

SERVICE DATASHEET · NEW

Hot Dip Galvanizing & Job Work

In-house kettle at Howrah since 2018



Operators at the galvanizing kettle

Indo East installed its own hot-dip galvanizing line at Howrah in 2018, completing vertical integration. We galvanize our own fabrication and take job work from others on the same kettle, to the same standards, with the same batch readings issued.

The commercial argument is simple: most Indian fabricators send steel out to be coated, which means two plants, two schedules, two inspection visits, and a coating nobody in the chain will commit to in writing. Here it is one company. A batch that comes out wrong is ours to put right rather than ours to chase.

CERTIFIED · REGISTERED

ISO 9001:2015

ISO 14001:2015

ISO 45001:2018

IEC 0211004090

EEPC RCMC

RDSO APPROVED

TECHNICAL SPECIFICATION

PARAMETER	SPECIFICATION
Kettle	7.0 m × 1.2 m × 1.6 m (L × W × D), natural-gas fired and temperature controlled
Bath temperature	About 450 °C, molten zinc
Coating held	75–85 microns as standard, read on a calibrated DFT gauge and recorded per batch
Standards	IS 2629 process · IS 4759 coating mass · IS 6745 and IS 2633 verification · ASTM A123, ASTM A153 or EN ISO 1461 where specified
Pre-treatment	Eight stages: degrease, rinse, acid pickle, rinse, flux, dry, dip, quench and measure
Capacity	1,500 MT a month
Longer than 7.0 m	Double-dipped. Standard practice, but it leaves a visible overlap line — agree it before fabrication, not at the kettle

PRODUCT RANGE

Job work galvanizing

Bring your fabrication; we pre-treat, dip, quench, inspect and issue the coating report per batch.

Design review under ASTM A385

Vent and drain holes at 25–30% of cross-sectional area, overlaps, weld sequence. Reviewed before steel is cut, at no charge.

Coating verification

Calibrated DFT readings as standard; stripping to IS 6745 and the copper sulphate dip to IS 2633 on request.

Zinc purity

Verified in-house on our Bruker Q2 ION spectrometer — it reads the zinc in the kettle, not just the incoming steel.

THE WORKS, AND THE LIMITS

Made at Jangalpur, Howrah

Every item on this datasheet is produced in-house at our integrated complex on NH-6 — cutting, fabrication, welding, pre-treatment, hot-dip galvanizing and final inspection. There is no sub-contractor in the chain.

18,000 MT

A YEAR, FAB & GALV EACH

7.0 × 1.2 × 1.6 m

KETTLE, AT 450 °C

1,500 MT

FABRICATION PER MONTH

5 MT

MAX SINGLE PIECE · CRANES TO 20 T

1,500 MT

GALVANIZING PER MONTH

22 km

TO KOLKATA PORT

TYPICAL APPLICATIONS

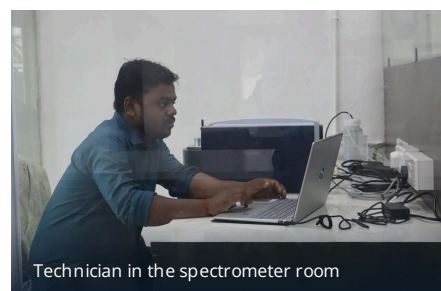
- Structural steel job work
- Line hardware and fittings
- Earthing material
- Fasteners and small parts
- Fabricated assemblies
- Re-galvanizing to specification

STANDARDS AND COMPLIANCE

Structural steel IS 2062, IS 8500 · **Galvanizing** IS 2629, IS 4759, IS 6745, IS 2633; ASTM A123, ASTM A153, ASTM A385 or EN ISO 1461 where specified · **Wind loading** IS 875 Part 3 · **Towers** IS 802 · **Line hardware** IS 2486 · **Fasteners** IS 1367 · **Earthing** IS 3043 · **Welding** IS 816, AWS D1.1; weld inspection IS 822 · **Tolerances** IS 7215. ISO 9001:2015, ISO 14001:2015 and ISO 45001:2018 certified; RDSO approved for railway structures; IEC 0211004090.

Three things we say before you ask

- Nothing longer than 7.0 m goes in the kettle in one dip.** Longer members are double-dipped — standard practice, but it leaves a visible overlap line, and we raise it before quoting rather than after dipping.
- Our laboratory is not NABL-accredited.** The equipment is real — Bruker Q2 ION spectrometer, universal testing machine, Rockwell tester, calibrated DFT gauges — but where a specification requires NABL type-test reports, that testing is arranged with an accredited laboratory against the order.
- We do not hold EN 1090.** It is a real certification with a real audit. IS 4759, ASTM A123 and EN ISO 1461 are different: they are specifications material is supplied and certified against, and we galvanize to them and issue the readings.



HOW TO ORDER

Send drawings, a bill of materials or a specification through [indoeast.com](mailto:info@indoeast.com). We review the scope, raise any queries and return a formal quotation, typically within 48 business hours. Third-party inspection by SGS, Bureau Veritas, TÜV, DNV or Intertek is supported at stages agreed before production. For export, the form at indoeast.com/export-enquiry.html asks for the five things that let us price properly.

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