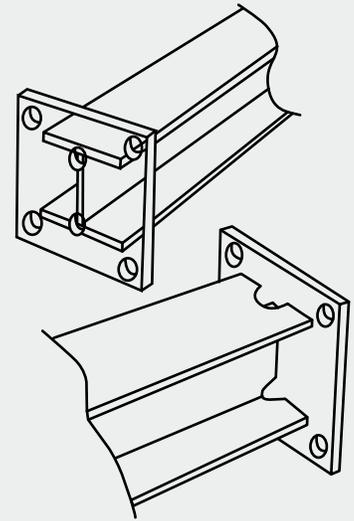
CONCEPTION

Vent and draining holes

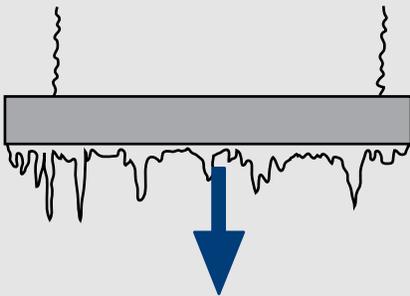


Thicker coating at weld due to higher silicon content of weld metal

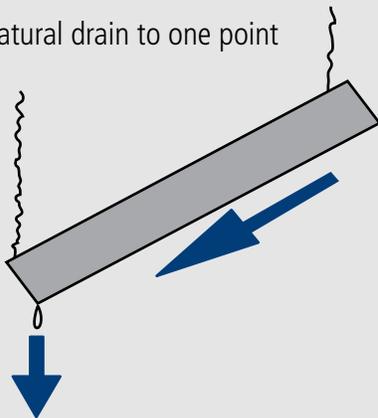
Weld splatter will be galvanized into the coating and should be removed during fabrication to avoid unsightly appearance.



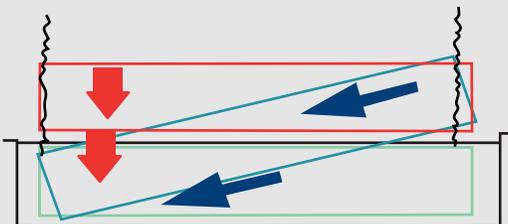
Zinc drips off causing spikes (dags) and a very rough surface



Natural drain to one point

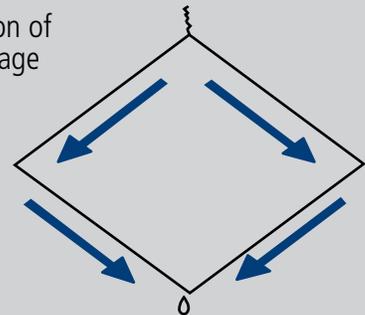


Size of frame and head height of hoists affect quality of drain

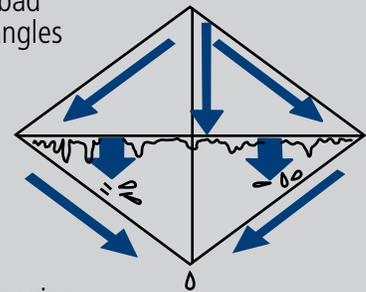


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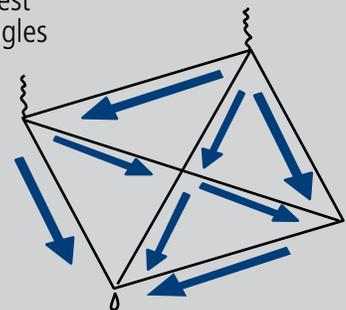
Combination of good drainage angles



Combination of good and bad drainage angles

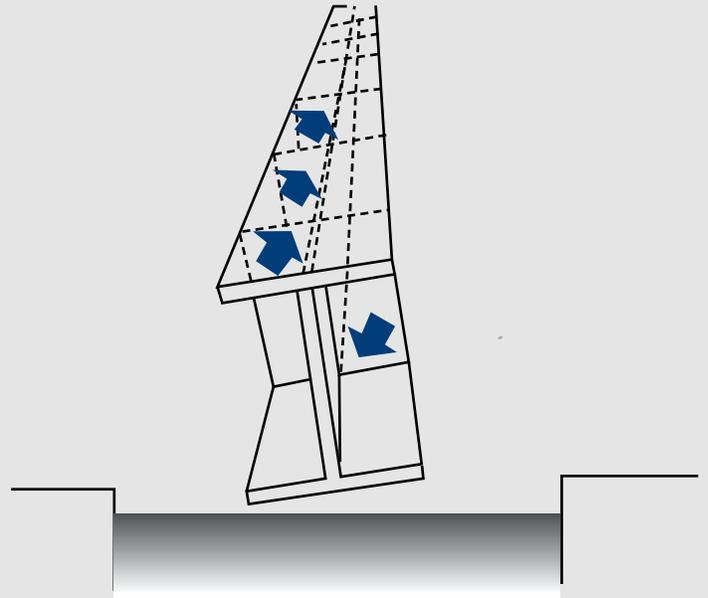


Multiple hanging points for best drainage angles

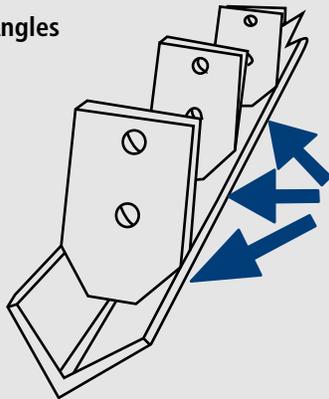


On immersion, the air travels up the underside surfaces causing air pockets at each plate

On withdrawal, zinc travels or flows down the upper surfaces, pooling at each plate

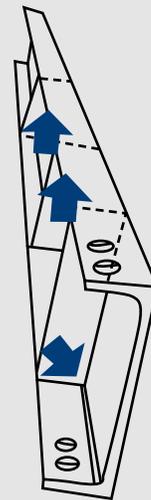


Angles



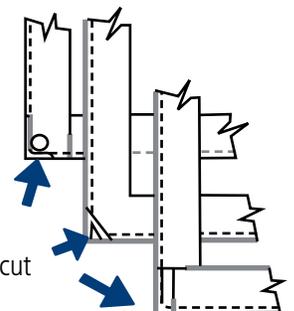
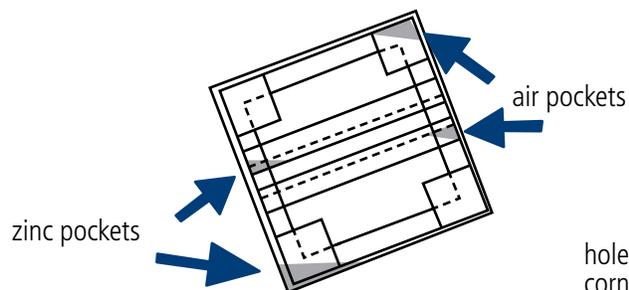
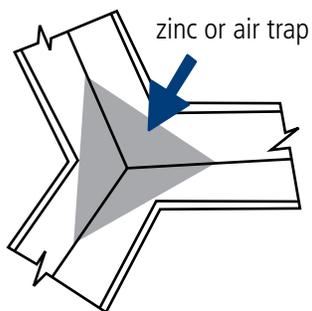
crop plates before welding

There will always be air or zinc traps even on channels.

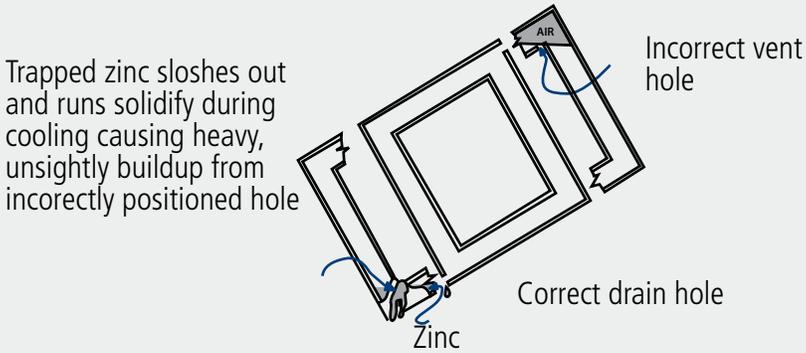
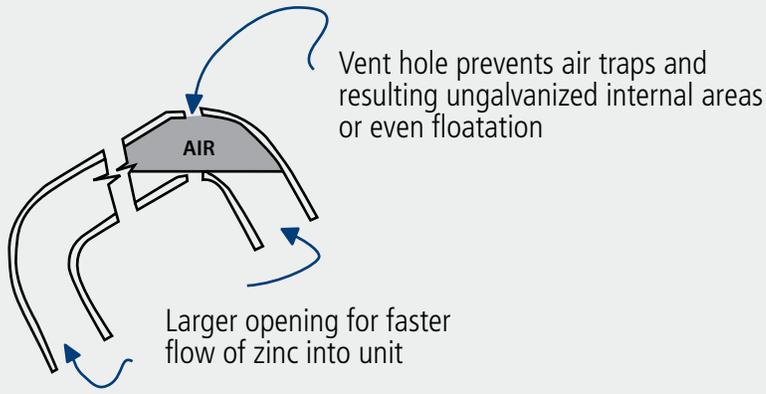


Remember, where zinc pools so will flux

Angle fabrications



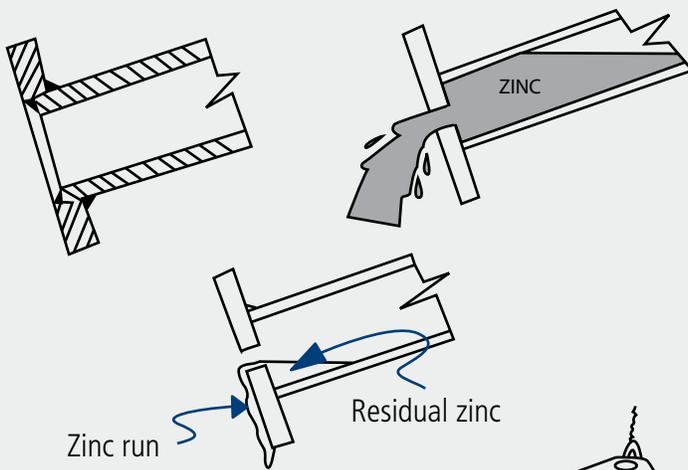
VENT HOLE CORRECT



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Suggested design for flanged hollow sections

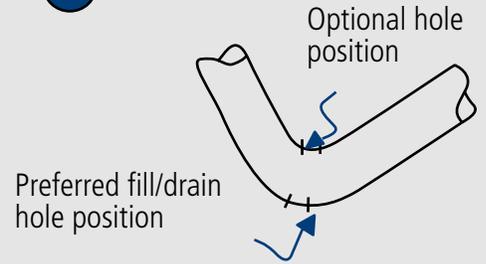
Center hole drainage is not recommended



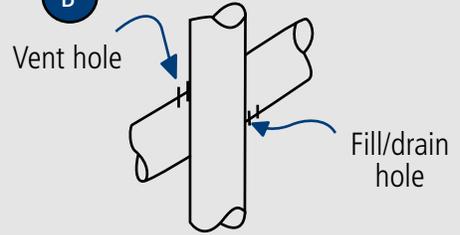
Open end or drain hole at the correct position and size



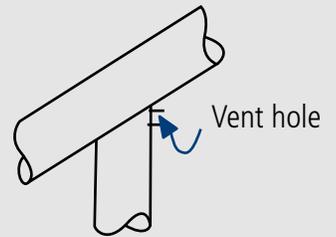
A



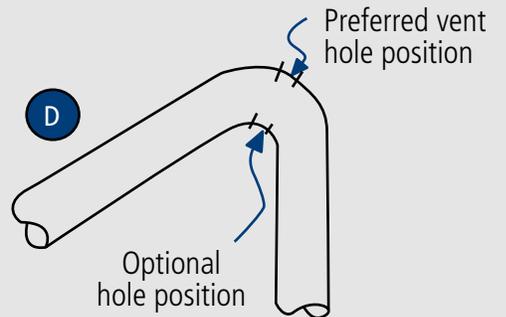
B



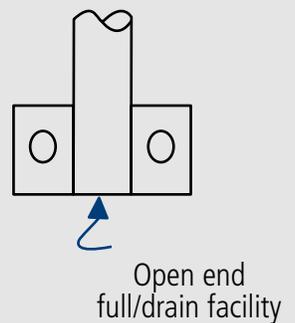
C



D

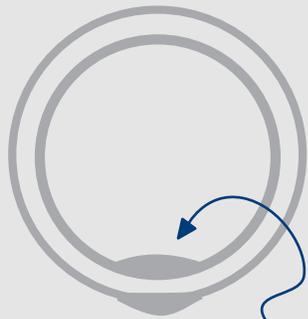
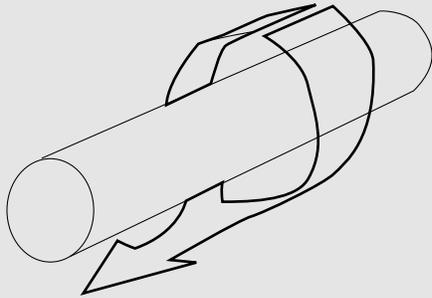
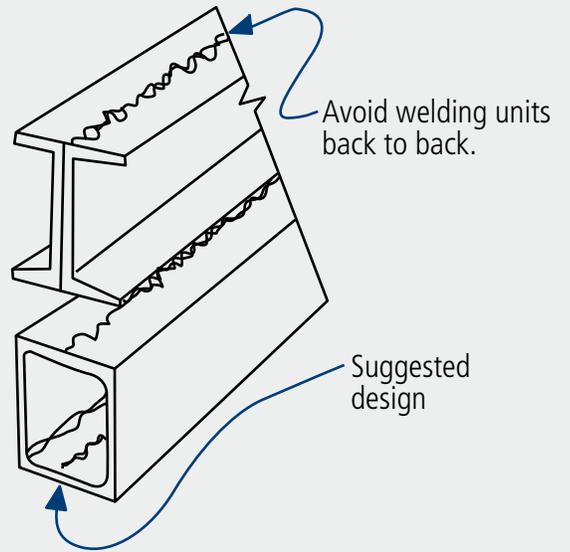
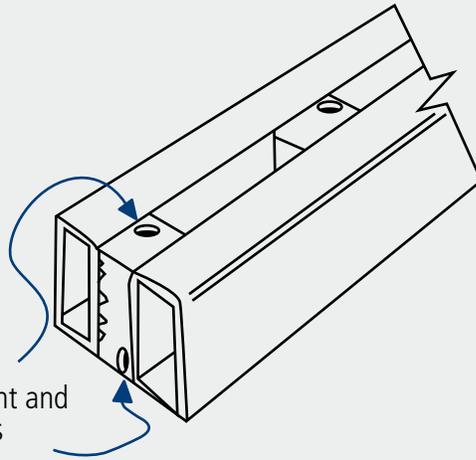


E



Space matching surfaces?

Do not forget to vent and drain hollow sections



Zinc will flow around and down circular units leaving drainage runs along units.

Vent and drain holes too small!



Vent and drain hole size. Vent and drain holes that are too small in hollow sections increase immersion time and may cause unsightly excessive zinc drainage runs as the zinc freezes during the draining period.



Chart 1. – Drainage holes for overlapping surfaces – steel thickness $\leq 1/2''$ (1.25 cm)

Overlapping surface po2 [cm2]	Holes	Unwelded surfaces
< 16 [< 103]	None	None
> 16 et < 64 [> 103 & < 413]	3/8" [1 cm]	1" [2.5 cm]
> 64 et < 400 [> 413 & < 2580]	1/2" [1.25 cm]	2" [5 cm]
each increment of 400 [2580]	3/4" [2 cm]	4" [10 cm]

Chart 2. – Drainage holes for overlapping surfaces – steel thickness $\geq 1/2''$ (1.25 cm)

Overlapping surface po2 [cm2]	Holes	Unwelded surfaces
< 16 [< 103]	None	None
> 16 et < 64 [> 103 & < 413]	None	None
> 64 et < 400 [> 413 & < 2580]	1/2" [1.25 cm]	2" [5 cm]
each increment of 400 [2580]	3/4" [2 cm]	4" [10 cm]

