
**Steel sheet, 55 % aluminium-zinc
alloy-coated by the continuous hot-dip
process, of commercial, drawing and
structural qualities**

*Tôles en acier revêtues en continu par immersion à chaud d'une
couche d'alliage aluminium-zinc 55 % de qualité commerciale, pour
emboutissage ou destinées à la construction*

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 17, *Steel*, Subcommittee SC 12, *Continuous mill flat rolled products*.

This fifth edition cancels and replaces the fourth edition (ISO 9364:2011), which has been technically revised.

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Steel sheet, 55 % aluminium-zinc alloy-coated by the continuous hot-dip process, of commercial, drawing and structural qualities

1 Scope

This document is applicable to the requirements for steel sheet, in coils and cut lengths, metallic-coated by the continuous hot-dip process with 55 % aluminium-zinc alloy coating.

The product is intended for applications requiring the corrosion characteristics of aluminium coupled with those of zinc, or heat resistance, or both.

The steel sheet is produced in a number of quality designations and grades, coating mass, surface treatments and coating finish conditions designed to be compatible with differing application requirements.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1460, *Metallic coatings — Hot dip galvanized coatings on ferrous materials — Gravimetric determination of the mass per unit area* ISO 9364:2017

ISO 2178, *Non-magnetic coatings on magnetic substrates — Measurement of coating thickness — Magnetic method* <https://standards.iteh.ai/catalog/standards/sist/412d600e-d0b3-4faa-82f9-250302ac754/iso-9364-2017>

ISO 3497, *Metallic coatings — Measurement of coating thickness — X-ray spectrometric methods*

ISO 6892-1, *Metallic materials — Tensile testing — Part 1: Method of test at room temperature*

ISO 7438, *Metallic materials — Bend test*

ISO 16163, *Continuously hot-dipped coated steel sheet products — Dimensional and shape tolerances*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <https://www.electropedia.org/>
- ISO Online browsing platform: available at <https://www.iso.org/obp>

3.1

commercial

base-metal quality intended for general fabricating purposes where sheet is used in the flat condition, or for bending or moderate forming

3.2

drawing

base-metal quality intended for parts where drawing or severe forming may be involved

3.3

deep drawing

base-metal quality intended for parts where severe forming or severe *drawing* (3.2) may be involved

3.4

interstitial-free steel

IF steel

extra-low-carbon steel in which all interstitial elements are stabilized with titanium and/or equivalent elements

Note 1 to entry: Interstitial-free steel is sometimes referred to as “stabilized steel”.

3.5

breakage allowance

agreed upon level of acceptable die breakage not subject to claim

3.6

normal spangle

coating formed as a result of unrestricted growth of aluminium-zinc alloy crystals during normal solidification

3.7

smooth finish

smoothness produced by *skin passing* (3.8) the coated material in order to achieve an improved surface condition as compared with the normal as-coated product

3.8

skin pass

light cold rolling of the product

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Note 1 to entry: The purpose of the skin passing is one or more of the following: to minimize the appearance of coil breaks, stretcher strains and fluting; to control the shape; and to obtain the required surface finish.

Note 2 to entry: Some increase in hardness and some loss in ductility will result from skin passing.

3.9

differential coating

coating deliberately produced to have a different *coating mass* (3.11) on each surface

3.10

lot

up to a specified quantity of steel sheet of the same designation rolled to the same thickness and coating condition

3.11

coating mass

total amount of coating on both sides of the sheet

Note 1 to entry: Coating mass is expressed in grams per square metre.

4 Dimensions

4.1 55 % aluminium-zinc alloy-coated steel sheet is produced in thicknesses from 0,25 mm to 5 mm inclusive after coating, and in widths of 600 mm and over in coils and cut lengths. 55 % aluminium-zinc alloy-coated steel sheet less than 600 mm wide, slit from wide sheet, is considered as sheet.

4.2 The thickness of 55 % aluminium-zinc alloy-coated steel sheet may be specified as a combination of the base metal and metallic coating, or as the base metal alone. The purchaser shall indicate on the order which method of specifying thickness is required. In the event that the purchaser does not indicate

any preference, the thickness as a combination of the base metal and coating will be provided. [Annex A](#) describes the requirements for specifying the thickness as base metal alone.

5 Conditions of manufacture

5.1 Steelmaking

Unless otherwise agreed by the interested parties, the processes used in making the steel and in manufacturing 55 % aluminium-zinc alloy-coated steel sheet are left to the discretion of the manufacturer. On request, the purchaser shall be informed of the steelmaking process being used.

5.2 Chemical composition

The chemical composition (heat analysis) shall conform to the requirements given in [Tables 1](#) and [2](#).

5.3 Chemical analysis

5.3.1 Heat analysis

An analysis of each heat shall be made by the manufacturer in order to determine compliance with the requirements given in [Tables 1](#) and [2](#). On request, a report of the heat analysis shall be made available to the purchaser or the purchaser's representative. Each of the elements listed in [Tables 1](#) and [2](#) shall be included in the report of the heat analysis. When the amount of copper, nickel, chromium or molybdenum present is less than 0,02 %, the analysis may be reported as "< 0,02 %".

5.3.2 Product analysis

A product analysis may be made by the purchaser in order to verify the specified analysis of the product and shall take into consideration any normal heterogeneity. The product analysis shall be in accordance with [Tables 2](#) and [3](#).

Table 1 — Chemical composition (heat analysis)

Mass fractions in percent

Base-metal quality		C	Mn	P	S
Designation	Name	max.	max.	max.	max.
01	Commercial	0,10	0,60	0,030	0,035
02 and 03 ^a	Drawing and deep drawing	0,06	0,50	0,020	0,025
220 to 550	Structural	0,25	1,15	0,05 ^b	0,035

^a Interstitial-free steel may be applied (see [5.4.1.3](#)).

^b Grades 250 and 280: phosphorus – 0,10 % max. Grade 350: phosphorus – 0,20 % max.

Table 2 — Limits on additional chemical elements

Mass fractions in percent

Element	Cu ^a max.	Ni ^a max.	Cr ^{a,b} max.	Mo ^{a,b} max.	Nb ^c max.	V ^{c,d} max.	Ti ^c max.
Heat analysis	0,20	0,20	0,15	0,06	0,008	0,008	0,008
Product analysis	0,23	0,23	0,19	0,07	0,018	0,018	0,018

^a The sum of copper, nickel, chromium and molybdenum shall not exceed 0,50 % on heat analysis. When one or more of these elements are specified, the sum does not apply, in which case, only the individual limits on the remaining elements apply.

^b The sum of chromium and molybdenum shall not exceed 0,16 % on heat analysis. When one or more of these elements are specified, the sum does not apply, in which case, only the individual limits on the remaining elements apply.

^c For interstitial-free steels only, the value of 0,15 % maximum for titanium, and 0,10 % maximum for niobium and vanadium are acceptable to ensure that the carbon and nitrogen are fully stabilized.

^d Heat analysis greater than 0,008 % may be supplied after agreement between the manufacturer and the purchaser.

Table 3 — Product analysis tolerances for Table 1

Mass fractions in percent

Element	Maximum of specified element	Tolerance over maximum specified
C	0,15	0,03
	0,25	0,04
Mn	1,15	0,05
P	0,20	0,01
S	0,035	0,01

NOTE The maximum tolerance is the allowable excess over the requirement of heat analysis shown in Table 1.

5.4 Mechanical properties

5.4.1 Commercial and drawing quality

5.4.1.1 Ordering conditions

55 % aluminium-zinc alloy-coated steel sheet of designations 02 and 03 are supplied under either of the following two ordering conditions.

- Ordering condition A: steel sheet mechanical properties shall, at the time the steel is made available for shipment, satisfy the applicable requirements of Table 4, when they are determined on test pieces obtained in accordance with the requirements in Clause 7. The values specified in Table 4 are applicable for the periods indicated in Table 5 from the time that the steel is available for shipment.
- Ordering condition B: steel sheet, ordered to make an identified part, shall be supplied with a commitment for satisfactory manufacturing performance within an established breakage allowance, which shall be previously agreed upon by the interested parties. In the agreement, the part name, the details of fabrication, and special requirements (such as freedom from stretcher strain or fluting) shall be specified.

In the case of ordering condition B, mechanical properties of the steel sheet may also be agreed upon by the interested parties and such properties may not necessarily satisfy the requirements of Table 4.

5.4.1.2 Fabrication qualities

55 % aluminium-zinc alloy-coated steel sheet is available in three fabrication qualities as given in 3.1 to 3.3.

5.4.1.3 Interstitial-free steel

Stabilized interstitial-free (IF) steel is applicable to orders for designations 02 and 03, provided that the purchaser is informed of the substitution and that related shipping documents reflect the actual material shipped.

Table 4 — Mechanical properties of commercial and drawing quality grades

Base-metal quality		R_{eL} max. ^a MPa	R_m max. ^b MPa	A min. ^c %		
Designation	Name			$L_o = 80$ mm	$L_o = 50$ mm	$L_o = 5,65 \sqrt{S_o}$ ^d
01	Commercial	—	—	—	—	—
02	Drawing	300 ^e	430	23	24	22
03	Deep drawing	260	410	25	26	24

R_{eL} = lower yield strength
 R_m = tensile strength
A = percentage elongation after fracture
 L_o = gauge length of original test piece
 S_o = original cross-sectional area of gauge length
1 MPa = 1 N/mm²

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For products produced according to the performance criteria (ordering condition B), the typical mechanical properties presented here are non-mandatory. For products specified according to mechanical properties (ordering condition A), the purchaser may negotiate with the manufacturer if a specific range, or a more restrictive range, is required for the application. When agreed to, such values may be specified.

NOTE With the exception of footnote c, these typical mechanical properties apply to the full range of steel sheet thicknesses. The yield strength tends to increase and some of the formability aspects tend to decrease as the sheet thickness decreases.

a The values apply to 0,2 % proof strength when a definite yield phenomenon is not present, otherwise to the lower yield strength (R_{eL}).

b The minimum tensile strength for qualities, 02 and 03, would normally be expected to be 270 MPa. All tensile strength values are determined to the nearest 10 MPa.

c For material up to and including 0,6 mm in thickness, the elongation values in this table shall be reduced by 2.

d This may be used for material over 3 mm in thickness.

e This value applies to skin-passed products only.

Table 5 — Applicable period for values specified in Table 4

Designation	Period
01	Not applicable
02	8 d
03	30 d

5.4.2 Structural quality

The mechanical properties, at the time the steel is made available for shipment, shall satisfy the requirements of Table 6.