

Title (en)  
PHOSPHATING PROCESS FOR COMPOSITE METALS

Publication  
**EP 0127204 B1 19880113 (DE)**

Application  
**EP 84200398 A 19840320**

Priority  
DE 3315086 A 19830426

Abstract (en)  
[origin: ES8501450A1] In a process for phosphating composite metals containing steel and zinc surfaces using phosphating solutions based on zinc phosphate by the dipping process, in order to achieve satisfactory formation of the phosphate layer, the composite metals are subjected to preliminary dipping for a maximum of 30 seconds in a phosphating solution based on zinc phosphate in order to initiate the formation of the phosphate layer, and are then conveyed to the main dip-phosphating zone. It is advantageous to spray the composite metals with a phosphating solution based on zinc phosphate while they are being conveyed from the preliminary to the main dip-phosphating zone, and it is advisable to limit the duration of the conveying and thus of the spraying treatment to a maximum of 30 seconds.

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**C23C 22/73**

IPC 8 full level  
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**GB 2138844 A 19841031; GB 2138844 B 19860618; GB 8410726 D0 19840531**; AU 2728084 A 19841101; AU 566551 B2 19871022; BR 8401938 A 19841204; CA 1225310 A 19870811; DE 3315086 A1 19841031; DE 3468702 D1 19880218; EP 0127204 A1 19841205; EP 0127204 B1 19880113; ES 531203 A0 19841201; ES 8501450 A1 19841201; JP S59205482 A 19841121; NZ 207947 A 19870930; PT 78409 A 19840501; PT 78409 B 19860527; US 4559087 A 19851217; ZA 843104 B 19841128

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**GB 8410726 A 19840426**; AU 2728084 A 19840426; BR 8401938 A 19840425; CA 452666 A 19840424; DE 3315086 A 19830426; DE 3468702 T 19840320; EP 84200398 A 19840320; ES 531203 A 19840330; JP 8358684 A 19840425; NZ 20794784 A 19840426; PT 7840984 A 19840411; US 60058784 A 19840417; ZA 843104 A 19840426