



Standard Specification for Electrodeposited Coatings of Zinc Nickel Alloy Deposits¹

This standard is issued under the fixed designation B 841; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ε) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers the requirements for electrodeposited zinc nickel alloy coatings on metals.

1.2 The values stated in SI units are to be regarded as the standard.

1.3 The following precautionary statement pertains to the test method portion only, Section 8, of this specification: *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:²

- B 117 Practice for Operating Salt Spray (Fog) Apparatus
- B 183 Practice for Preparation of Low-Carbon Steel for Electroplating
- B 242 Guide for Preparation of High-Carbon Steel For Electroplating
- B 320 Practice for Preparation of Iron Castings for Electroplating
- B 322 Guide for Cleaning Metals Prior to Electroplating
- B 374 Terminology Relating to Electroplating
- B 487 Test Method for Measurement of Metal and Oxide Coating Thickness by Microscopical Examination of a Cross Section
- B 499 Test Method for Measurement of Coating Thicknesses By the Magnetic Method: Nonmagnetic Coatings on Magnetic Basis Metals
- B 504 Test Method for Measurement of Thickness of Metallic Coatings by the Coulometric Method
- B 507 Practice for Design of Articles To Be Electroplated on Racks

B 568 Test Method for Measurement of Coating Thickness by X-Ray Spectrometry

B 571 Practice for Qualitative Adhesion Testing of Metallic Coatings

B 602 Test Method for Attribute Sampling of Metallic and Inorganic Coatings

B 697 Guide for Selection of Sampling Plans for Inspection of Electrodeposited Metallic and Inorganic Coatings

B 762 Test Method of Variables Sampling of Metallic and Inorganic Coatings

B 849 Specification for Pre-Treatments of Iron or Steel for Reducing Risk of Hydrogen Embrittlement

B 850 Guide for Post-Coating Treatments of Steel for Reducing the Risk of Hydrogen Embrittlement

B 3951 Practice for Commercial Packaging

3. Terminology

3.1 *Definitions*—Many items used in this specification are defined in Terminology B 374.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *significant surface, n*—that portion of a coated article's surface where the coating is required to meet all the requirements of the coating specification for that article. Significant surfaces are usually those that are essential to the serviceability or function of the article, or that can be a source of corrosion products or tarnish films that interfere with the function or desirable appearance of the article.

3.2.2 *Discussion*—Significant surfaces are those surfaces that are identified by the purchaser by, for example, indicating them on an engineering drawing of the product or marking a sample item of the product.

4. Classification

4.1 There is one class of zinc nickel coating defined as follows:

4.1.1 *Class 1*—Deposits having a minimum of 5 and maximum 12 mass % nickel, the balance being zinc.

4.2 There are five chromate conversion coating types that are defined as follows:

4.2.1 *Type A*—With colorless (blue bright) conversion coatings,

4.2.2 *Type B*—With yellow iridescent conversion coatings,

4.2.3 *Type C*—With bronze conversion coatings,

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

4.2.4 *Type D*—With black chromate conversion coatings, and

4.2.5 *Type E*—Any of the above plus organic topcoat.

NOTE 1—Whereas colored chromate conversion coatings are usually meant to include various shades of yellow to bronze when used with nonalloyed zinc, yellow and bronze chromate conversion coatings are considered distinctly different in appearance and performance when applied to alloyed zinc coatings and are formulated specifically to produce the desired coating and are formulated specifically to produce the desired coating.

4.3 There are three grades according to thickness and are defined as follows:

Minimum Thickness, μm	New ASTM Grade	Old ASTM Grade
5	5	1
8	8	2
10	10	3

5. Ordering Information

5.1 In order to make the application of this specification complete, the purchaser needs to supply the following information to the seller in the purchase order and drawings:

5.1.1 Title, ASTM designation number, and date of issue of this standard specification,

5.1.2 Deposit by classification including Class, Type, and Grade (see 4.1, 4.2, 4.3),

5.1.3 Composition and metallurgical condition of the substrate to be coated,

5.1.4 Location of significant surfaces (see 3.2.1),

5.1.5 Heat treatment for stress relief, whether it has been performed by purchaser or is required (see 6.7),

5.1.6 Heat treatment after electroplating, if required (see 6.8),

5.1.7 Whether or not location of rack marks is to be defined (see 6.3.1),

5.1.8 Any requirement for special test specimens (see 8.1.1),

5.1.9 Acceptance inspection procedure to be used (see Section 8), and

5.1.10 Any requirement for certification (see Section 10).

5.1.11 Any other items needing agreement. For the purposes of this specification, prior agreement on the nature of the finish is required as items plated in bulk may differ in appearance from those that are rack plated.

6. Coating Requirements

6.1 *Substrate*—The metal to be plated shall be free of flaws and defects that will be detrimental to the zinc alloy coating. It shall be subjected to such cleaning, pickling, and electroplating procedures as are necessary to yield deposits with the desired quality.

NOTE 2—Proper preparatory procedures and thorough cleaning are essential to ensure satisfactory adhesion and corrosion resistance performance of the coating. Materials used for cleaning should not damage the basis metal, for example by causing defects such as pits, intergranular attack or stress corrosion cracking. It is recommended that the following practices for cleaning, where appropriate, be used: Practices B 183 and B 320, and Guides B 242 and B 322.

6.1.1 The electroplating shall be applied after all basis metal heat treatments have been completed.

6.2 Nature of Coating:

6.2.1 The coating shall consist of a zinc nickel alloy that has a minimum of 5 and maximum 12 mass percent nickel, the balance being zinc.

6.2.2 The coating shall be produced from an aqueous electroplating system that may be either an alkaline or acid formulation as specified by the purchaser.

6.2.3 The coating shall have such supplementary conversion coatings as defined in 4.2 and specified in the purchase order.

6.3 Appearance:

6.3.1 The coating on all ready visible surfaces shall have an acceptable and characteristic appearance as agreed upon by the purchaser and seller. The coating shall be uniform insofar as the basis metal will permit. When the article is to be plated on a rack, contact marks may be unavoidable. Location of such marks(s) shall be indicated on the article or its drawing.

6.3.2 Defects and variations in appearance that arise from surface conditions of the substrate (scratches, pores, roll marks, inclusions, and the like) and that persist in the coating despite the observance of good metal finishing practices shall not be cause for rejection. The coating shall be adherent, free from blisters, pits, or discontinuities, and shall be free of cracks in the as plated state. Flaking shall be cause for rejection in either the as plated state or after subsequent operations.

NOTE 3—These coatings are commonly used in automotive applications where subsequent forming, bending, and crimping operations are commonly performed. These operations will necessarily detract from the performance of the coatings. While some cracking of coatings will be unavoidable, flaking of the coating after these subsequent operations shall be cause for rejection.

NOTE 4—Coatings generally perform better in service when the substrate over which they are applied is smooth and free of torn metal, inclusions, pores, and other defects. The specifications covering the unfinished product should provide limits for these defects. A metal finisher can often remove defects through special treatments, such as grinding, polishing, abrasive blasting, chemical etches, and electropolishing. However, these are not normal in the treatment steps preceding the application of the coating. When they are desired, they are the subject of special agreement between the purchaser and the seller.

6.4 Thickness:

6.4.1 The thickness of the coating everywhere on the significant surfaces as defined in 3.2.1 and shall conform to the requirements of the specified grade as defined in 4.3.

NOTE 5—The thickness of electrodeposited coatings varies from point to point on the surfaces of a product (see Practice B 507). The thickness is less in interior corners and in holes. Such surfaces are often exempt from thickness requirements. If the full thickness is required in those locations, the electroplater will have to use special techniques that will probably raise the cost of the process.

NOTE 6—The coating requirement of this specification is a minimum. Variation in the thickness from point to point on an article and from article to article in a production lot is inherent in electroplating. Therefore, if all of the articles in a production lot are to meet the thickness requirement, the average coating thickness for the production lot as a whole will be greater than the specified minimum.

6.5 *Adhesion*—The coating shall withstand normal handling and storage conditions without chipping, flaking, or other coating damage and shall conform to the minimum requirements set forth in Section 8.

6.6 *Corrosion*—The corrosion resistance of the coating may be evaluated using the method in [Appendix X1](#).

6.7 *Pretreatment of Iron and Steel for Reducing the Risk of Hydrogen Embrittlement*:

6.7.1 Parts that are made of steels with ultimate tensile strengths of 1000 MPa (hardness of 31 HRC or greater) that have been machined, ground, cold formed, or cold straightened subsequent to heat treatment shall require stress relief heat treatment when specified by the purchaser, the tensile strength to be supplied by the purchaser. Specification [B 849](#) may be consulted for a list of pre-treatments that are widely used.

6.8 *Post-Coating Treatments of Iron and Steel for Reducing the Risk of Hydrogen Embrittlement*:

6.8.1 Parts that are made of steels with ultimate tensile strengths of 1000 MPa (hardness of 31 HRC or greater), as well as surface hardened parts, may require post-coating hydrogen embrittlement relief baking when specified by the purchaser, the tensile strength to be supplied by the purchaser. Specification [B 850](#) may be consulted for a list of post-treatments that are widely used.

7. Sampling

7.1 The sampling plan used for the inspection of a quantity of the coated articles shall be as agreed upon between the purchaser and the seller.

NOTE 7—Usually, when a collection of coated articles, the inspection lot (see [7.2](#)), is examined for compliance with the requirements placed on the articles, a relatively small number of the articles, the sample, is selected at random and is inspected. The inspection lot is then classified as complying or not complying with the requirements based on the results of the inspection of the sample. The size of the sample and the criteria of compliance are determined by the application of statistics. The procedure is known as sampling inspection. Three standards, Test Method [B 602](#), Guide [B 697](#), and Test Method [B 762](#) contain sampling plans that are designed for the sampling inspection of coatings. Test Method [B 602](#) contains four sampling plans, three for use with tests that are nondestructive and one when they are destructive. The buyer and seller may agree on the plan or plans to be used. If they do not, Test Method [B 602](#) identifies the plan to be used. Guide [B 697](#) provides a large number of plans and also gives guidance in the selection of a plan. When Guide [B 697](#) is specified, the buyer and seller need to agree on the plan to be used. Test Method [B 762](#) can be used only for coating requirements that have a numerical limit, such as a coating thickness. The test must yield a numerical value and certain statistical requirements must be met. Test Method [B 762](#) contains several plans and also gives instructions for calculating plans to meet special needs. The buyer and the seller may agree on the plan or plans to be used. If they do not, Test Method [B 762](#) identifies the plan to be used.

NOTE 8—When both destructive and nondestructive tests exist for the measurement of a characteristic, the purchaser needs to state which is to be used so that the proper sampling plan is selected. A test may destroy the coating but in a noncritical area; or, although it may destroy the coating, a tested part can be reclaimed by stripping and recoating. The purchaser needs to state whether the test is to be considered destructive or nondestructive.

7.2 An inspection lot shall be defined as a collection of coated articles that are of the same kind, that have been produced to the same specification that have been coated by a single supplier at one time or at approximately the same time under essentially identical conditions, and that are submitted for acceptance or rejection as a group.

7.3 If special test specimens are used to represent the coated articles in a test, the number used shall be that required in [8.1.1](#).

8. Test Methods

8.1 *Special Test Specimens*:

8.1.1 The permission or the requirement to use special test specimens, the number to be used, the material from which they are to be made, and their shape and size shall be stated by the purchaser.

NOTE 9—Test specimens often are used to represent the coated articles in a test if the articles are of a size, shape, or material that is not suitable for the test or if it is preferred not to submit articles to a destructive test because, for example, the articles are expensive or few in number. The specimen should duplicate the characteristics of the article that influence the property being tested.

8.1.2 Special test specimens used to represent articles in an adhesion, porosity, corrosion resistance, or appearance test shall be made of the same material, in the same metallurgical condition, and have the same surface condition as the articles they represent, and be placed in the production lot of and be processed along with the articles they represent.

8.1.3 Special test specimens used to represent articles in a coating thickness test may be made of a material that is suitable for the test method even if the represented article is not of the same material. For example, a low-carbon steel specimen may represent a brass article when the magnetic thickness test is used (see Test Method [B 499](#)). The thickness specimen need not be carried through the complete process with the represented article. If not, introduce it into the process at the point where the coating is applied and carry it through all steps that have a bearing on the coating thickness. In rack plating, rack the specimen in the same way with the same distance from and orientation with the anodes and other items in the process as the article it represents.

NOTE 10—When special test specimens are used to represent coated articles in a thickness test, the specimens will not necessarily have the same thickness and thickness distribution as the articles unless the specimens and the articles are of the same general size and shape. Therefore, before finished articles can be accepted on the basis of a thickness test performed on special test specimens, the relationship between the thickness on the specimen and the thickness on the part needs to be established. The criterion of acceptance is that thickness on the specimen that corresponds to the required thickness on the article.

8.2 *Composition of Coating*—Verify the composition of the coating by atomic absorption spectrophotometry (AA), inductively coupled plasma (ICP), or directly coupled plasma (DCP) or other methods if found to be capable of results within 10 % of known standards.

8.3 *Appearance*—Examine the coating at up to 10× magnification for conformance to the requirements of appearance.

8.4 *Thickness*—Measure the coating thickness at locations on the significant surface designated by the purchaser, and make the measurement with an accuracy of 10 % or better by use of one of the following test methods: Test Methods [B 487](#), [B 499](#), [B 504](#), [B 568](#).

8.5 *Adhesion*—Test the adhesion of the coating in accordance with Practice [B 571](#). The choice of test method shall be one of those appropriate for zinc coatings.

8.6 *Corrosion Resistance*—See [Appendix X1](#).



9. Rejection and Rehearing

9.1 Articles that fail to conform to the requirements of this specification may be rejected. Rejection shall be reported to the producer or supplier promptly and in writing. In case of dissatisfaction with the results of a test, the producer or supplier may make a claim for a rehearing. Coatings that show imperfections during subsequent manufacturing operations may be rejected.

10. Certification

10.1 When specified in the purchase order or contract, the purchaser shall be furnished certification that samples representing each lot have been either tested or inspected as directed

in this specification and the requirements have been met. When specified in the purchase order or contract, a report of the test results shall be furnished.

11. Packaging

11.1 The packaging and packing requirements shall be in accordance with Practice D 3951 or as specified in the contract or order.

12. Keywords

12.1 coatings electrodeposited; corrosion resistant coatings; electrodeposited zinc nickel alloy plating; electroplating; zinc alloy; zinc nickel

APPENDIX

(Nonmandatory Information)

X1. Corrosion Resistance of Coating

TABLE X1.1 Neutral Salt Spray Hours

Class	Grade	Type	Base Metal Corrosion	Alloy Corrosion Product
1	5	A	150	20
	5	A/E	300	150
	8	A	240	20
	8	A/E	400	150
	10	A	500	20
	10	A/E	620	150
1	5	B	500	120
	5	B/E	620	240
	8	B	720	120
	8	B/E	840	240
	10	B	960	120
	10	B/E	1080	240
1	5	C	750	180
	5	C/E	1000	300
	8	C	960	180
	8	C/E	1200	300
	10	C	1000	180
	10	C/E	1500	300
1	5	D	500	100
	5	D/E	620	220
	8	D	720	100
	8	D/E	840	220
	10	D	960	100
	10	D/E	1080	220

X1.1 The corrosion resistance of the coating may be evaluated using Practice B 117. Table X1.1 suggests durations

of continuous testing that properly applied coatings should withstand but are to be used as a guide only.

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