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## Welded Gabion Specification

*Wire*  
*Coating of Wire*  
*(PVC, and Galvanized)*  
*Wire Shear Strength*  
*Gabion Sizes(Nominal)*

*\* Custom sizes available on request*

Kaap Wire Mesh Gabion baskets and panels produced from pre-galvanised wire welded mesh, pre-galfan (Zn+5%Al) wire welded mesh, and HDPE and PVC on heavily galvanised or galfan coated wire welded mesh. The Permathene gabion welded mesh shall meet ASTM 974-97 for Welded Mesh Gabions.

**Wire:**

- **Tensile Strength:** The steel wire used to manufacture of gabions and the spirals shall have a tensile strength between 350-750N/mm<sup>2</sup>.
- **Elongation:** Shall not be less than 10%. Tests must be carried out on a sample of at least 25cm long
- **Wire Tolerance:** +-3%

**Coating of wire:**

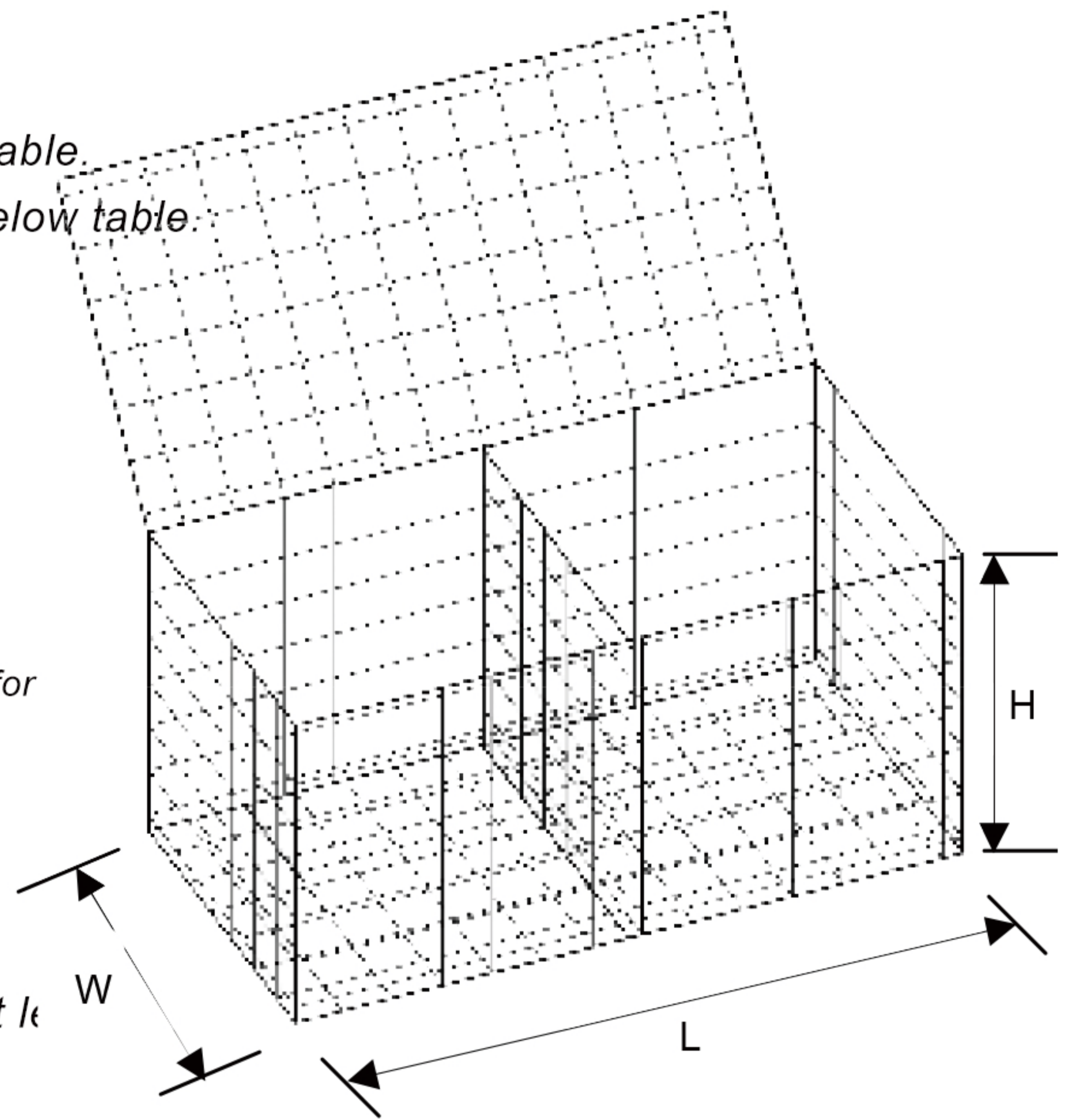
- **Hot-dip Galvanised** coated to BS443/EN10244-2:2001, see below table.
- **Galfan (Zn95%+ALU5%)** coated to BS443/EN10244-2:2001, see below table.

Minimum weight of coating (g/m <sup>2</sup> )			
Diameter(mm)	3	4	5
Galvanised wire	255	275	280
Galfan Wire	255	275	280

4mm wire is standard for Permathene welded mesh, the other sizes are available for custom jobs.

**Wire Shear Strength:**

- **Depth of weld pot** not less than 15% of wire ID.
- **Weld shear strength** should reach to 50% of wire tensile strength at  $k$



**Joining:**

Spirals and stiffeners are 3.4mm galvanised or galfan wire.

Gabion Size (m)	2x1x1	1x1x1	2x0.5x1(ht)	2x1x0.5(ht)	2x0.5x0.5	1x0.5x0.5	2x0.3x0.5	1x0.3x0.5	0.5x0.5x0.5	1x0.3x0.75	1x0.3x1	2x0.3x1	1x0.5x1	2x0.3x0.75	1.5x0.5x0.5	1.5x1x0.5	2x0.75x0.75
panel 2x1	4		2	2								2					
panel 1x1	2	6									2		2				
panel 2x0.75														2			4
panel 2x0.5			2	2	4		2					2					
panel 2x0.3							2					2		2			
panel 1x0.5			3	3		4		2					4			2	
panel 1x0.3								2		2	4	3					
panel 0.5x0.5					3	2			6						2		
1x0.75										2							
0.3x0.75										2				3			
panel 0.3x0.5							3	2									
1.5x1																2	
1.5x0.5															4	2	
panel 0.75x0.75																	2
diaphragm 1x1	1																
Stiffeners 0.5	16	8	2	16	2	1			2				4		3	8	8
Stiffeners 0.3			16		16	8	8	8			4	8		8			
Spirals 2m	4		4	4	4		4					4		2			4
Spirals 1m	12	12	6	6		4		4		2	8	6	8			4	
Spirals 0.75m										2				6			12
Spirals 1.5															4	4	
Spirals 0.5m			6	6	12	8	6	4	16						8	4	
Spirals 0.3m							6	4		2	4	6	4	6			

HDPE coated welded gabions are also available, please call us to enquiry.

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