GALVANIZING DESIGN DETAILS

EDMONTON TANK SIZE LIMITATIONS
Lifting capacity = 10 tonnes
SINGLE DIP MAX.
(Double dipping - subject to a premium)

MINIMUM VENT & DRAIN HOLE SIZES:
TUBULAR SECTIONS
Drain hole sizes to be the greater of the following two options:
1. Meet or exceed the following tubular size chart:

<table>
<thead>
<tr>
<th>NOMINAL</th>
<th>O.D.</th>
<th>HOLE SIZE (PER END)</th>
</tr>
</thead>
<tbody>
<tr>
<td>≤ 2&quot;</td>
<td>60</td>
<td>2@10 1⁄4</td>
</tr>
<tr>
<td>2 ½&quot;</td>
<td>73</td>
<td>2@13 1⁄2</td>
</tr>
<tr>
<td>3&quot; - 3 ½&quot;</td>
<td>89 - 102</td>
<td>2@16 1⁄4</td>
</tr>
<tr>
<td>4&quot; - 5&quot;</td>
<td>114 - 141</td>
<td>2@19 1⁄4</td>
</tr>
<tr>
<td>6&quot;</td>
<td>168</td>
<td>2@22 1⁄4</td>
</tr>
<tr>
<td>7&quot;</td>
<td>190</td>
<td>2@25 1</td>
</tr>
<tr>
<td>8&quot;</td>
<td>219</td>
<td>2@29 1 1⁄4</td>
</tr>
<tr>
<td>10&quot;</td>
<td>273</td>
<td>2@32 1 1⁄2</td>
</tr>
<tr>
<td>12&quot;</td>
<td>324</td>
<td>2@36 1</td>
</tr>
<tr>
<td>14&quot;</td>
<td>356</td>
<td>2@40 1</td>
</tr>
<tr>
<td>16&quot;</td>
<td>406</td>
<td>2@44 1 1⁄2</td>
</tr>
</tbody>
</table>

2. Hole size to be 1.5 times the plate or wall thickness.

NOTES
- Single drain diameter 25% of section size
- Holes within 6mm (¼”) from corner or weld

WARPAGE
- Consult us on assemblies of thick and thin sections or double dips
- Double dip sections are significantly more prone to warpage

PERMANENT MARKING
13mm (½”) stamps, 1.5mm (1⁄16”) deep.
Grind area before stamping. Tags must be steel. DAAM can provide customized tags at extra cost. Wire used for tags must be a minimum of 1.3mm in diameter.

BOLT HOLES
If strength allows, use 3mm (¼”) rather than 2mm (⅛”) oversize (CISC 23.3.2).

RADIAL CLEARANCE
Minimum 3mm (⅛”) on all hinges, moving parts and sleeves; disassembly by others prior to galvanizing.

THREADED PARTS
NC and NPT only. Nuts, bolts, or studs should be sent disassembled. Nut retreading done at extra cost. NPT, nuts and male threads attached to steel, or too large to centrifuge, must be manually retreaded at a significant extra cost. Chamfer male thread ends.

SASKATOON TANK SIZE LIMITATIONS
Lifting capacity = 6 tonnes
SINGLE DIP MAX.
(Double dipping - subject to a premium)

OVERLAPPING SURFACES
Overlapping surfaces that are seal welded can be a maximum of 64in² (400cm²) or venting is required.

COLD BENDING
Use proper bending radii (usually > 4x section thickness).

HANGING HOLES / LIFTING LUGS
Installed if required, at extra cost. Check with us for location and size required.

TANKS & PIPE SPOOLS
Consult us on fabrication design.

DELIVERY
Deliver all materials disassembled on an open truck.

WET STORAGE STAIN
Freshly galvanized surfaces must be stacked to drain off water and ventilate.

DOUBLE DIP
DAAM Galvanizing is not responsible for warpage, distortion and/or related stresses created by the differential heating and cooling during the double dip process. Please utilize alternative design in order to single dip. Any damage resulting from the double dipping process is not the responsibility of the galvanizer.
**PIPE COLUMNS**
- Abrasive blast shellac before welding

**SIMPLE BEAMS** *(small end plates only)*
Holes optional. If holes can be provided in the locations indicated, a cleaner, blemish free coating will be obtained.

**C OR WF**

**CROP**
- Clip internal stiffeners 4 sides and “manhole” (open to 25% area)
- Holes in base plate or notch pipewall. Min. 1 ½ x base plate thickness
- Crop gussets

**H.S.S. COLUMNS**
- Notch or drill web
- Crop all corners
- Crop all plates

**COMPLEX BEAMS & ASSEMBLIES** *(WF, Channel, Angle, H.S.S. Stubs)*
NOTCHES OR HOLES REQUIRED

**VENT & DRAIN HOLES**
**STRUCTURAL SECTIONS**
**CROP**
- Min. 25mm x 25mm (1" x 1")

**HOLES**
- Always ≥ material thickness: min. 10mm (¾") within 6mm (¼") from corner or weld

**H.S.S.**
- Holes in same plane as frame
- Total hole area 10% x-section area each end
- Minimum square opening size 20mm x 20mm/¾” x ¾” (see minimum drain hole size table.)

**END PLATES**
1. The most desirable fabrication is completely open, with the same diameter as the section top and bottom.
2. These are equal substitutes if the full opening is not allowed.
3. This must be used when no holes are allowed in the cap or base plate—two half circles 180˚ apart and at opposite ends of the pole.

**PIPE HANDRAIL & H.S.S. FABRICATIONS**
- Remove shellac and paint on pipe and fittings prior to fabrication
- Abrasive blasting can be done at DAAM Galvanizing for extra cost
- Hole size per vent and hole table
- All holes in plane of handrail
- Aluminum plugs can be purchased at DAAM Galvanizing

**CROP**
- 2 holes within 6mm of solid end plugs
- 1 hole at bottom of each bend
- 2 holes within 6mm of each closed end
- Not required if base plate opened
- 1 hole on each continuous outside corner

**daamgalvanizing.com**

**EDMONTON PLANT**
9390 48 Street NW
Edmonton, AB T6B 2R3

**SASKATOON PLANT**
874 57 Street East
Saskatoon, SK S7K 5Z1

**CALGARY DEPOT**
10630 Enterprise Way SE
Calgary, AB T3S 0A2