



A valmont  COMPANY

Design Considerations

In order to provide our clients with the best possible solutions, Webforge Locker presents the following information to help you with your material and finishing selection.

Please be advised however, that this information is provided as a guide only and was prepared using resourced technical data and market based experience. Talk to your Webforge Locker representative to further discuss your design requirements.

Material Considerations

Mild Steel

Mild Steel contains the same properties as iron, although it has increased carbon content. Mild Steel is the most common form of steel as it is relatively low cost and provides material properties accepted for many applications. However, this also makes it susceptible to rusting; this occurs when the material comes in contact with water and oxygen. Where salt is present, usually in salt water, the effect is exaggerated.

Due to the nature of the material, Webforge Locker recommends that the product be coated prior to installation. Typical protection methods include Hot Dip Galvanising and electro-plating. These processes cannot guarantee against material corrosion as any scratching or minor damage can expose these raw material leaving it vulnerable to rust.

Aluminium

Aluminium carries the advantages of a light weight material; around one third the weight of steel. It is a soft metal, and as such can be prone to surface blemishes during manufacturing processes. Webforge Locker may recommend the material be coated prior to installation, if necessary. Aluminium naturally generates a protective oxide coating and is highly corrosion resistant. Different types of surface treatment such as anodising, painting or lacquering can further improve this property. Surface treatment is particularly useful for applications where protection and conservation are required, such as external applications.

Stainless Steel

All Stainless Steels have a high resistance to corrosion. This resistance to attack is due to the naturally occurring chromium-rich oxide film formed on the surface of the steel. Although extremely thin, this invisible, inert film is tightly adherent to the metal and extremely protective in a wide range of corrosive environments. The film is rapidly self-repairing in the presence of oxygen and damage by abrasion, cutting or machining is quickly repaired.

The two main grades of Stainless Steel used are 304 and 316; and both have high corrosion resistance.

Grade 316 has excellent corrosion resistance. Its main advantage over grade 304 is its increased ability to resist pitting and crevice corrosion in warm chloride environments. It resists ordinary

rusting in virtually all architectural applications and is often chosen for more aggressive environments such as sea front buildings and fitting on wharves and piers.

Although Stainless Steel has a high corrosion resistance, it is still susceptible to surface damage. The main problem is an issue called Tea Staining. This discolouration is caused by a buildup of contaminants on the surface of the material. The closer to a marine environment, the more severe the effect becomes; within 5 kilometers of the coast, grade 316 or above should be used. Lesser resistant grades such as 304 will be subject to more damage in less time.

Webforge Locker recommends that Stainless Steel be passivated or electro polished to minimize the effects of tea staining.

Maintenance also plays a key role in the defense against Stainless Steel corrosion. Washing the material regularly prevents buildup of contaminants and extends the life of the product dramatically. Although tea staining may occur, it does not affect the structural integrity of the material and can be controlled.

Titanium

Titanium is characterized by an excellent resistance to corrosion, from the most oxidant acids to saline atmospheres. However these increased capabilities come at an increased price point.

Copper

Copper is often used as an electrical conductor in cables, but is also used as a decorative building material. Copper is a very malleable and corrosion resistant material.

Brass

Brass is a term used to describe a wide range of copper-zinc alloys that have a combination of properties including strength, ductility, hardness, conductivity, wear resistance and corrosion resistance. These properties ensure that brass can be easily punched, fabricated and formed.

Galvabond®

Galvabond® G2 steel is hot-dipped, zinc-coated, commercial forming steel with a spangled surface, suitable for general manufacturing. As the material is pre coated, manufacturing processes such as expanding and perforating can leave raw material beneath exposed. This can result in rusting of the exposed material which may spread over time. Webforge Locker does not recommend using Galvabond® material over 1.6mm thick for this reason. Additionally, pre-galvanised materials such as Galvabond® are recommended by Webforge Locker for indoor use only, due to the risk of corrosion.

Zincalume®

Zincalume® G250 steel is a hot-dipped zinc/aluminium alloy coated, structural steel with a regular spangled surface. The coating is a blend of aluminium and zinc which greatly enhances its corrosion resistance. Zincalume® has been found to have a lifespan of up to four times that of ordinary galvanised steel.

As the material is pre coated, manufacturing processes such as expanding and perforating can leave the raw material beneath exposed. This can result in rusting of the exposed material which may spread over time. Webforge Locker does not recommend using Zincalume® material over 1.6mm thick for this reason.

Zincanneal® / Zincseal®

Material such as Zincanneal® and Zincseal® are hot-dipped, zinc/iron alloy coated and are suitable for coating prior to installation. As the material is pre coated, manufacturing processes such as expanding and perforating can leave the raw material beneath exposed. This can result in rusting of the exposed material which may spread over time. Webforge Locker does not recommend using this material over 1.6mm thick for this reason.

Galvabond®, Zinalume®, Zincanneal®, Zincseal® are registered trademarks of BlueScope Steel Limited.

Coating and Finishing Considerations

Anodising

Anodising converts the surface of aluminium from its natural state to another; with markedly different properties. This new surface is not a coating in the traditional sense as it is produced from the parent material and is integral with it. This provides highly effective corrosive resistance.

Due to manufacturing processes surface scuffs and scratching may be visible. Although care is taken to prevent this, Webforge Locker cannot guarantee against it and light scratching and other marks are often emphasized by the anodising process.

Understanding that anodising itself is a translucent finish, any inconsistencies within the supplied aluminium (including metallurgy, surface texture or grain structure) can become evident or accentuated after anodising. Webforge Locker ensures where practical, that raw material for any job is sourced from the same mill run, thereby reducing the variation in the level of impurities. However, even with this extra care Webforge Locker are unable to guarantee a consistent surface finish.

*For more information refer to LD-101.3- Anodising Aluminium.

Electro Polishing

Electro Polishing is a process of removing a layer of metal from the surface, leaving a smooth and bright finish, generally used on stainless steel. Maintenance is required to prevent build-up of contaminants which can lead to corrosion and tea-staining.

Powder Coating

Powder Coating is a decorative and durable plastic coating which can be provided in an almost unlimited range of colours. Powder Coating is an environmentally friendly process, as it does not give off any Volatile Organic Compounds which are evident in other liquid based coatings. Scratching or chipping the coated surface of the product after it has been powder coated can leave the raw material exposed. This can cause corrosion to the product over time.

Passivating

Passivating is a method of removing surface contaminants from Stainless Steel. It does not usually affect the surface colour of the material. Maintenance is required to prevent build-up of contaminants which can lead to corrosion and tea-staining.

Electroplating

Electroplating is an electro chemical process used to deposit a metallic coating on the base material, and is done after the manufacturing process. Scratching of the product after it has been electroplated can leave the raw material exposed. This can cause corrosion to the product over time.

P.V.C Coating

Material may be supplied with a P.V.C protective coating to protect against marking to the material. This can interfere with machinery during the manufacturing process. As a result of this, Webforge Locker may be forced to remove the coating, which may result in surface markings to the material. Webforge Locker will not be held responsible if this occurs during the manufacturing process.