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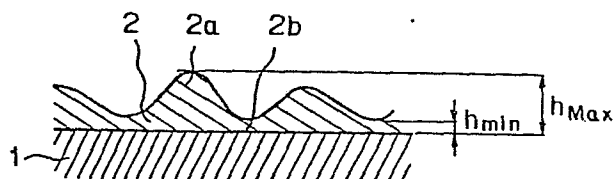
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Process for producing a multilayer-coated strip having excellent corrosion resistance and weldability and useful for containers.

A multilayer-coated steel strip having an excellent corrosion resistance and weldability and useful for cans and containers is produced by a process in which a steel strip substrate is plated with nickel or a nickel-based alloy to form nickel based coating layers each having an average amount of 2 to 10 mg/m², provided with a number of convex and concave portions thereof, portions of which layers having a coating thickness of 0.001 μ m or more have a total area corresponding to 10 to 90% of the entire area of the surfaces of the substrate; the nickel based plated substrate is coated with tin to form tin coating layers on the nickel-based coating layers, each of which tin coating layers has an average amount of 200 to 2000 mg/m²; the resultant precursory coated steel strip is heated at a temperature equal to or higher than the melting point of tin to convert the nickel-based coating layers and the tin coating layers to base coating layers consisting essentially of an Fe-Ni-Sn-based alloy and having a number of convex and concave portions thereof, and intermediate coating layers formed on the base coating layers, consisting essentially of tin and having a number of convex and concave portions thereof; and then an electrolytic chromate treatment is applied onto the intermediate tin coating layers to form surface coating layers consisting of electrolysed chromate.

Fig. 1





DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.4)
Y	EP-A-0 063 933 (NIPPON STEEL CORP.) * Claims 1-5; page 26, lines 8-16 * ---	1,6	C 25 D 5/12 C 25 D 11/38
Y	FR-A-2 478 680 (TOYO KOHAN CO. LTD) * Claims 1,2,5 * ---	1,6	
A	FR-A-2 483 470 (NIPPON STEEL CORP.) * Claims 1,6,7 * ---	1,6	
A	EP-A-0 164 092 (KAWASAKI STEEL CORP.) * Claims 1-2 * ---	1,6	
A	EP-A-0 055 481 (NIPPON STEEL CORP.) ---		
A	US-A-4 601 957 (F. FUJIMOTO et al.) -----		
			TECHNICAL FIELDS SEARCHED (Int. Cl.4)
			C 25 D
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 08-06-1989	Examiner DE ANNA P.L.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	