
Cinkove prevleke - Smernice in priporočila za zaščito železnih in jeklenih konstrukcij proti koroziji - 2. del: Zahteve in priporočila za izdelke, namenjene vročemu pocinkanju (ISO/DIS 14713-2:2026)

Zinc coatings - Guidelines and recommendations for the protection against corrosion of iron and steel in structures - Part 2: Requirements and recommendations for articles to be hot dip galvanized (ISO/DIS 14713-2:2026)

Zinküberzüge - Leitfäden und Empfehlungen zum Schutz von Eisen- und Stahlkonstruktionen vor Korrosion - Teil 2: Feuerverzinken (ISO/DIS 14713-2:2026)

Revêtements de zinc - Lignes directrices et recommandations pour la protection contre la corrosion du fer et de l'acier dans les constructions - Partie 2: Galvanisation à chaud (ISO/DIS 14713-2:2026)

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91.080.13	Jeklene konstrukcije	Steel structures

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ISO/DIS 14713-2

Zinc coatings — Guidelines and recommendations for the protection against corrosion of iron and steel in structures —

Part 2: Requirements and recommendations for articles to be hot dip galvanized

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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).

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For an explanation of 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 www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 107, *Metallic and other inorganic coatings*, Subcommittee SC 4, *Hot dip coatings (galvanized, etc.)*.

This third edition, which has been technically revised, cancels and replaces the second edition (ISO 14713-2:2019). The main changes compared with the previous edition are as follows:

- Title has been amended to clarify the purpose of document
- [Clause 3](#) has been aligned to ISO 1461 with definitions of 'galvanizer' and 'wet storage stain' now included
- [Clause 4](#) has been extensively edited to make requirements on designers/manufacturers clearer and avoid repetition of information
- [Clause 6](#) has been extensively revised
- Information on castings has been consolidated into [6.3](#)
- A new diagram ([Figure 1](#)) and explanation of the k-area of beams has been added in [6.5](#)
- Significant revisions made to Clause 6.6 (now [6.5](#))
- Small technical correction has been made to [Table A.2](#)
- Sub-clauses have been added to [Annex A](#) to better organise the information provided
- New [Annex B](#) added to provide a simplified checklist of actions for designers/manufacturers.
- Editorial changes to simplify language and apply a consistent use of terms.

A list of all parts in the ISO 14713 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

ISO/DIS 14713-2:2026(en)**Introduction**

Hot dip galvanized coatings are applied to fabricated iron or steel articles through immersion in a bath of molten zinc to apply a highly durable and abrasion resistant protective coating that is metallurgically bonded to the substrate (see ISO 1461 [\[1\]](#)).

Application of a galvanized coating after fabrication or manufacture of the steel article ensures that the galvanized coating provides complete coverage for the article. It is therefore necessary to optimize design and fabrication of steel articles to ensure their suitability for the batch hot dip galvanizing process. This includes aspects such as design detailing to allow access or drainage of molten zinc and venting of air; choice of steel grades and methods of fabrication.

This document provides requirements and recommendations for the design, fabrication and manufacture of iron or steel articles to be hot dip galvanized.

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Zinc coatings — Guidelines and recommendations for the protection against corrosion of iron and steel in structures —

Part 2: Requirements and recommendations for articles to be hot dip galvanized

1 Scope

This document gives requirements and recommendations for the general principles of design of articles to be hot dip galvanized after fabrication (e.g. in accordance with ISO 1461 [1]) for the corrosion protection of, for example, articles that have been manufactured in accordance with EN 1090-2 [2]

This document does not apply to hot dip galvanized coatings applied to continuous wire or sheet (e.g. to EN 10346 [3]).

2 Normative references

There are no normative references in this document.

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 8044 and the following apply.

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

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

3.1 hot dip galvanizing

formation of a galvanized coating of either zinc or zinc iron alloys, or both, on fabricated iron or steel articles by dipping in a zinc melt

3.2 hot dip galvanized coating galvanized coating

coating obtained by *hot dip galvanizing* (3.1)

3.3 duplex system

hot dip galvanized coating (3.2) with an additional liquid paint or powder coating

3.4 galvanizer

company or organization that operates a plant for the *hot dip galvanizing* (3.1) of batches of fabricated iron or steel articles