

5600000 COATING NEW STRUCTURAL STEEL
COMMENTS FROM INTERNAL/INDUSTRY REVIEW

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560-9.1.1, I would recommend addressing some concerns by the CEI in recent projects. The top flange is coated below the recommended dry film thickness which can lead to rusting on the top flange. The original intent was not to prevent rust but to prevent bleeding that could mar the interior or exterior coating on adjacent surfaces. CEI's have argued that they should see no rust on the top flange and I think just miss-understand the application of a mist-coat and the intent of the language.

Would recommend adding an additional sentence or two to the end of 560-9.1.1. It would read: "When stud welding is specified, apply a mist coat of inorganic zinc-rich primer to the top flange at a dry film thickness no greater than 1 mil. Remove and repaint the top flange if rust is bleeding onto an adjacent surface of the girder. Visible rust on the top flange is not rejectable/is allowed."

Response: Understand the concern. The addition of the mist coat to the top flange should minimize any bleeding from the top flange. However, I agree with the possibility of some bleeding depending on the time of exposure to the environment prior to encapsulation in the concrete, and we have added a sentence directing to prevent this occurrence. The Contractor should be responsible for determining the means and time when this protection is needed, and the CEI will be able to enforce such protection if needed. We prefer not to add language allowing rust on the top flange since we cannot control the time of exposure, and for longer exposure times, excessive rust on the top flange may be basis for rejection as determined by the Engineer.
