

Example Agenda for Pre-Galvanizing Meeting Related to AESS Projects

I. AESS Category Characteristics & Cost Matrix

- a. Review modified AESS matrix for HDG and AGA publication [*Hot-Dip Galvanized Architecturally Exposed Structural Steel: Specifiers Guide*](#)
- b. Supply of project drawings containing information on weight and surface area
- c. What modified AESS category applies to which pieces/assemblies
- d. Define custom characteristics for HDG for each AESS category
- e. Identify critical or significant surfaces
- f. Review AISC/CISC cost matrix for AESS
- g. Rank category characteristics in order of importance regarding cost
- h. Identify any critical parts or surfaces where budget should be focused

II. Identification & Marking of Parts

- a. Identify acceptable types of markings
- b. How to mark AESS category and characteristics required for each part
- c. How to mark critical or significant surfaces

III. Steel Chemistry

- a. Identify all steel grades used and for what parts
- b. Supply of Material Test Reports (MTRs) for all heats of steel
- c. Identify assemblies where mixed appearance may occur
- d. Identify steels where excessive coating thickness and/or brittle coatings may occur

IV. Design & Fabrication

- a. Evaluate susceptibility for warpage/distortion (ASTM A384)
- b. Evaluate susceptibility for embrittlement (ASTM A143)
- c. Confirm the use of design and fabrication best practices (ASTM A385 and AGA Publication [*Design of Products to be HDG After Fabrication*](#))
- d. Identify vent/drain holes where size or location can be optimized for aesthetics
- e. Acceptable appearance of vent/drain holes before HDG (drilled and/or smoothed)
- f. Evaluate susceptibility for weeping welds or rust bleeding; identify mitigation strategy
- g. Identify all welding rod types used and for what assemblies
- h. Supply of Material Test Reports (MTRs) for all welding wire/rods used
- i. Use of anti-spatter sprays and acceptable materials
- j. Acceptable appearance of welds before galvanizing
- k. Use of masking materials

- l. Evaluate oversized parts and acceptability of progressive dipping
- m. Define a procedure for communicating and resolving inadequate design details or insufficient preparation of welds, vent/drain holes, etc. after delivery to the galvanizer

V. HDG Processing

- a. Define a procedure to communicate and remedy cosmetic damages due to transportation or handling before HDG
- b. Evaluate available lift points for HDG and any potential impact on aesthetics
- c. Use of post-treatments

VI. Finishing & Surface Smoothing

- a. Acceptable appearance after smoothing for handling marks, roughness, runs, spikes, dross inclusions, galvanizing skimmings, or other surface conditions
- b. Acceptable appearance of HSS seams
- c. Acceptable appearance of mill markings
- d. Plugging of holes, plug material, and acceptable appearance of plugged holes
- e. Acceptable appearance of welds; agree on a procedure for smoothing raised welds
- f. Acceptable appearance of welds, seams, mill markings, or other raised areas where grinding prior to HDG was not performed; agree on a procedure should this issue arise
- g. Acceptable appearance of thermally cut edges on thick steels; agree on a procedure should this issue arise
- h. Acceptable appearance of progressive dip line

VII. Duplex Systems

- a. Define acceptance criteria and assign responsibilities for surface smoothing. See ASTM A123 6.2, A123 6.4, and D6386 5.2 (for painting) or D7803 5.1.1 (for powder coating)
- b. If using zinc-rich paint for touch-up and repair at the galvanizing plant, evaluate re-coat window of the paint and mutually agree whether repair material should be applied by the galvanizer or painter
- c. Define use of compatible filler materials to fill small indentations in the galvanizing

VIII. Handling, Storage & Wet Storage Stain (WSS)

- a. Define acceptable handling methods after HDG
- b. Define packaging or dunnage requirements
- c. Define realistic expectations for preventing and removing WSS at the HDG plant
- d. Responsibility for preventing WSS during trucking
- e. Define storage and WSS removal procedures at the job site

IX. Inspection

- a. Define customer hold-points during QA/QC
- b. Reporting

X. Touch-Up & Repair At The Galvanizing Plant

- a. Repair material selection and practical limitations of the chosen material

- b. Use of cosmetic touch-up
- c. Cosmetic touch-up material selection and color matching

XI. Touch-Up & Repair At The Jobsite

- a. Repair material selection and practical limitations of the chosen material
- b. Define responsibility and a procedure for field repairs due to transportation, handling damage (flaking), or other erection activities
- c. Define responsibility and a procedure for remedying weeping welds and rust bleeding