

# Hot-Dip Galvanized Steel vs. Paint



Newly galvanized



30 years later

Hot-Dip Galvanized Steel	VS.	Paint
No	<b>Special Handling</b>	Paper interleve, cloth slings, wood separators
No	<b>Field Touch-up</b>	Required
Factory	<b>Application</b>	Field or Factory
No	<b>Weather Dependent</b>	Yes
-75°F to 392°F	<b>Temperature Range</b>	< 200°F
Cathodic & Barrier	<b>Corrosion Protection</b>	Barrier
> 3.9 mils (1/4" thick steel)	<b>Coating Thickness</b>	Variable
3600 psi	<b>Bond Strength</b>	300-600 psi
179 to 250 DPN	<b>Hardness/Abrasion Resistance</b>	Varies by Type
75 Years	<b>Service Life - Atmospheric</b>	12-15 Years



Newly painted



4 years later<sup>1</sup>

## Initial and Maintenance Cost Analysis<sup>2</sup>

COATING SYSTEM	YEARS							TOTAL NPV <sup>3</sup> \$/ft <sup>2</sup>
	0	5	10	15	20	25	30	
Galvanized Steel	\$1.67							\$1.67
IOZ Primer/ HB Epoxy	\$1.99			\$0.31 Touch-up	\$0.41 Maint. Repair			\$2.71
IOZ Primer/ Waterborne Acrylic	\$1.89			\$0.33 Touch-up	\$0.46 Maint. Repair			\$3.24
IOZ Primer/ HB Epoxy/ Acrylic Urethane	\$2.62				\$0.34 Touch-up	\$0.43 Maint. Repair		\$3.39
Latex/Latex/Latex	\$1.95		\$0.47 Touch-up	\$0.74 Maint. Repair	\$1.07 Full Repair	\$0.19 Touch-up	\$0.20 Maint. Repair	\$4.71

<sup>1</sup>Representative of expected results.

<sup>2</sup>This table represents a practical maintenance cycle in a moderate industrial environment. It also represents a 250-ton project of typical size/shape, and a 30-year planned service life. The paint costs are based on a conventional spray, SP6 surface preparation in an eastern U.S. exposure. Source: NACE 98 Paper #509, Costing Considerations For Maintenance and New Construction Coating Work.

<sup>3</sup>Net Present Value

# Performance Notes

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## Special Handling

- The zinc-iron alloy layers of the hot-dip galvanized (HDG) steel coating are harder than steel and are unaffected by rough handling typical during shipment and erection. Banding of HDG steel pieces in contact with each other is common and acceptable.
- There are significant material and labor costs associated with packaging painted structural steel or steel assemblies for shipping, including wood dunnage and soft material (paper, cardboard) interleave to prevent contact between individual pieces.

## Field Touch-up

- Rarely needed for HDG steel unless for cosmetic reasons to hide a chain mark or to provide corrosion protection to a field-modified area.
- There is usually a time-consuming inspection and field touch-up necessary to repair damaged areas of painted bare steel.

## Application

- Galvanizing is always factory-controlled, with a precise, scientific methodology that ensures complete coverage and corrosion protection.
- Whether the application of paint is done in the factory or field, the internal tubular sections and hard-to-reach areas of bare steel remain unprotected; these areas are where corrosion usually begins.

## Weather Dependent

- Hot-dip galvanizing can be done any day of the year, the process totally independent of weather conditions.
- Painted systems often experience project delays because of unpredictable weather. When the parameters of safe and quality painting (temperature, humidity, wind) are stretched or compromised, coating failure is almost assured.

## Temperature Range

- HDG steel provides superior corrosion protection when in service in a range of temperatures, from -75 F to 392 F.
- Most paints perform poorly in temperatures greater than 200 F.

## Corrosion Protection

- Hot-dip galvanizing provides both cathodic and barrier protection to steel, delivering a rust- and maintenance-free system in most environments for 75 years or more.
- Paint is a barrier protector only, and when scratches and cracks occur, corrosion of the underlying steel is immediate.

## Coating Thickness

- The metallurgical reaction between 840 F molten zinc and iron in steel ensure a uniform and guaranteed coating thickness, documented in ASTM specifications.
- Paint coating thickness on all surfaces is as variable and uniform as the applicator, with corners and edges highly susceptible to corrosion because of thin films.

## Bond Strength

- The alloying of zinc and iron in the HDG coating means the zinc and steel metallurgically become one, yielding a coating bond ten times greater than the strictly mechanical bond of paint to steel.

## Hardness/Abrasion Resistance

- With a coating hardness greater than that of steel alone, galvanized steel provides a durable, scratch-resistant coating that maintains the integrity of overall corrosion protection system.
- Paints are generally not resistant to scratching, cracking, or impact, resulting in a compromised coating where corrosion begins and maintenance painting is required.

## Service Life

- Hot-dip galvanized steel commonly provides maintenance-free corrosion protection for 75 years or more in atmospheric use, especially as our environment and air have become cleaner as a result of regulation.
- Sun, heat, wind, and weathering are constants that result in paint typically requiring touch-up and replacement in 12 – 15 years, costing far more than galvanizing over the intended life of the project.