



Designation: **B633**—~~11~~ **B633** – 13

Standard Specification for Electrodeposited Coatings of Zinc on Iron and Steel¹

This standard is issued under the fixed designation B633; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reappraisal. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reappraisal.

This standard has been approved for use by agencies of the Department of Defense.

1. Scope

1.1 This specification covers material and process requirements for electrodeposited zinc coatings applied to iron or steel articles to protect them from corrosion. ~~It does not cover electrodeposited zinc-coated steel wire or sheets (see Specification A591/A591M for sheets).~~

1.2 The coatings are provided in four standard thickness classes (4.1), in the as-plated condition or with one of ~~three~~ five types of supplementary ~~finish~~ finishes (4.2).

1.3 High strength metals, unless otherwise specified, including high strength steels having a tensile strength greater than 1700 MPa (247 ~~ksi~~ Rksi, 46HRC) ~~46~~ shall not be electroplated.

1.4 It does not cover continuous processes for electrodeposited zinc coated steel wire or sheets (see Specification [A591/A591M](#) for sheets.)

1.5 It may be used for fasteners but specific specifications have been developed for manufacturing fasteners in Committee F16 which may be more applicable (see Specifications [F1941](#) and [F1941M](#)).

1.6 The values stated in SI units ~~shall~~ are to be regarded as standard. No other units of measurement are included in this standard.

1.7 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

1.8 *This standard has been revised to address RoHS requirements that seek to limit the exposure of workers and the public from exposure to toxic metals. Additional types V and VI have been added to permit non-chromate passivate treatments to be used in replacement of hexavalent chromium.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[A591/A591M](#) Specification for Steel Sheet, Electrolytic Zinc-Coated, for Light Coating Weight [Mass] Applications (Withdrawn 2005)³

[B117](#) Practice for Operating Salt Spray (Fog) Apparatus

[B183](#) Practice for Preparation of Low-Carbon Steel for Electroplating

[B201](#) Practice for Testing Chromate Coatings on Zinc and Cadmium Surfaces

[B242](#) Guide for Preparation of High-Carbon Steel for Electroplating

[B254](#) Practice for Preparation of and Electroplating on Stainless Steel

[B320](#) Practice for Preparation of Iron Castings for Electroplating

[B322](#) Guide for Cleaning Metals Prior to Electroplating

[B374](#) Terminology Relating to Electroplating

[B487](#) Test Method for Measurement of Metal and Oxide Coating Thickness by Microscopical Examination of Cross Section

¹ This specification is under the jurisdiction of ASTM Committee B08 on Metallic and Inorganic Coatings, and is the direct responsibility of Subcommittee B08.06 on Soft Metals.

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² For referenced ASTM standards, visit the ASTM website, [www.astm.org](#), or contact ASTM Customer Service at [service@astm.org](#). For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

³ The last approved version of this historical standard is referenced on [www.astm.org](#).

[B499 Test Method for Measurement of Coating Thicknesses by the Magnetic Method: Nonmagnetic Coatings on Magnetic Basis Metals](#)

[B504 Test Method for Measurement of Thickness of Metallic Coatings by the Coulometric Method](#)

[B567 Test Method for Measurement of Coating Thickness by the Beta Backscatter Method](#)

[B568 Test Method for Measurement of Coating Thickness by X-Ray Spectrometry](#)

[B571 Practice for Qualitative Adhesion Testing of Metallic Coatings](#)

[B602 Test Method for Attribute Sampling of Metallic and Inorganic Coatings](#)

[B697 Guide for Selection of Sampling Plans for Inspection of Electrodeposited Metallic and Inorganic Coatings](#)

[B762 Test Method of Variables Sampling of Metallic and Inorganic Coatings](#)

[B849 Specification for Pre-Treatments of Iron or Steel for Reducing Risk of Hydrogen Embrittlement](#)

[B850 Guide for Post-Coating Treatments of Steel for Reducing the Risk of Hydrogen Embrittlement](#)

[D2092 Guide for Preparation of Zinc-Coated \(Galvanized\) Steel Surfaces for Painting \(Withdrawn 2008\)³](#)

[F1470 Practice for Fastener Sampling for Specified Mechanical Properties and Performance Inspection](#)

[F1941 Specification for Electrodeposited Coatings on Threaded Fasteners \(Unified Inch Screw Threads \(UN/UNR\)\)](#)

[F1941M Specification for Electrodeposited Coatings on Threaded Fasteners \(Metric\)](#)

2.2 *Military Standard*.⁴

[MIL-STD-1312 Fastener Tests, Methods \(Test 12\)](#)

3. Terminology

3.1 Definitions:

3.1.1 Definitions of the terms used in this specification are in accordance with Terminology [B374](#).

3.1.2 *passivite*—*passivate*—for the purpose of this specification, a conversion coating on zinc shall not contain hexavalent chromium.

4. Classification

4.1 *Thickness*—The coating shall be provided in one of the four thickness classes defined in [Table 1](#).

TABLE 1 Thickness Classes for Coatings

Classification Number and Conversion Coating Suffix	Service Condition	Thickness, min µm
Fe/Zn 25	SC 4 (very severe)	25
Fe/Zn 12	SC 3 (severe)	12
Fe/Zn 8	SC 2 (moderate)	8
Fe/Zn 5	SC 1 (mild)	5

4.2 *Finish*—The coating shall have one of the finish types defined in [Table 2](#).

TABLE 2 Finish Type and Corrosion Resistance Requirements

Type	Description	Minimum Salt Spray h
I	As-plated without supplementary treatments	
II	With colored chromate coatings	96
III	With colorless chromate conversion coatings	12
IV	With phosphate conversion coatings	
V	With colorless passivate	72
VI	With colored passivate	120

5. Ordering Information

5.1 When ordering the electroplating of articles, the purchaser shall state ASTM B633, the date of issue, service condition number, and the Type (see [4.1](#), [4.2](#), and [7.1](#)).

5.2 If necessary, the purchaser shall include on his part drawings or purchase order the following:

5.2.1 Basis metal alloy designation and ultimate tensile strength of the steel,

⁴ Available from Standardization Documents Order Desk, DODSSP, Bldg. 4, Section D, 700 Robbins Ave., Philadelphia, PA 19111-5098, <http://www.dodssp.daps.mil>.
<http://dodssp.daps.dla.mil>.

- 5.2.2 Thickness, if other than specified (4.1, 7.1),
- 5.2.3 Location of significant surface (7.1.1, 7.1.2),
- 5.2.4 Luster (7.3),
- 5.2.5 Exceptions to stress relief heat treatment prior to plating, ((6.4),
- 5.2.6 Exception to Hydrogen Embrittlement Relief after plating, (6.5).
- 5.2.7 Corrosion resistance test, if specified (9.3, 10.3),
- 5.2.8 Hydrogen embrittlement test, if required (9.4, 10.4), including the tensile strength of the items,
- 5.2.9 Sample size for inspection, if other than specified, and
- 5.2.10 Supplementary requirements, if applicable (see Supplementary Requirement).

6. Materials and Manufacture

6.1 The coatings shall be non-alloyed zinc produced by electrodeposition.

6.2 Defects in the surface of the basis metal, such as scratches, porosity, pits, inclusions, cracks, roll marks, and die marks, may adversely affect the appearance and performance of coatings applied thereto despite the observance of the best electroplating practices. Accordingly, the electroplater's responsibility for defects in the coating resulting from such conditions shall be waived, except when he is the prime contractor supplying electroplated parts. In this event, the basis metal shall be subjected to such polishing or buffing operations as are necessary to yield deposits with the desired final luster and appearance. To minimize problems of this sort, the specifications covering the basis material on the item to be electroplated shall contain appropriate limitations to such basis metal conditions.

6.3 *Cleaning of Basis Metal*—Proper preparatory procedures and thorough cleaning of the basis metal are essential to ensure satisfactory adhesion and corrosion resistance performance of the coating. It is recommended that the following appropriate recommended practices and guides be used: B183, B242, B254, B320, and B322.

6.4 *Pretreatment of Iron or Steel for the Purpose of Reducing the Risk of Hydrogen Embrittlement*—All steel parts having an ultimate tensile strength greater than 1000 MPa (31 HRC) and that have been machined, ground, cold formed, or cold straightened, shall be heat treated for stress relief to reduce the risk of hydrogen embrittlement in the part before clean and electroplate processes. If these heat treatments are not required, the purchaser shall specify in the ordering information their exception, (5.2.5). If the purchaser does not specify an exception to heat treatment, then the plater shall use Table 1 in B849 to determine the appropriate heat treatment for the steel based on its tensile strength.

6.5 *Post Coating Treatments of Iron and Steel for the Purpose of Reducing the Risk of Hydrogen Embrittlement*—All electroplated steel parts having a tensile strength greater than 1000 MPa (31 HRC) as well as surface hardened parts, shall be baked to reduce the risk of hydrogen embrittlement. If these heat treatments are not required, the purchaser shall specify in the ordering information their exception (5.2.5). If the purchaser does not specify an exception to heat treatment, then the plater shall use Table 1 in B850 to determine the appropriate heat treatment for the steel based on its tensile strength. The baking treatment shall be done before the application of the supplementary treatments and within 4 h of removal from the last process. Electroplated springs and other parts subject to flexure shall not be flexed before the hydrogen embrittlement relief treatment. Baked parts shall not crack or fail by fracture when tested in accordance with 10.4.

6.6 *Reactivation Treatment*—Electroplated surfaces passivated as a result of the baking operation shall be reactivated before receiving a supplementary treatment.

NOTE 1—Surfaces should be activated as soon as possible following baking and handled carefully to avoid contamination and maintain an active surface for post processing. Proprietary methods are available to prepare the surface or a 2% v/v sulfuric acid in deionized water or a 7-10 g/L solution of sulfamic acid in deionized water can be used.

6.7 *Supplementary Treatments*—The supplementary film treatment for Types II, III, V, and VI shall be in accordance with Practice B201 (see Notes 2 and 3). The treatment required for conversion to Type IV shall be in accordance with Guide D2092.

NOTE 2—The zinc surface is attacked by supplementary treatments, thereby diminishing the amount of metallic zinc present. With Classes Fe/Zn25 and Fe/Zn13, Fe/Zn12, this reduction is insignificant; but it is significant with Fe/Zn8 and Fe/Zn5. Therefore, it is recommended that supplementary treatments not be applied to zinc coatings having a nominal thickness less than 5 μ m.

NOTE 3—Although Types V and VI are technically not “chromate” films and they do not contain leachable hexavalent chromium ions, they are supplemental coatings that render the active zinc surface passive and provide added protection to the steel part.

7. Coating Requirements

7.1 *Thickness*—The thickness shall be specified in accordance with 4.1 and 5.1: (see Note 2).

7.1.1 *Significant Surfaces*—Significant surfaces are areas where minimum thicknesses to be met shall be designated on the applicable drawing or by the provision of a suitably marked sample. Significant surfaces may be defined as those normally visible, directly or by reflection, which are essential to the appearance or serviceability of the article when assembled in normal position or which are the source of corrosion products that deface visible surfaces on the assembled article.

7.1.2 Surfaces on which the specified thickness of deposit cannot readily be controlled, such as threads, holes, deep recesses, bases of angles, and similar areas, are normally exempt from minimum thickness requirements, unless they are specially designated