

Zinc Coating Thickness Requirements: ASTM A153 vs. F2329

Dimension	ASTM A153		ASTM F2329		
	Avg. Coating Thickness of Specimens Tested	Avg. Coating Thickness of Any Individual Specimen	Avg. Coating Thickness of Specimens Tested (Production Lot)	Avg. Coating Thickness of Specimens Tested (Batch Lot)	Avg. Coating Thickness of Any Individual Specimen
Class A – Castings – Malleable Iron, Steel	3.4 mils 86 µm	3.1 mils 79 µm	N/A	N/A	N/A
Class B1 – Thickness ≥ 3/16 in & Length > 15 in	3.4 mils 86 µm	3.1 mils 79 µm	N/A	N/A	N/A
Class B2 – Thickness < 3/16 in & Length > 15 in	2.6 mils 66 µm	2.1 mils 53 µm	N/A	N/A	N/A
Class B3 – Any Thickness & Length ≤ 15 in	2.2 mils 56 µm	1.9 mils 48 µm	N/A	N/A	N/A
Class C – Fasteners, Diameter > 3/8 in	2.1 mils 53 µm	1.7 mils 43 µm	2.0 mils 50 µm	1.7 mils 43 µm	1.7 mils 43 µm
Class C – Washers, Thickness = 3/16 in & Thickness = 1/4 in					
F2329 – Washers, Thickness ≥ 3/16 in	Ref. A153 Classes C or B	Ref. A153 Classes C or B	2.0 mils 50 µm	1.7 mils 43 µm	1.7 mils 43 µm
F2329 Supplementary Requirement S1 – A394 Bolts	Ref. A153 Class C 2.1 mils 53 µm	Ref. A153 Class C 1.7 mils 43 µm	2.8 mils 70 µm	2.8 mils 70 µm	2.5 mils 63 µm
Class D – Fasteners, Diameter ≤ 3/8 in	1.7 mils 43 µm	1.4 mils 36 µm	1.7 mils 43 µm	1.5 mils 38 µm	1.5 mils 38 µm
Class D – Washers, Thickness < 3/16 in					