GENERAL INDEX

1 INTRODUCTION 16
1.1. Justification and interest of the topic 16
1.2. Research hypothesis 18
1.3. Research objectives 20
1.4. Methodology and structure of the investigation 21
2 BACKGROUND 22
2.1. Corrosion key concepts 22
2.1.1. Definitions 22
2.1.2. Electrochemical corrosion 23
2.1.3. Electrochemical potential 25
2.1.4. Atmospheric corrosion 27
2.1.5. Influencing atmospheric pollutants in corrosion processes 28
2.1.6. Mechanical tension and corrosion 29
2.2. Galvanization processes 29
2.2.1. Discontinuous galvanizing 29
2.2.2. Continuous galvanizing 30
2.3. Long-term corrosion calculation on zinc-based coatings 30
2.3.1. Zinc-based coatings 30
2.3.2. ZM alloys 34
2.4. Structure characterization of ZM alloys 35
2.5. Corrosion behaviour and corrosion products characterization 36
2.6. Relevant international standards covering ZM coatings 38
2.6.1. Standards to classify environments and corrosivity categories 38
2.6.2. Standards to classify continuously hot-dip coated steel flat products for cold forming 42
2.6.3. Standard to classify steel wire products 44
2.6.4. Differences between standards in terms of aluminium and magnesium content 44
2.6.5. Product standard regarding cable trays systems 45
2.7. Environmental claims in Zinc-Aluminium-Magnesium alloys 46
2.8. Zinc-Aluminium-Magnesium alloys offered in the market 47
2.9. Example of application: Cable trays systems 53
2.9.1. Brief Cable Tray systems introduction 53
2.9.2. Types of cable tray systems according to their metallic coating 53
2.9.3. Cable trays system manufacturers using ZM alloys 55
2.10. Accelerated corrosion tests on ZM 57
2.10.1. Introduction 57
2.10.2. Accelerated tests description and main conclusions 57
2.11. Field corrosion tests on Z and ZM alloys coatings 61
2.11.1. Introduction 61
2.11.2. Field tests description and main conclusions 61
3 METHODOLOGYCAL FRAMEWORK 70

3.1. Introduction 70
3.2. Block I: General analysis 71
3.2.1. Classification of field tests results 71
3.2.2. Filtering of results 71
3.2.3. Statistical analysis per ISO 9223 corrosivity categories 71
3.2.4. Average linear evolution of Z and ZM finishes 71
3.2.5. Ratios Z-ZM and Z/ZM 71
3.2.6. Behaviour of ZM during first year of exposure 71
3.3. Block 2: Long-term corrosion prediction 72
3.3.1. General approach 72
3.3.2. Applications in projects calculations 72
4 RESULTS AND DISCUSSIONS 77
4.1. General view of results classified by year and corrosivity class 77
4.1.1. Summary of field tests results 77
4.1.2. ZM alloys 82
4.1.3. Zinc coatings 86
4.2. Boxplot charts 90
4.2.1. ZM alloys 90
4.2.2. Zinc coatings 93
4.3. Average linear charts 95
4.4. Global evolution between Z and ZM average mass loss 99
4.5. Ratios Z-ZM and Z/ZM evolution over the time 101
4.6. The behaviour of ZM alloys during the first years of exposure 105
4.6.1. Background 105
4.6.2. Analysis on a 4-year test 105
4.6.3. Analysis on a 6-year test 107
4.7. Cut edges effect 110
4.8. Long-term corrosion prediction 111
4.8.1. Corrosion prediction with the actual field tests values analysis 111
4.8.2. Corrosion prediction using the general corrosion expression 112
4.8.3. Application of long-term corrosion prediction to ZM alloys with general corrosion expression 112
5 CASE STUDY 124
5.1. Part I: Duration calculation from a given thickness coating 124
5.2. Part II: Corrosion calculation from a given exposition time 126
5.3. Economic impact 129
6 CONCLUSIONS, SYNTHESIS OF CONTRIBUTIONS AND FUTURE RESEARCHES 130
6.1. Conclusions 130
6.2. Synthesis of contributions 133
6.3. Final reflection 134
6.4. Future researches 134
REFERENCES 135

INDEX OF FIGURES

Figure 1: Corrosion resistance of *Magnelis* alloy in a cyclic test (Source: Arcelor Mittal public brochure *Magnelis: Think strategy*)....18
Figure 2: Mass loss comparison between galvanized steel and zinc alloys (Source: Wheeling-Nisshin public ZAM brochure)....19
Figure 3: Comparison between Tata Corus *Magizinc*® and zinc coatings. Source: Tata Corus public *Magizinc* brochure)....19
Figure 4: General scheme of a dry cell with $ClNH_4$ as electrolyte....24
Figure 5: Diagram of the operation of an acid solution corrosion cell....25
Figure 6: Diagram of the operation of an aerated neutral solution corrosion cell....25
Figure 7: Variation of ft, versus wetness time. Source: own illustration based on reference (Morcillo & Feliu, 1993)....32
Figure 8: Variation of α versus mean values of SO_2. Source: own illustration based on reference (Morcillo & Feliu, 1993)....32
Figure 9: Variation of β versus mean values of chlorides. Source: own illustration based on reference (Morcillo & Feliu, 1993)....32
Figure 10: Corrosion evolution in ZM alloys for C2-CX corrosivity class (µm vs years)....35
Figure 11: Characterization of the uncorroded Zn-Mg-Al coating: (a) General structure; (b) High resolution figure representing the detailed microstructure of the ternary eutectic....36
Figure 12: NSST corrosion resistance of Z and ZM materials....36
Figure 13: Barrier layer effects creation in ZM materials....37
Figure 14: Aluminium content (%) ranges according to the 3 main standards for ZM materials....44
Figure 15: Magnesium content (%) ranges according to the 3 main standards for ZM materials....45
Figure 16: Zinc runoff rate. Source: (Source: Arcelor Mittal public brochure *Magnelis book*)....46
Figure 17: Production impact on CO_2 emissions in *Magnelis*® production. (Source: Arcelor Mittal public brochure *Magnelis book*)....47
Figure 18: Evolution of metal alloys development in the European market....47
Figure 19: Content of aluminium and magnesium offered by the main ZM suppliers....52
Figure 20: Sum of aluminium and magnesium content offered by the main ZM suppliers....52
Figure 21: NSST duration before red rust. % represents the sum of Al+Mg content....53
Figure 22: Example of pre-galvanized cable trays offer (Source: Pemsa Cable Management SAU – Spain. Public catalogue)....54
Figure 23: Example of white and yellow electroplated finish in mesh cable trays (Source: Schneider Electric, public catalogue)....55
Figure 24: Evolution of mass loss from 3 to 24 months....69
Figure 25: Methodology to choose the type of material. Part I: Duration calculation from a given thickness coating: Z finishes....73
Figure 26: Methodology to choose the right material. Part I: Duration calculation from a given thickness coating: ZM finishes....74
Figure 27: Methodology to choose the right material. Part II: Corrosion calculation from a given exposition time: Z finishes....75
Figure 28: Methodology to choose the right material. Part II: Corrosion calculation from a given exposition time: ZM finishes....76
Figure 29: ZM mass loss for C2 corrosivity category boxplot chart....90
Figure 30: ZM mass loss for C3 corrosivity category boxplot chart....91
Figure 31: ZM mass loss for C4 corrosivity category boxplot chart....92
Figure 32: ZM mass loss for C5 corrosivity category boxplot chart....92
Figure 33: ZM mass os for CX corrosivity category boxplot chart....93
Figure 34: Z mass loss for C2 corrosivity category boxplot chart....93
Figure 35: Z mass loss for C3 corrosivity category boxplot chart....94
Figure 36: Z mass loss for C4 corrosivity category boxplot chart....94
Figure 37: Z mass os for C5 corrosivity category boxplot chart....95
Figure 38: Z mass loss for CX corrosivity category boxplot chart....95
Figure 39: Mass loss evolution over time for C2 corrosivity category....96
Figure 40: Mass loss evolution over time for C3 corrosivity category....97
Figure 41: Mass loss evolution over time for C4 corrosivity category....97
Figure 42: Mass loss evolution over time for C5 corrosivity category....98
Figure 43: Mass loss evolution over time for CX corrosivity category....98
Figure 44: Mass loss yearly average evolution for Z and ZM coatings....100

Figure 45: Evolution of the average of Z-ZM ratio along corrosivity categories 102
Figure 46: Evolution of the average of Z/ZM ratio along corrosivity categories 103
Figure 47: Yearly evolution of Z-ZM and Z/ZM indicators by corrosivity category 104
Figure 48: Yearly evolution of Z/ZM general average ratio for 4-years exposure test 106
Figure 49: Yearly evolution of Z/ZM average ratio for 4-years exposure test - C2 corrosivity category 106
Figure 50: Yearly evolution of Z/ZM average ratio for 4-years exposure test - C3 corrosivity category 107
Figure 51: Yearly evolution of Z/ZM average ratio for 4-years exposure test - C4 corrosivity category 107
Figure 52: Yearly evolution of Z/ZM general average ratio for 6-years exposure test 109
Figure 53: Yearly evolution of Z/ZM average ratio for 6-years exposure test - C2 corrosivity category 109
Figure 54: Yearly evolution of Z/ZM average ratio for 6-years exposure test - C3 corrosivity category 110
Figure 55: Yearly evolution of Z/ZM average ratio for 6-years exposure test - C4 corrosivity category 110
Figure 56: Yearly mass loss graphic evolution in C2 corrosivity category for each of the calculated values of *n* 115
Figure 57: Yearly mass loss graphic evolution in C3 corrosivity category for each of the calculated values of *n* 117
Figure 58: Yearly mass loss graphic evolution in C4 corrosivity category for each of the calculated values of *n* 119
Figure 59: Yearly mass loss graphic evolution in C5 corrosivity category for the calculated value of *n*. 121
Figure 60: Yearly mass loss graphic evolution in CX corrosivity category for the calculated value of *n* 123
Figure 61: Yearly mass loss graphic evolution for all corrosivity categories using the average of of *n* values 123
Figure 62: Yearly mass loss graphic evolution for C2, C3 and C4 corrosivity categories using the average of *n* values 124

ÍNDEX OF TABLES

Table 1: Standard Electrode Potentials in Aqueous Solution at 25°C 26
Table 2: Variables and parameters used in the methods to estimate annual corrosion (A) 31
Table 3: Possible values of n-parameter for different types of atmospheres 33
Table 4: n ranges obtained in long-term exposures (10-20 years) 33
Table 5: n-parameter values for predicting and estimating zinc corrosion attack according to EN ISO 9224 34
Table 6: Long-term corrosion equations for the different corrosivity categories in ZM and ZA alloys 34
Table 7: Time to red rust appearance as a function of testing conditions in weeks 37
Table 8: 24 h cycle time distribution in Volvo® test according to STD1027 38
Table 9: Corrosion results expressed in coating mass loss for each material tested by Galvazinc & Cetim in Volvo test according to STD1027 38
Table 10: ISO atmosphere corrosivity categories 39
Table 11: Corrosion rates for zinc, r_{corr}, expressed in $\mu m \cdot a^{-1}$ for the first year of exposure for the different corrosivity categories ISO 9223 39
Table 12: Description of typical atmospheric environments related to the estimation of corrosivity categories (Source: ISO 9223) 40
Table 13: Time exponent values for predicting and estimating corrosion attack. Source: ISO 9224 (Table 2) 41
Table 14: Composition of zinc/aluminium/magnesium alloys according to EN 10346 42
Table 15: Coating mass for Zinc (Z) and Zinc-magnesium alloy (ZM). Source: EN 10346 (Table 12) 43
Table 16: Most relevant metallic alloys alternative to traditional zinc-based coatings 44
Table 17: Classification for corrosion resistance according to IEC 61537 45
Table 18: Salt spray test duration according to IEC 61537 46
Table 19: Main alloys based on zinc-aluminium-magnesium products existing in the market and their corresponding manufacturers, used in electrical conduits 48
Table 20: Minimum coating thickness and mass on samples that are not centrifuged (ISO 1461) 54
Table 21: Examples of cable trays system manufacturers using ZM and ZA alloys (standard or wire cable trays) 56
Table 22: Accelerated test #1 summary and corrosion rate 57
Table 23: Accelerated test #2 summary and corrosion rate (µm) 58
Table 24: Accelerated test #3 summary and corrosion rate (µm) 59
Table 25: Accelerated test #4 summary and corrosion rate (µm) 60
Table 26: Accelerated test #5 summary and corrosion rate (µm) 60
Table 27: Accelerated test #6 summary and corrosion rate (µm) 61
Table 28: Field test #1 summary and corrosion rate 62
Table 29: Field test #2 summary and corrosion rate 62
Table 30: Field test #3 summary and corrosion rate 63
Table 31: Field test #4 summary and corrosion rate 64
Table 32: Field test #5 summary and corrosion rate 65
Table 33: Field test #6 summary and corrosion rate 66
Table 34: Field test #7 summary and corrosion rate 67
Table 35: Field test #8 summary and corrosion rate 68
Table 36: Field test #9 summary and corrosion rate 69
Table 37: Field test #10 summary and corrosion rate 70
Table 38: Field tests results summary of the different research works analysed 78
Table 39: Summary of corrosion rate results (µm/year) for ZM finishes 84
Table 40: Reviewed summary of corrosion rate results (µm/year) for ZM finishes 85
Table 41: Average, median and standard deviation from field tests for ZM finishes 86
Table 42: Summary of corrosion rate results (µm/year) for Z finishes 88
Table 43: Reviewed summary of corrosion rate results (µm/year) for Z finishes 89
Table 44: Average, median and standard deviation from field tests for Z finishes 90
Table 45: Average mass loss of Z and ZM finishes (µm) 96
Table 46: Average, gap ZM-Z and ratio Z/ZM yearly evolution by corrosivity class 101
Table 47: Average of mass loss for Z-ZM ratio by corrosivity category 101
Table 48: Average of mass loss for Z/ZM ratio by corrosivity category 102
Table 49: Ratio Z/ZM in 4 years field test (test number 8) 105
Table 50: 4 years tests field results (example for test number 8.1: Brest) 105
Table 51: Yearly evolution of Z/ZM average ratio for 4-years exposure test 106

Table 52: Ratio Z/ZM in 6 years field test (test number 10) 107
Table 53: 6 years tests field results (test number 10.1: Brest) 108
Table 54: Yearly evolution of Z/ZM average ratio for 6-years exposure test 108
Table 55: Corrosion parameters using logarithmic method. Forecasted values 113
Table 56: Yearly mass loss evolution in C2 corrosivity category for each of the calculated values of n. 114
Table 57: Yearly mass loss evolution in C3 corrosivity category for each of the calculated values of n. 116
Table 58: Yearly mass loss evolution in C4 corrosivity category for each of the calculated values of n. 118
Table 59: Yearly mass loss evolution in C5 corrosivity category for the calculated value of n 120
Table 60: Yearly mass loss evolution in CX corrosivity category for the calculated value of n 122
Table 61: Case study - Part I: Calculated duration (years) for a 24 microns coating thickness for Z and ZM finishes 126
Table 62: Case study - Part II: Calculated corrosion (microns) for a 20 years warranty for Z and ZM finishes 128

ÍNDEX OF EQUATIONS

Equation 1: General long-term corrosion expression 30
Equation 2: Long-term corrosion calculation in Z coatings (method 1) 31
Equation 3: Long-term corrosion calculation in Z coatings (method 2) 31
Equation 4: Long-term corrosion calculation in Z coatings (method 3) 31
Equation 5: Long-term corrosion calculation in Z coatings (method 4) 31
Equation 6: Calculation of fc coefficient in Method 4 calculation method 31
Equation 7: Long-term corrosion calculation in Z coatings (method 5) 32
Equation 8: Long-term corrosion calculation in Z coatings (method 6) 33
Equation 9: Long-term corrosion calculation in Z coatings (method 7) 33
Equation 10: Long-term corrosion calculation in Z coatings (method 8) 33
Equation 11: Long-term corrosion calculation in Z coatings (method 9) 33
Equation 12: Long-term corrosion calculation in Z coatings (method 10) 33
Equation 13: Conversion of thickness units (microns)-(g/m^2) 42
Equation 14: Corrosion function for C2 corrosivity category-Year 2 113
Equation 15: Corrosion function for C2 corrosivity category-Year 4 113
Equation 16: Corrosion function for C2 corrosivity category-Year 6 114
Equation 17: Corrosion function for C2 corrosivity category-Average 114
Equation 18: Corrosion function for C3 corrosivity category-Year 2 115
Equation 19: Corrosion function for C3 corrosivity category-Year 4 115
Equation 20: Corrosion function for C3 corrosivity category-Year 6 115
Equation 21: Corrosion function for C3 corrosivity category-Average 115
Equation 22: Corrosion function for C4 corrosivity category-Year 2 117
Equation 23: Corrosion function for C4 corrosivity category-Year 4 117
Equation 24: Corrosion function for C4 corrosivity category-Year 6 117
Equation 25: Corrosion function for C4 corrosivity category-Average 117
Equation 26: Corrosion function for C5 corrosivity category-Year 2 119
Equation 27: Corrosion function for CX corrosivity category-Year 2 121
Equation 28: Calculation of *t* parameter from the general corrosion expression 125