



## Sheet Steel Gauges and Thicknesses

Within the construction industry there is often confusion over gauges, gauge numbers and the actual thickness. The industry has been trying to move away from gauge numbers, without complete success. The following information will show why sheet steel products should be specified to the decimal thickness.

### Manufacturers' Standard Gauge For Steel Sheets

The most common gauge system used in Canada for structural sheet steel products is the Manufacturers' Standard Gauge (MSG). The MSG for steel sheets was developed having a DEFINITE THICKNESS equivalent for each gauge number. In the standard gauge system the density of steel is taken as 489.6 lbs/ft<sup>3</sup>, or 40.80 lbs/ft<sup>2</sup>/in. However, since sheet weights are calculated on the basis of specified width and length, with all shearing on the over side, and also since sheets are somewhat thicker at the centre than they are at the edges, a further adjustment was made to obtain a closer approximation for inter-changeability between weight and thickness. Over a long period of time this value for sheets has been found to be close to 2.5 per cent heavier than 40.80 lb/ft<sup>2</sup>/in. A figure of 41.820 lb/ft<sup>2</sup>/in is the one commonly used to express the relationship between weight and thickness for steel sheet.

### The Galvanized Sheet Gauge

The Galvanized Sheet Gauge is an older system used primarily by the trades consuming non-structural galvanized steel and is a measure of the zinc coated sheet thickness. It was developed in the early days of galvanizing before sophisticated wipers were available and, consequently, zinc thicknesses were thicker than today. The GSG system was used on some of the older gauge charts published years ago that unfortunately still seem to get used even today.

### Thickness Definitions

There are a number of terms used for sheet steel products that need to be explained because they will affect the thickness of product that could be delivered to the job site.

**Nominal Thickness:** When sheet steel is produced by the steel companies it is manufactured to a target or "nominal" thickness. As with all manufacturing processes, variations in the final thickness of the sheet are unavoidable. However, the thickness is controlled very tightly to ensure that it does not fall below the minimum thickness (as described below).

**Base Steel Thickness:** The thickness of the sheet steel material without any coatings.

**Coated Thickness:** The thickness of the steel sheet including any metallic coatings (i.e. zinc or 55% aluminum-zinc alloy) and paint coatings.

**Design Thickness:** The design thickness is the thickness of the base steel only, and is used by the engineer to determine the structural properties of the cold formed product. This is the thickness that a manufacturer will list in their product catalogues and load tables, where it could also be called the nominal base steel thickness.

**Minimum Thickness:** The minimum thickness of structural sheet steel building products delivered to the job site will be the design thickness minus the maximum allowable under-tolerance specified by the CSA-S136-2001 Standard or the material specification, whichever is the more restrictive. The minimum thickness allowed by the CSA-S136-2001 Standard is 95% of the design thickness.

### Gauge Number And Decimal Thickness

Table 1 shows the relationship between the MSG numbers, the nominal or design thickness, and the minimum thickness based on the CSA-S136-2001 Standard.

Gauge Number	Minimum Base Steel Thickness (95% of Design Thickness)		Design Thickness (Nominal Base Steel Thickness)	
	inches	mm	inches	mm
8	0.1562	3.967	0.1644	4.176
10	0.1278	3.245	0.1345	3.416
12	0.0994	2.524	0.1046	2.657
13	0.0852	2.164	0.0897	2.278
14	0.0710	1.802	0.0747	1.897
15	0.0639	1.624	0.0673	1.709
16	0.0568	1.443	0.0598	1.519
18	0.0454	1.153	0.0478	1.214
20	0.0341	0.866	0.0359	0.912
22	0.0284	0.721	0.0299	0.759
24	0.0227	0.577	0.0239	0.607
26	0.0170	0.432	0.0179	0.455
28	0.0142	0.359	0.0149	0.378
29	0.0128	0.326	0.0135	0.343
30	0.0114	0.290	0.0120	0.305

## Minimum Thickness Allowance for Coatings

Sheet steel products are normally coated with a metallic coating (i.e. zinc or 55% aluminum-zinc alloy), and also may be painted. The minimum thicknesses of typical hot-dipped metallic coatings are given in Table 2. The metallic coating thickness must be added to the minimum base sheet thickness when determining the delivered sheet thickness. Metallic coatings are also subject to manufacturing tolerances the same as the base steel. Therefore, the actual thickness of the metallic coating will generally be greater than the minimums listed in Table 2. This factor needs to be considered when attempting to verify the base steel thickness of a coated product.

**Table 2 - Minimum Metallic Coating Thicknesses**

Coating Designation	Minimum Thickness (inches)	Coating Designation	Minimum Thickness (mm)
A01	0.0004	ZF001	0.010
A25	0.0007	ZF075	0.018
G01	0.0004	Z001	0.010
G60	0.0010	Z180	0.025
G90	0.0015	Z275	0.038
AZ50	0.0016	AZM150	0.041
AZ55	0.0018	AZM165	0.046
AZ60	0.0020	AZM180	0.051

A significant amount of sheet steel is also prefinished with a paint system on top of the metallic coating. The thickness of these paint/primer layers must also be included when measuring the thickness of the sheet. The thicknesses of typical paint coatings vary from 0.0003 to 0.001 in. (0.008 to 0.025 mm) per side. Some thick film paint systems (e.g. Barrier Series) have thicknesses of 0.004 to 0.012 in. (0.100 to 0.300 mm). Listed in Table 3 are the thicknesses of common prefinished paint systems used in Canada.

**Table 3 - Thicknesses of Prefinished Paint Systems**

Paint System	Nominal Thickness <sup>(1)</sup>	
	inches	mm
8000+ Series, HMP	0.001	0.025
10000 Series	0.001	0.025
Elite and Metallic Series	0.002	0.051
Barrier Series - 4 mil	0.004	0.100
Barrier Series - 8 mil	0.008	0.200
Barrier Series - 12 mil	0.012	0.300
Washcoat	0.0003	0.008

(1) The paint thicknesses listed are per coated side.

## Minimum Thickness for Common Prefinished Material

Table 4 shows the minimum thickness for a galvanized sheet with a common paint system.

**Table 4 - Minimum Thickness for Prefinished<sup>(1)</sup> Sheet**

Gauge Number	Minimum Base Steel Thickness (95% of Design Thickness)		Minimum Coated Steel Thickness	
	inches	mm	inches	mm
	20	0.0341	0.866	0.0369
22	0.0284	0.721	0.0312	0.794
24	0.0227	0.577	0.0255	0.650
26	0.0170	0.432	0.0198	0.505
28	0.0142	0.359	0.0170	0.432
29	0.0128	0.326	0.0156	0.399
30	0.0114	0.290	0.0142	0.363

(1) The sheet has a G90 (Z275) zinc coating (0.0015 in./0.040 mm), an 8000+ Series paint coating on the finish side (0.001 in./0.025 mm) and a wash coat on the reverse side (0.0003 in./0.008 mm).

## Additional Gauge Equivalents for Steel Studs

The steel stud industry in Canada has in regular use additional gauge number equivalents that are different than shown in Table 1. Starting in June 2004, Canada will join the United States and adopt a common set of standard base steel thicknesses for lightweight steel framing components (e.g. studs and joists). These gauges are unique to this industry and are shown in Table 5. The CSA-S136-2001 maximum under-tolerance also applies to these gauges as well as does the metallic coating allowances listed in Table 2.

**Table 5 - Standard Thicknesses for Lightweight Steel Framing Components**

Designation Thickness (mils) <sup>(2)</sup>	Minimum Base Steel Thickness <sup>(1)</sup>		Design Thickness		Steel Framing Gauge No. (for reference only)
	(in.)	(mm)	(in.)	(mm)	
18	0.0179	0.455	0.0188	0.478	25
30	0.0296	0.752	0.0312	0.792	20 - Drywall
33	0.0329	0.836	0.0346	0.879	20 - Structural
43	0.0428	1.087	0.0451	1.146	18
54	0.0538	1.367	0.0566	1.438	16
68	0.0677	1.720	0.0713	1.811	14
97	0.0966	2.454	0.1017	2.583	12
118	0.1180	2.997	0.1242	3.155	10

(1) Minimum thickness represents 95% of the design thickness. Metric (mm) minimum thicknesses were calculated by converting the Imperial (in.) values.

(2) A "mil" is 1/1000 of an inch (e.g. 30 mils is 0.030 inches).

## Conclusion

An important thing to remember about gauge numbers is that they do not refer to only one thickness but instead represent a range of thicknesses within the allowable tolerances, or to different thicknesses for different products. Gauge numbers are not regulated and are generally used for convenience in sales literature. **Decimal thickness is required for structural design and material ordering.** The steel industry encourages everyone to use decimal thicknesses in specifying sheet steel products and avoid the potential problems inherent with gauges.

## For More Information

For more information on sheet steel building products, or to order any CSSBI publications, contact the CSSBI at the address shown below or visit the web site at [www.cssbi.ca](http://www.cssbi.ca)