

DRAFT AMENDMENT NO. 1

TO

**IS 18573 : 2024 COLD FORMED WELDED CARBON STEEL SQUARE AND
RECTANGULAR HOLLOW SECTIONS FOR MECHANICAL, GENERAL
ENGINEERING AND DECORATIVE PURPOSES - SPECIFICATION**

(Third Revision)

(Page 5, clause 13.2) — Substitute the following for the existing:

When square and rectangular section are to be hot dip galvanized, they shall first be thoroughly descaled and then dipped in a bath of molten zinc at a temperature suitable to produce a complete and uniformly adherent coating of zinc. The zinc used for coating shall conform to IS 209 or IS 13229. The galvanizing shall be capable of passing the test specified in IS 2633. Specific requirement for galvanizing and mass of coating shall be subject to mutual agreement between the purchaser and the manufacturer or as per the manufacturer's standard.

Pre galvanized sheet or strip may be used for manufacturing hollow sections. In case of pre galvanised sheet or strip, zinc coating shall confirm the requirements of coatings specified in IS 277 **excluding the coating of weld portion. Specific requirement for the method of coating and mass of coating of external weld section shall be subject to mutual agreement between the purchaser and the manufacturer as per the manufacturer's standard.**