

Hot galvanized and galvanized sheet metal is used to a greater extent for components of the body, which are especially subject to corrosion.

Conformance with the following points is necessary when working with these parts.

- The welding smoke contains poisonous zinc oxide, so that especially good extraction is necessary in the welding bay.
- Do not grind off zinc coat for resistance spot welding and inert gas welding. The zinc coat must be ground off for brazing jobs.
- If at all possible, welded connections should be made with resistance spot welding. Increase welding current by at least 10 % over value for non-galvanized plates. Apply highest possible electrode contact force (make break out test on sample sheet metal). A coat of spot welding paste can be applied for better sealing.
- Inert gas welding should be preferred to autogen welding in areas not accessible for resistance spot welding, because of the lower heat dispersion.
- Machining or forming of galvanized sheet metal in warm state is normal. Make sure that extraction of poisonous vapours is carried out thoroughly.
- Remove burnt residual zinc completely. Align, grind down and tin out visible joints as normal.
- Coat ground-off zinc coat with zinc dust paint.