



NLMK PA GALVANIZING CAPABILITIES
GALVANIZED (Line 1, 2, 3) & GALVANNEALED (Line 3 only)

	LINE 3	LINE 2
Gauge Range	0.018 to 0.135	.012 to .065 @ 60", to .071 @ 52" * (0.010 Substrate)
Width Range	24 to 72 <small>Footnote 1</small>	24 to 60 <small>Footnote 1</small>
Incoming Coil Size	72,000 max	50,000 max
Incoming Inner Diameter	20 to 24	20, 24
Incoming Outer Diameter	80 max	74 max
Exit Coil Size	10,000 to 72,000	50,000 max
Exit Inner Diameter	20 to 24	20 to 24
Exit Outer Diameter	30 to 80	74 max
Coating Weight	G30 to G235 (Galvanize - GI)	G30 to G140
	A25 to A60 (Galvanneal - GA)	
Coated Product Types	Galvanize Minimum Spangle	Galvanize Minimum Spangle
	Galvanize Regular Spangle	
	Galvanize Extra-Smooth	Galvanize Extra-Smooth
	Galvanneal	
	Culvert	
Surface Treatments	Chrome Passivation Chemical Treatment	Chrome Passivation Chemical Treatment
	RoHS Tri-Valent Cr Chemical Treatment	RoHS Tri-Valent Cr Chemical Treatment
	Non-Chrome Chemical Treatment	Non-Chrome Chemical Treatment
	Electrostatic Oiling	Oiled - Roller Applicator
	High Chrome Paint Pretreatment	
Base Property	CS/B - Commercial Steel Type B	CS/B
Product Types	FS/B - Forming Steel Type B (PREFERRED on L3)	FS/B
	SS - Structural Steel Grades 33, 37, 40, 50, 55, 57, 80	SS - Structural Steel Grades 33, 37, 40, 50, 55, 57, 80
	*DDS - Deep Drawing Steel	*DDS
	EDDS - Extra Deep Drawing Steel	EDDS
	HSLA - High Strength Low Alloy	HSLA
	*DDS - produced either as a fully finished '1005A' substrate or is overgraded to a 1001 IF full hard (default) substrate.	
Inspection	Parsytec Automatic Surface Inspection System	Manual Only

UL Certification (All lines)	Coating Weight	Gauge Range covered (nominal)
	G90 - designated as 'G90U'	.018 - .131
	G60 - designated as 'G60U'	.018 - .135
	G40 - designated as 'G40U'	.018 - .135
	G30 - designated as 'G30U'	.018 - .130
	A60 - designated as 'A60U'	.018 - .135
	A40 - designated as 'A40U'	.018 - .135

Oil Coating Weights for RP oil when desired:
 light = 50 mg/sqft (applied to one side)
 medium = 75 mg/sqft (applied to one side)
 heavy = 120 mg/sqft (applied to one side)

Automotive (Metric) / ASTM A653
(Imperial Unit & Metric Unit)
Conversion Chart &
Coated Products Production Value

Conversion Calculation: 1oz/sqft = 305.15 g/sqmeter

Auto. Metric Designation	Galvanized		Production CTW Value*
	ASTM A653 Equivalent Metric	Imperial	
30G/30G		G20	→ G30
35G/35G		G23	→ G30
40G/40G		G26	→ G30
45G/45G	Z90	G30	→ G30
50G/50G		G33	→ G35
55G/55G		G36	→ G40
60G/60G	Z120	G39	→ G40
70G/70G		G46	→ G60
90G/90G	Z180	G60	→ G60
98G/98G		G64	→ G70
100G/100G		G66	→ G70
110G/110G		G72	→ G75
120G/120G		G79	→ G90
	Z275	G90	→ G90
	Z305	G100	→ G100
	Z350	G115	→ G115
	Z450	G140	→ G140
	Z500	G165	→ G165
	Z550	G185	→ G185
	Z600	G210	→ G210
	Z700	G235	→ G235

Auto. Metric Designation	Galvannealed		Production CTW Value*
	ASTM A653 Equivalent Metric	Imperial	
20A/20A		A13	→ A30
30A/30A		A20	→ A30
35A/35A		A23	→ A30
	ZF75	A25	→ A30
40A/40A		A26	→ A30
45A/45A		A29	→ A30
50A/50A		A33	→ A40
55A/55A		A36	→ A40
60A/60A	ZF120	A39	→ A40
	ZF180	A60	→ A60

Notes:
 Some Imperial values are calculated to determine the production value to be used.
 NLMK-PA Galvanizing currently assumes MIN coating weights.
 Some Automotive limits include a MAX coating weight limitation, these must be inquired.
 *Production Values are determined by considering actual Galv line capabilities.