

GABIONS GALMAC® COATED

Gabions are baskets made of 8x10 double twisted steel woven wire mesh, as per EN 10223-3:2013 (Figs. 1, 2). Gabions are filled with stones at the project site to form flexible, permeable, monolithic structures such as retaining walls, channel linings, and weirs for erosion control projects. The standard specifications of mesh-wire are shown in Table 2. The gabion is divided into cells by means of diaphragms positioned at approximately 1m centers (Fig.1). In order to reinforce the structure, all mesh panel edges are selvaged with a wire having a greater diameter (Table 3). Dimensions and sizes of gabions are shown in Table 1. The material is supplied from an ISO 9001 certified factory.

Steel wire mesh

The nominal tensile strength of the wire mesh shall be as per Table 2 (EN 10223-3:2013). The punch strength of the wire mesh shall be as per table 2 (UNI 11437.)

Wire

The steel wire used in the manufacture of the unit is galvanized with Galmac, a Zn-5%Al alloy. The standard specifications of wire are shown in Tables 3. All tests on wire must be performed prior to manufacturing the mesh.

1. **Tensile strength:** the wire used for the manufacture of gabions shall have a tensile strength between 350-550 N/mm² as per EN 10223-3:2013. Wire tolerances (Table 4) are in accordance with EN 10218 (Class T1).
2. **Elongation:** Elongation at fracture shall not be less than 8%, on a gauge length of 250 mm as per EN 10223-3: 2013.
3. **Galmac coating:** minimum quantities of Galmac (Table 4) meet the requirements of EN 10244-2 (Table 2 - Class A).
4. **Adhesion of Galmac:** the adhesion of the Galmac coating to the wire shall be such that, when the wire is wrapped six turns around a mandrel having four times the diameter of the wire, it does not flake or crack when rubbing it with the bare fingers, according to EN 10244.
5. **Outwearing accelerated aging test:** when subjected to test in sulphur dioxide environment (EN ISO 6988) after 28 cycles of discontinuous test the mesh shall not show more than 5% of DBR (Dark Brown Rust).

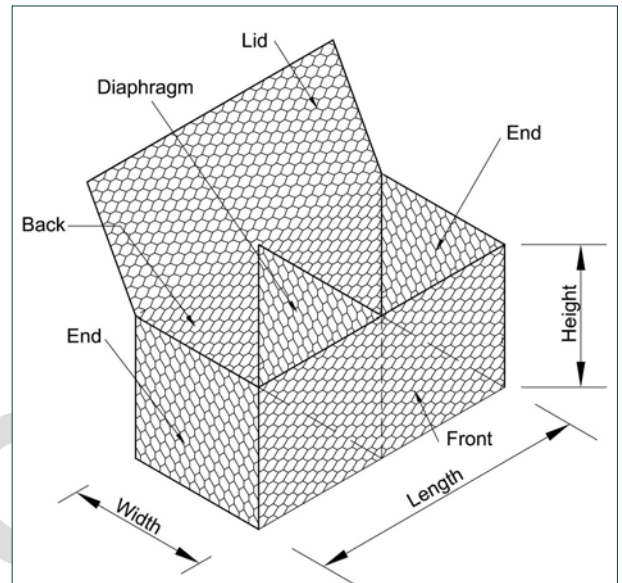
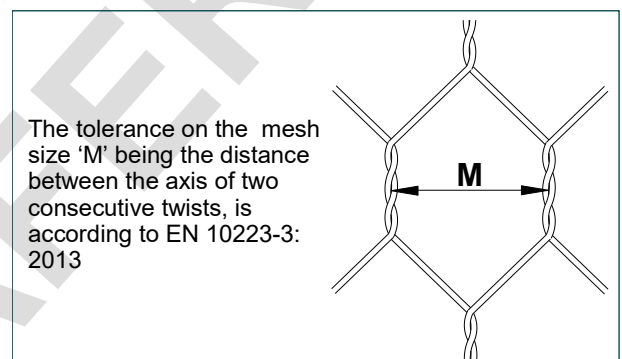


Figure 1



The tolerance on the mesh size 'M' being the distance between the axis of two consecutive twists, is according to EN 10223-3: 2013

Figure 2

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Table 1: Sizes of gabions

Length (m)	Width (m)	Height (m)	# of cells
2	1	0.5	2
3	1	0.5	3
4	1	0.5	4
1.5	1	1	1
2	1	1	2
3	1	1	3
4	1	1	4

All sizes and dimensions are nominal.
Tolerances of $\pm 5\%$ of the width, height and length of the gabions shall be permitted (EN 10223-3:2013).

Quantity Request

When requesting a quotation, please specify:

- size of units (length x width x height, see Table 1)
- type of mesh
- type of coating and diaphragms

EXAMPLE: No. 100 gabions 2x1x1m - Mesh type 8x10 - Wire diam. 2.70 mm - GalMac® - with diaphragms.

Lacing Operations

Lacing operations can be made by using the tools shown in Fig.5. Stainless steel rings having the following specification can be used instead of lacing wire (Figs. 3, 4):

- diameter: 3.00 mm
- tensile strength: >1700 - 1900N

Spacing of the rings must not exceed 200 mm (Fig.3)

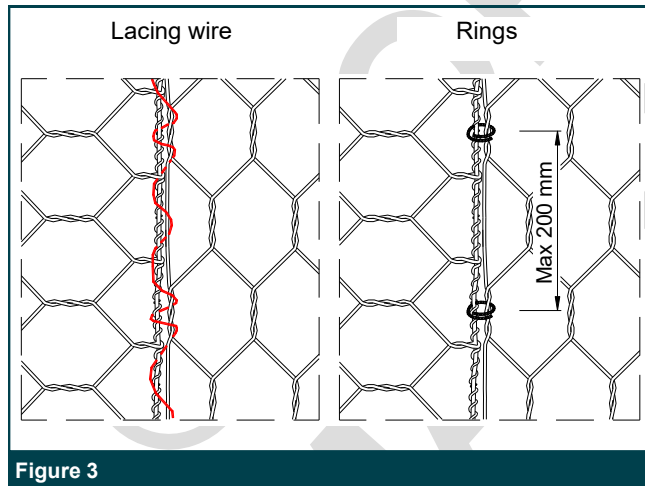


Figure 3

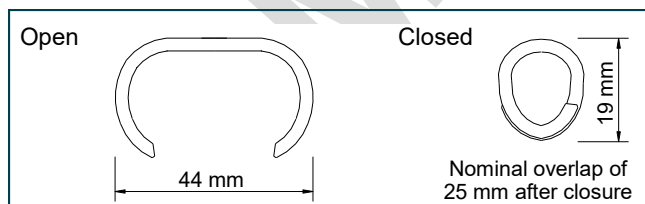


Figure 4

Table 2: Standard Mesh-Wire

Type	M (mm)	Tolerance (mm)	Wire Diameter (mm)	Mesh Tensile Strength (kN/m)	Punch Strength (kN)
8x10	80	-0/+10	2.7	50	67
8x10	80	-0/+10	3.0	60	82

Table 3: Standard wire diameters

	Mesh Wire	Selvage Wire	Lacing Wire
8x10 Mesh Type	\varnothing mm	2.7/3.7	3.4/4.4
8x10 Mesh Type	\varnothing mm	3.0	3.9

Table 4: Wire tolerances and coatings

Wire diameter	mm	2.20	2.70	3.00	3.40	3.90
Wire diameter tolerance (\pm)	mm	0.06	0.06	0.07	0.07	0.07
Min. Galmac quantity	g/m ²	230	245	255	265	275

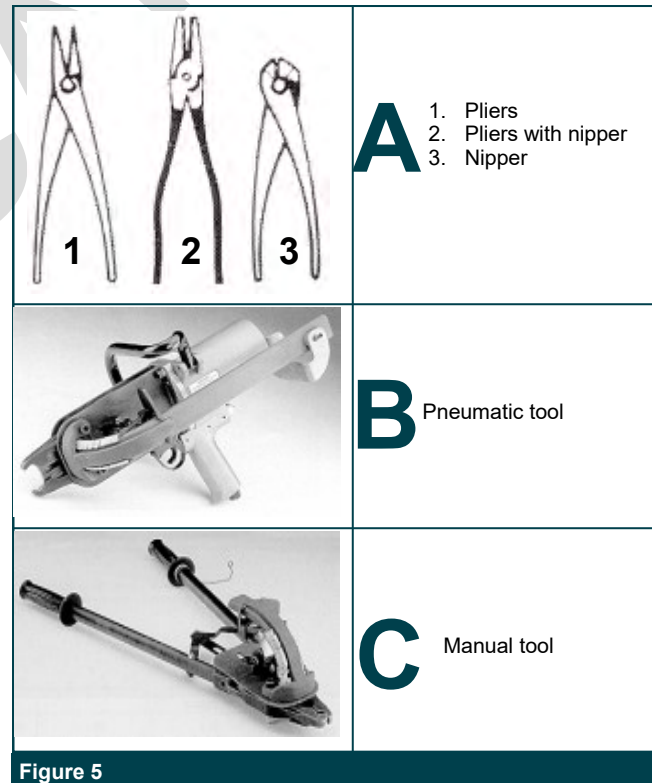


Figure 5

Maccaferri Asia Regional HQ

Unit 3A-11, Block G, Phelio Damansara 1, Petaling Jaya, Selangor, 46350, Malaysia
T: +(60-3) 7957 8330 F: +(60-3) 7957 9080
E: info@asia.maccaferri.com www.maccaferri.com/asia/

Bureau Veritas Certified Quality System Company with Accredia's and UKAS' s accreditation.