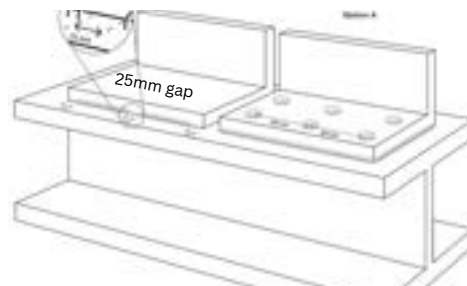
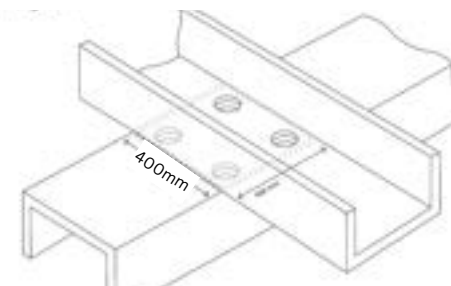
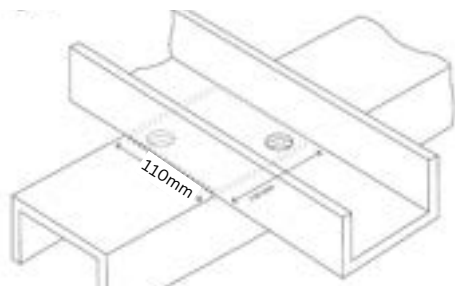


OVERLAPPING SURFACES

Overlapping surfaces are potentially dangerous as air trapped between surfaces may be converted to superheated steam in the galvanizing bath and can lead to an explosion. For overlapping surfaces which are larger than 100mm x 100mm and sealed by continuous welding, holes should be drilled as indicated below.



The number and sizes of holes required to vent an overlapping are takes account of the area of overlap and guidance is provided in the table below Ideally holes should be through both sections. An alternative is to use intermittent welds. In should be noted that overlapping surfaces like this can result in pretreatment solutions becoming trapped between the surfaces resulting in potential seepage staining.

Area of Overlap 'a'	Recommended Action
$a \leq 100 \text{ cm}^2$	Circumferential tight weld. The material should be dry for the welding process and overlapping parts should be smooth and assembled without gaps.
$100 < a \leq 1000 \text{ cm}^2$	In diagonally opposite corners, either: 2 x $\geq 12 \text{ mm}$ holes at corners or 2 x $\geq 25 \text{ mm}$ intermittence of weld at corners
$1000 < a \leq 2500 \text{ cm}^2$	Either: 4 x $\geq 12 \text{ mm}$ holes at corners or 4 x $\geq 25 \text{ mm}$ intermittence of weld at corners
$a > 2500 \text{ cm}^2$	In diagonally opposite positions, either: $\geq 12 \text{ mm}$ holes at corners and circumferentially at least every 300 mm from the corners or $\geq 25 \text{ mm}$ intermittence of weld at corners and circumferentially at least every 300 mm from the corners.
Note 1	An overlapping area of 100 cm^2 means $10 \text{ cm} \times 10 \text{ cm}$ or $20 \text{ cm} \times 5 \text{ cm}$ etc.
Note 2	Area of overlap 'a' represents areas shown in figures 7a, 7b and 8.

Please note, diagrams are not to scale.

Note: If there are any doubts or questions, please contact your galvanizer.

Should you wish any further information please do not hesitate to contact one of our experts on
 Elgin – 01343 548855 or
 Cumbernauld – 01236 731444
 or alternatively email any enquiries direct to our technical team at
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