

Siedlce, 03.08.2010 r.



Corrosion Protection Plant  
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WARRANTY CONDITIONS FOR HOT-DIP ZINC COATING  
for hot-dip galvanizing steel structures

POLIMEX-MOSTOSTAL S.A. gives the warranty for the period of time from two to five years (from the date of dispatching from our firm) for the hot dip-galvanizing steel structures produced according to ISO 1461 : 2009 standard.

Warranty period depends on the degree of aggressiveness of the environment (corrosivity category) in which the steel structure mentioned above will be stored, assembled and used in compliance with the table below:

Table 1

Periods of time for hot-dip galvanizing coatings for atmospheric corrosion.  
Type of the atmosphere and corrosivity category according to ISO 14713-1.

	Type of atmosphere	Corrosivity category	Period of time
1.	Inconsiderable corrosive burden	C1	5 years
2.	Little corrosive burden	C2	5 years
3.	Moderate corrosive burden	C3	5 years
4.	Strong corrosive burden	C4	4 years
5.	Very strong burden	C5, CX	2 years

Warranty granted to the following conditions:

- a) buyer directly upon receipt of the construction will repair coatings damaged during transport and handling, in accordance with ISO 1461, section 6.3: *"Repair should include the removal of contaminants (dust, oil, grease, traces of corrosion) and the necessary cleaning and surface preparation of the damaged space for the required grip."* Repair should be made by the painting primer paint rich in zinc. Thickness of the coating should be at least 100  $\mu\text{m}$ .
- b) storage, assembly and operation of the structures mentioned above will take place in an environment of aggressive corrosion category defined in Table 1, for the given warranty period,
- c) buyer qualifies environment's corrosivity category according to ISO 14713-1,
- d) during the time of storage elements of the construction will be stored on clippers to prevent direct contact with the ground and gathering up the precipitation and mechanical impurities (physical pollutions),
- e) zinc coating damaged during assembly will be mended in accordance with the Point (a),
- f) once a year the user will control zinc coating and will protect foci of corrosion which may occur, in compliance with the Point (a).

- g) Purchaser within 7 days before the planned inspection, notify Polimex-Mostostal SA about the date of the review and allow its representative to participate in it.  
If Polimex-Mostostal SA representative does not report for review within the prescribed period, the Employer will make inspection alone.
- h) Protocols with annual inspection will be kept on Employer`s files.

During the warranty total surface of the focuses of corrosion on steel substratum can not be bigger than specified in ISO 1461 (p. 6.3) standard for the imperfect places.

Warranty will not cover

- special cases of corrosive exposure given in ISO 14713-1 standard (in these cases time of the warranty should be individually agree in writing),
- mechanical damages of zinc coating made by shipment, transportation and assembly beyond POLIMEX-MOSTOSTAL S.A., when buyer has not mended these damages according to the Point (a), or when the surface of mended damages is bigger than that one permissible, specified in ISO 1461 for the imperfect places,
- mechanical or thermal damages of the zinc coating made by cutting, welding, drilling the holes and any other transformations of the construction after hot-dip galvanizing which cause damages of the zinc coating,
- mechanical, thermal and chemical damages during the time of operation,
- damages caused by stroke of fate (accidents).


So-called white corrosion (white-gray spots made by atmospheric factors) does not make the reason for complaint of the zinc coating.

Worked out:

  
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