

DESCRIPTION

COATED STEEL SHEET

Technical Field

[0001] The present invention relates to a coated steel sheet.

Background Art

[0002] In recent years, a coated steel sheet is used as an automobile structural member from the viewpoint of rust prevention, and an alloyed hot-dip zinc-coated steel sheet is mainly applied in the Japanese market. The alloyed hot-dip zinc-coated steel sheet is a coated steel sheet for which firstly hot-dip zinc-coating is performed on a steel sheet and then an alloying heat treatment is performed thereon such that the weldability and corrosion resistance after painting are improved by means of diffusion of Fe from the steel sheet (substrate steel sheet) in the coating layer. For example, a coated steel sheet described in Patent Literature 1 is representatively used as a coated steel sheet for automobiles in Japan.

[0003] Usually, a coated steel sheet for automobile is used in a state formed into a complex shape from a sheet form, therefore it is in many cases subjected to press forming. In the case of an alloyed hot-dip zinc-coated steel sheet, the coating layer becomes hard due to diffusion of Fe from the substrate steel sheet. Therefore, the coating layer is easily detached, and there is a unique problem such as powdering or flaking that is not experienced in a hot-dip zinc-coated steel sheet having a soft coating layer.

[0004] Further, in the case of a coated steel sheet provided with a hard coating layer, the coating layer is prone to be damaged by an external pressure, and once a crack is generated, the crack propagates to an interface between the coating layer and the steel substrate (steel sheet). And it is regarded as a problem that the coating layer is prone to be detached from the interface with the steel substrate (steel sheet) as a starting point to cause falling.

For example, when an alloyed hot-dip zinc-coated steel sheet is used for an automobile outer panel, the steel substrate (steel sheet) tends to be exposed due to simultaneous detachment of a paint and a coating layer by an impingement of a stone (chipping) kicked up by a traveling vehicle. Therefore, its corrosion advances faster than a coated steel sheet provided with a soft coating layer which is not alloyed. For this reason, in a case of use for an extended time period, erosion due to corrosion of the steel substrate starts, so especially when it is used as an underbody member, it is feared that the collision safety performance is deteriorated.

Furthermore, since the alloyed hot-dip zinc-coated steel sheet contains Fe in the

coating layer, if such chipping occurs, reddish-brown rust is readily generated due to corrosion of the coating layer, which causes a problem also on the appearance of an automobile.

[0005] As a solution to these problems, it is effective to apply a coated steel sheet with a coating layer having a favorable toughness and not containing Fe. For example, as an automobile coated steel sheet with a coating layer not containing Fe, a hot-dip zinc-coating steel sheet is mainly used in North America, Europe, *etc.* In this regard, a hot-dip zinc-coating steel sheet which has not undergone an alloying treatment is resistant to chipping. In addition, since Fe is not contained in the coating layer in contrast to an alloyed hot-dip zinc-coated steel sheet, red rust in the initial stage of corrosion is also less likely to appear. However, when it is painted, the coating layer is easily corroded under the paint film to raise the paint film (blistering). Therefore, a hot-dip zinc-coating steel sheet is by no means suitable for an automobile coated steel sheet, because the steel substrate also starts to be eroded when it is used for a long time period.

[0006] As a method of enhancing the corrosion resistance of a hot-dip Zn coating, there is, for example, a method of adding Al in the Zn coating layer, and in the building materials field, as disclosed in Patent Literature 2, as a high corrosion resistance coated steel sheet, a hot-dip Al-Zn coated steel sheet is widely put to practical use. The coating layer of such a hot-dip Al-Zn coated steel sheet is constituted with a dendrite-like α -Al phase (dendritic structure) crystallized first from the molten state, and a structure consisting of a Zn phase and an Al phase formed in the interstices of the dendritic structures (interdendritic structure). The dendritic structure is passivated, and the interdendritic structure has a higher Zn concentration than the dendritic structure. Therefore, corrosion concentrates on the interdendritic structure.

As a result, corrosion propagates through the interdendritic structure in a moth-eaten pattern, and corrosion propagation paths become complicated, which makes it difficult for the corrosion to reach the steel substrate (steel sheet).

For this reason, when a hot-dip Al-Zn coated steel sheet is used as a not-painted bare material, its corrosion resistance is superior to a hot-dip zinc-coated steel sheet having the same thickness of the coating layer.

[0007] When such a hot-dip Al-Zn coated steel sheet is used as an automobile outer panel, it is common that the coated steel sheet is supplied to an automobile manufacturer, *etc.* in a state having been already coated in a continuous hot-dip metal coating facility, processed into a panel part shape there, and thereafter the integral painting for an automobile including chemical conversion, electropainting, intermediate painting, and top coat painting is

conducted.

[0008] It has been also studied to add Mg to a Zn-Al coating layer for the purpose of improving the corrosion resistance. For example, Patent Literature 3 discloses a hot-dip Zn-Al-Mg coated steel sheet in which the corrosion resistance is improved by forming a Zn/Al/MgZn₂ ternary eutectic structure containing a Mg compound such as MgZn₂ in a coating layer. It is considered that the inclusion of Mg improves the sacrificial corrosion protection property of the coating layer to improve the anticorrosion effect of the steel substrate.

[0009] Patent Literature 4 discloses a hot-dip Al-Zn coated steel sheet in which the corrosion resistance after painting is improved by breaking down a passive state of the dendritic structure by inclusion of Sn or In.

[0010] Further, Patent Literature 5 and Patent Literature 6 describe a hot-dip Al-Zn alloy coated steel sheet which contains Mg and Sn in combination. In Patent Literature 5 and 6, it is described that the hot-dip Al-Zn alloy coated steel sheet is superior in corrosion resistance after painting and/or workability.

[0011] Patent Literature 1: Japanese Patent Application Laid-Open (JP-A) No. 2003-253416

Patent Literature 2: Japanese Patent Publication (JP-B) No. S46-7161

Patent Literature 3: JP-A No. 2001-329383

Patent Literature 4: Japan International Publication No. WO2014/155944

Patent Literature 5: JP-A No. 2015-214747

Patent Literature 6: JP-A No. 2002-180225

SUMMARY OF INVENTION

Technical Problem

[0012] However, when the outer panel using the hot-dip Al-Zn coated steel sheet described in Patent Literature 2 is damaged at the paint film and the coating layer (when the steel substrate is exposed), the exposed steel substrate acts as a cathode, and preferential dissolution of Zn (selective corrosion of the interdendritic structure) occurs at the interface between the paint film and the coating layer due to a unique phase structure of the coating layer consisting of the above described two structures of dendritic structure and interdendritic structure. This propagates deep into the sound area of the painting to cause a large paint film blister. As a result, there arises a well-known problem that the erosion of the steel substrate cannot be suppressed.

Further, the interdendritic structure has lower hardness than the dendritic structure. Therefore, due to the difference in the hardness between the interdendritic structure and the

dendritic structure, deformation is concentrated in the interdendritic structure during press working. As a result, it is known that a crack is developed in the coating layer to reach the steel substrate. Since corrosion is promoted in the vicinity of a crack where the steel substrate is exposed, in the case of the conventional hot-dip Al-Zn coated steel sheet, not only paint film blistering occurs, but also the erosion of the steel substrate cannot be suppressed.

[0013] Further, a MgZn_2 phase included in the coating layer of the hot-dip Zn-Al-Mg coated steel sheet described in Patent Literature 3 is brittle. Therefore, when the coated steel sheet is subjected to processing, there is a risk that a large number of cracks may be generated starting from the Zn/Al/ MgZn_2 ternary eutectic structure. Since the steel substrate is exposed when cracks are generated, there has been also a problem that the erosion of the steel substrate cannot be sufficiently suppressed near the processed area.

[0014] In the case of the hot-dip Al-Zn coated steel sheet described in Patent Literature 4, Mg is not contained in the coating layer, and any attempt to reduce the corrosion rate of the coating layer itself has not been made. Therefore, it is conceivable that the sacrificial corrosion protection property is not satisfactory as an automobile coated steel sheet, from the viewpoint of suppressing the erosion of the steel substrate for a long time period.

[0015] Further, with respect to the hot-dip Al-Zn alloy coated steel sheet described in Patent Literature 5 and 6, control of the coating structure has not been sufficiently studied, and therefore it is presumed that MgZn_2 is formed as a brittle Mg-containing intermetallic compound in the coating layer.

In this case, it is surmised that the resulting hot-dip Al-Zn alloy coated steel sheet is inferior in workability, and further that the sacrificial corrosion protection property is not sufficient, and a crack is formed in the coating layer at the time of pressing. Therefore, it is predicted that corrosion propagates in the processed area starting from the crack.

It is considered that these hot-dip Al-Zn alloy coated steel sheets do not have workability or sacrificial corrosion protection property satisfactory as a coated steel sheet for an automobile, from the viewpoint of suppressing the erosion of the steel substrate for a long time period.

[0016] That is, a hot-dip Zn coated steel sheet that is superior in both corrosion resistance after painting and sacrificial corrosion protection property has heretofore not been developed, and in particular a coated steel sheet suitable for automotive applications has not been in existence.

[0017] An object of an aspect of the present disclosure is to provide a coated steel sheet excellent in any of corrosion resistance after painting, sacrificial corrosion protection property, and workability.

Solution to Problem

[0018] The method of attaining the object includes the following aspect.

[0019] <1> A coated steel sheet including a steel sheet and a coating layer provided on at least a part of a surface of the steel sheet, wherein:

the coating layer has a chemical composition including in terms of % by mass:

Al: from 15% to 60%

Mg: from 0.5% to 8.0%

Sn: from 0.5% to 20.0%

Si: from 0.05% to 1.50%

Bi: from 0% to 5.0%,

In: from 0% to 2.0%,

Ca: from 0% to 3.0%,

Y: from 0% to 0.5%,

La: from 0% to 0.5%,

Ce: from 0% to 0.5%,

Cr: from 0% to 0.25%,

Ti: from 0% to 0.25%,

Ni: from 0% to 0.25%,

Co: from 0% to 0.25%,

V: from 0% to 0.25%,

Nb: from 0% to 0.25%,

Cu: from 0% to 0.25%,

Mn: from 0% to 0.25%,

Sr: from 0% to 0.5%,

Sb: from 0% to 0.5%,

Pb: from 0% to 0.5%,

B: from 0% to 0.5%, and

a balance consisting of Zn and impurities, wherein:

the coating layer has a laminar Mg_2Sn phase-containing structure in an area fraction of from 5 to 65%, and a structure containing a solid solution of Zn and Al, and

the laminar Mg_2Sn phase-containing structure is a structure constituted with a Zn phase and a laminar Mg_2Sn phase having a thickness of less than 1 μm , and wherein the laminar Mg_2Sn phase exists dividing the Zn phase into a plurality of regions.

<2> The coated steel sheet according to <1> above, wherein a content of Mg is from 0.5% to 3.0%, and a content of Sn is from 1.0% to 7.5% in terms of % by mass.

<3> The coated steel sheet according to <1> or <2> above, wherein a content of Al is from 20% to 60%, a content of Mg is from 1.0% to 2.0%, a content of Sn is from 1.0% to 5.0%, and a content of Si is from 0.05% to 1.0% in terms of % by mass.

<4> The coated steel sheet according to any one of <1> to <3> above, wherein the content of Sn and the content of Mg satisfy the following Formula (1):

$$\text{Mg} \leq \text{Sn} \leq 2.5 \times \text{Mg} \quad \text{Formula (1)}$$

wherein, in Formula (1), each atomic symbol indicates a content of the element in terms of % by mass.

<5> The coated steel sheet according to any one of <1> to <4> above, wherein the area fraction of the laminar Mg_2Sn phase-containing structure is from 20% to 60%.

<6> The coated steel sheet according to any one of <1> to <5> above, wherein the area fraction of the laminar Mg_2Sn phase-containing structure is from 30% to 60%.

<7> The coated steel sheet according to any one of <1> to <6> above, wherein an area fraction of the structure containing a solid solution of Zn and Al is from 35% to 95%.

<8> The coated steel sheet according to any one of <1> to <7> above, wherein the coating layer has a massive MgZn_2 phase with an equivalent circle diameter of 1 μm or more in an area fraction of from 0% to 20%.

<9> The coated steel sheet according to any one of <1> to <8> above, wherein the coating layer has a massive MgZn_2 phase with an equivalent circle diameter of 1 μm or more in an area fraction of from 0% to 5%.

<10> The coated steel sheet according to any one of <1> to <9> above, wherein the coating layer has a massive Zn phase with an equivalent circle diameter of 2 μm or more in an area fraction of from 0% to 20%.

<11> The coated steel sheet according to any one of <1> to <10> above, wherein the coating layer has a massive Zn phase with an equivalent circle diameter of 2 μm or more in an area fraction of from 0% to 10%.

<12> The coated steel sheet according to any one of <1> to <11> above further including an interfacial alloy layer with a thickness of from 100 nm to 1.5 μm consisting of an Al-Fe intermetallic compound between the steel sheet and the coating layer.

Advantageous Effects of Invention

[0020] In an aspect of the present disclosure, a coated steel sheet excellent in any of corrosion resistance after painting, sacrificial corrosion protection property, and workability can be provided.

BRIEF DESCRIPTION OF DRAWINGS

[0021] [FIG. 1] FIG. 1 is a backscattered electron image (BSE image) taken with an SEM at a magnification of 2000x on an example of the coating layer of the coated steel sheet according to the present disclosure (No. 26 of Example).

[FIG. 2] FIG. 2 is a backscattered electron image (BSE image) taken with an SEM at a magnification of 6000x of the region A in FIG. 1.

[FIG. 3] FIG. 3 is a backscattered electron image (BSE image) taken with an SEM at a magnification of 2000x on the coating layer of the coated steel sheet of No. 24 of Example.

[Fig. 4] FIG. 4 is a backscattered electron image (BSE image) taken with an SEM at a magnification of 2000x on the coating layer of the coated steel sheet of No. 29 of Example.

[FIG. 5] FIG. 5 is a backscattered electron image (BSE image) with an SEM of a cross section of a coating layer for explaining a method of identifying a Zn/Al/MgZn₂ ternary eutectic structure and measuring the area fraction of the same.

DESCRIPTION OF EMBODIMENTS

[0022] An example of the present disclosure will be described below.

In the present disclosure, the indication of “%” with respect to the content of each element in a chemical composition means “% by mass”.

A numerical range expressed by "x to y" includes the values of x and y in the range as the minimum and maximum values, respectively.

In a case “less than” or “more than” is affixed to the above x or y, such x or y is not included in the range as the minimum or maximum value.

The content of an element of a chemical composition may be expressed as the amount of an element (for example, the amount of Zn, the amount of Mg, or the like), or the concentration of an element (for example, the concentration of Zn, the concentration of Mg, or the like).

The “planar part corrosion resistance” refers to the corrosion resistant property of the coating layer itself.

The “sacrificial corrosion protection property” refers to a property of suppressing the corrosion of an area where a steel substrate is exposed (for example, a cut end surface of a coated steel sheet, an area where cracking occurred during processing, or an area where a steel substrate was exposed by detachment of the coating layer).

The "equivalent circle diameter" is a diameter of a circle having the same area as the region defined by the outline of a phase, which is identified in a cross section of a coating layer (a cross section cut in the thickness direction of the coating layer).

“C direction” means the direction perpendicular to the rolling direction of a steel

sheet.

“L direction” means the direction parallel to the rolling direction of a steel sheet.

[0023] The coated steel sheet of the present disclosure includes a steel sheet and a coating layer provided on at least part of the surface of the steel sheet.

The coating layer has a predetermined chemical composition. In addition, the coating layer has a laminar Mg_2Sn phase-containing structure in an area fraction of from 5 to 65%, and a structure containing a solid solution of Zn and Al (hereinafter, for convenience, also referred to as “dendritic structure”).

The laminar Mg_2Sn phase-containing structure is a structure constituted with a Zn phase and a laminar Mg_2Sn phase having a thickness of less than 1 μm , wherein the laminar Mg_2Sn phase exists dividing the Zn phase into a plurality of regions.

[0024] The coated steel sheet of the present disclosure can be a coated steel sheet that is superior in any of corrosion resistance after painting, sacrificial corrosion protection property, and workability by virtue of the above constitution. The coated steel sheet of the present disclosure was invented based on the following findings.

[0025] The inventors investigated the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability of a coating layer suitable for a coated steel sheet for automotive applications, building materials applications, *etc.* As a result, the following findings were obtained.

Although the Mg-containing intermetallic compound constitutes a brittle phase, a Mg_2Sn phase has more favorable plastic deformability as compared to a $MgZn_2$ phase. By forming a structure in which the Mg_2Sn phase exists dividing the Zn phase into a plurality of laminar regions in a Zn phase having favorable plastic deformability, the laminar Mg_2Sn phase-containing structure as a whole expresses favorable plastic deformability, which contributes to improvement of the workability.

In addition, the Mg_2Sn phase serves as a supply source of Mg ions in a corrosive environment, and since Mg ions make the corrosion product to an insulating film, corrosion under the paint film in a painted state may be suppressed. Although the mechanism is not clear, in the case of a structure in which the laminar Mg_2Sn phase exists dividing the Zn phase into a plurality of regions, the corrosion propagates along the laminar Mg_2Sn phase, and as a result the laminar Mg_2Sn phase functions as a source of Mg ions for a long time period. The Mg_2Sn phase is electrically less noble as compared to the $MgZn_2$ phase, and is inherently superior in sacrificial corrosion protection property. Therefore, it is presumed that it has an improving effect of corrosion resistance after painting and sacrificial corrosion protection property.

[0026] Therefore, when a laminar Mg_2Sn phase-containing structure constituted with a Zn phase and a laminar Mg_2Sn phase having a thickness of less than 1 μm , in which the laminar Mg_2Sn phase exists dividing the Zn phase into a plurality of regions, is made to be present at a predetermined amount in terms of area fraction, the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability are all enhanced. Specifically, when the area fraction of the laminar Mg_2Sn phase-containing structure is 5% or more, the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability become superior to a commercially available coated steel sheet.

[0027] From the above findings, it has been found that the coated steel sheet of the present disclosure is a coated steel sheet superior in any of corrosion resistance after painting, sacrificial corrosion protection property, and workability.

[0028] In addition, since the coated steel sheet of the present disclosure has a granular layer-dispersed structure that exhibits plastic deformability be present in the coating layer, it can be also superior in resistance to chipping and attain extension of the lifetime of a coated steel sheet after painting.

The coated steel sheet of the present disclosure contains a predetermined amount of Al in the coating layer, and has a dendritic structure that raises the melting point of the coating layer. Therefore, it can be also superior in resistance to seizure, and can prevent the coating layer from sticking to a press mold during press molding. That is, it is possible for the coated steel sheet of the present disclosure to be superior in both corrosion resistance after painting and press formability.

[0029] The coated steel sheet of the present disclosure will be described in detail below.

[0030] First, a steel sheet will be described.

There is no particular restriction on a steel sheet used as an original sheet for coating, and various steel sheets of an Al-killed steel, an ultra-low carbon steel, a high carbon steel, various high tensile strength steels, a Ni, Cr-containing steel, or the like can be used. There is no particular restriction on a steelmaking method, the strength of a steel, or a pretreatment of steel sheet, such as a hot rolling method, a pickling method, or a cold rolling method.

[0031] There is also no particular restriction on the chemical composition (C, Si, *etc.*) of a steel sheet. It has not been confirmed that elements such as Ni, Mn, Cr, Mo, Ti, or B contained in the steel sheet affect the coating layer.

[0032] Next, a coating layer will be described.

First, the chemical composition of a coating layer will be described.

The chemical composition of a coated steel sheet includes Al, Mg, Sn, and Si as essential elements, and the balance is Zn and impurities. The chemical composition of a

coated steel sheet may include at least one of Bi, In, Ca, Y, La, Ce, Cr, Ti, Ni, Co, V, Nb, Cu, Mn, Sr, Sb, Pb and B as an optional element. That is, the optional element needs not be contained.

The content of each element in the coating layer means the average content of each element contained in the entire coating layer.

[0033] [Al: from 15% to 60%]

Al is an essential element for improving the corrosion resistance after painting and the seizure resistance of a coating layer. Most of Al is present as an Al phase inside a dendritic structure in the coating layer.

The dendritic structure described later is not passivated due to the effect of Sn contained, and in a state not to become a factor for decreasing the corrosion resistance after painting. Meanwhile, when the melting point of the coating layer is low, there arises a problem of seizure of a metal in the coating layer with a press mold. However, as the Al concentration becomes higher, the area fraction of the dendritic structure that is a high melting point structure increases, and, as a result, it is possible to prevent the coating layer from sticking to the press mold at the time of press molding (namely, the resistance to seizure is improved).

The Al concentration required to secure the area fraction of the dendritic structure capable of developing sufficient resistance to seizure is 15% or more. Therefore, the lower limit of the Al concentration is set at 15%. A preferable Al concentration is 20% or more.

Meanwhile, when the Al concentration exceeds 60%, an “interfacial alloy layer composed of an Al-Fe intermetallic compound” formed at the interface between a coating layer and a steel substrate described later grows excessively to impair the workability. Therefore, the upper limit of the Al concentration is set at 60%. A preferable Al concentration is 40% or less.

[0034] [Mg: from 0.5% to 8.0%]

Mg is an essential element for forming a laminar Mg_2Sn phase-containing structure in a coating layer to impart favorable corrosion resistance after painting, sacrificial corrosion protection property, and workability to the coating layer. Mg is present in the coating layer in a form of a Mg-containing intermetallic compound, and dissolved into a corrosive environment as Mg ions under a corrosive environment. Mg ions convert a Zn-based corrosion product to an insulating film, and rust to a barrier film. From the above, penetration of a corrosion factor into the coating layer and under the paint film can be suppressed so as to contribute to improvement of the corrosion resistance after painting. Most of Mg is contained in a laminar Mg_2Sn phase-containing structure. The formation of

the granular Mg_2Sn phase-containing structure improves any of the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability. The Mg concentration required to improve the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability is 0.5%. Therefore, the lower limit of the Mg concentration is set at 0.5%. A preferable Mg concentration is 1.0% or more.

Meanwhile, when the Mg concentration exceeds 8.0%, a massive MgZn_2 phase described later is excessively generated to impair the workability. Therefore, the upper limit of the Mg concentration is set at 8.0%. From the viewpoint of suppressing formation of the massive MgZn_2 phase that impairs the workability, a preferable Mg concentration is 3.0% or less. A more preferable Mg concentration is 2.0% or less.

[0035] [Sn: from 0.5% to 20.0%]

Sn is an essential element for forming a laminar Mg_2Sn phase-containing structure in a coating layer together with Mg to impart favorable corrosion resistance after painting, sacrificial corrosion protection property, and workability to the coating layer. Further, Sn is an element having an effect of suppressing formation of a massive MgZn_2 phase together with a Zn/Al/ MgZn_2 ternary eutectic structure.

Therefore, Sn is also an element that enhances the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability of the coating layer.

When the Sn concentration is low, it becomes difficult to form a laminar Mg_2Sn phase-containing structure, while the generation amounts of a Zn/Al/ MgZn_2 ternary eutectic structure and a massive MgZn_2 phase increase. As a result, the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability of the coating layer tend to decrease. Therefore, the lower limit of the Sn concentration is set at 0.5%. From the viewpoint of sufficiently forming a laminar Mg_2Sn phase-containing structure and sufficiently suppressing formation of a Zn/Al/ MgZn_2 ternary eutectic structure and a massive MgZn_2 phase, a preferable Sn concentration is 0.1% or more, and a more preferable Sn concentration is 1.5% or more.

Meanwhile, when the Sn concentration is excessive, the surplus Sn crystallizes as a potentially nobler Sn phase to decrease the corrosion resistance after painting, and the sacrificial corrosion protection property. Therefore, the upper limit of the Sn concentration is set at 20.0%. From the viewpoint of improving the corrosion resistance after painting, a preferable Sn concentration is 7.5% or less, and a more preferable Sn concentration is 5.0% or less.

[0036] [Si: from 0.05% to 1.50%]

Si, when contained in a coating bath, is an element that suppresses the reactivity of

Zn and Al contained in the coating bath with Fe element in an original sheet for coating. That is, Si is an essential element to control the formation behavior of an interfacial alloy layer composed of an Al-Fe intermetallic compound having an effect on the adhesion and workability of the coating layer (in particular, an interfacial alloy layer containing or consisting of Fe_2Al_5) by controlling the reactivity between the coating layer and the steel substrate. The minimum Si concentration necessary for suppressing the interfacial alloy layer is 0.05%.

When the Si concentration is less than 0.05%, an interfacial alloy layer grows immediately after dipping an original sheet for coating in the coating bath to make it difficult for the coating layer to acquire favorable ductility, and therefore the workability tends to decrease. Consequently, the lower limit of the Si concentration is set at 0.05%. A preferable Si concentration is 0.2% or more.

Meanwhile, when the Si concentration exceeds 1.50%, a potentially nobler Si phase remains in the coating layer, and functions as a cathode zone in corrosion. As a result, it leads to decrease in corrosion resistance after painting. Therefore, the upper limit of the Si concentration is set at 1.50%. A preferable Si concentration is 1.0% or less.

In this regard, Si may occasionally exist in the coating layer as a Mg_2Si phase which is an intermetallic compound with Mg, but insofar as the area fraction of the Mg_2Si phase is 5% or less, it does not affect the performance at all.

[0037] [Bi: from 0% to 5.0%]

Bi is an element contributing to improvement of the sacrificial corrosion protection property. Therefore, the lower limit of the Bi concentration should be more than 0% (preferably 0.1% or more, and more preferably 3.0 or more).

Meanwhile, when the Bi concentration increases, the coating layer is easily corroded under the paint film, and the corrosion resistance after painting tends to deteriorate in the sense that the paint film blistering is prone to become large. Therefore, the upper limit of the Bi concentration is set at 5.0% or less (preferably 0.5% or less, and more preferably 0.1% or less).

[0038] [In: from 0% to 2.0%]

In is an element contributing to improvement of the sacrificial corrosion protection property. Therefore, the lower limit of the In should be more than 0% (preferably 0.1% or more, and more preferably 3.0 or more).

Meanwhile, when the In concentration increases, the coating layer is easily corroded under the paint film, and the corrosion resistance after painting tends to deteriorate in the sense that the paint film blistering is prone to become large. Therefore, the upper limit of the

In concentration is set at 2.0% or less (preferably 0.3% or less).

[0039] [Ca: from 0% to 3.0%]

Ca is an element capable of adjusting the Mg dissolution amount optimum for imparting corrosion resistance after painting and sacrificial corrosion protection property. Therefore, the lower limit of the Ca concentration should be more than 0% (preferably 0.05% or more).

Meanwhile, when the Ca concentration increases, the workability tends to deteriorate. Therefore, the upper limit of the Ca concentration is set at 3.0% or less (preferably 1.0% or less).

[0040] [Y: from 0% to 0.5%]

Y is an element contributing to sacrificial corrosion protection property. Therefore, the lower limit of the Y concentration should be more than 0% (preferably 0.1% or more).

Meanwhile, when the Y concentration increases, the corrosion resistance after painting tends to deteriorate. Therefore, the upper limit of the Y concentration is set at 0.5% or less (preferably 0.3% or less).

[0041] [La and Ce: from 0% to 0.5%]

La and Ce are elements contributing to sacrificial corrosion protection property. Therefore, the lower limits of the La concentration and the Ce concentration should be respectively more than 0% (preferably 0.1% or more).

Meanwhile, when the La concentration and the Ce concentration increase, the corrosion resistance after painting tends to deteriorate. Therefore, the upper limits of the La concentration and the Ce concentration are respectively set at 0.5% or less (preferably 0.3% or less).

[0042] [Cr, Ti, Ni, Co, V, Nb, Cu, and Mn: from 0% to 0.25%]

Cr, Ti, Ni, Co, V, Nb, Cu, and Mn are elements contributing to sacrificial corrosion protection property. Therefore, the lower limits of the concentrations of Cr, Ti, Ni, Co, V, Nb, Cu, and Mn should be respectively more than 0% (preferably 0.05% or more, and more preferably 0.1% or more).

Meanwhile, when the concentrations of Cr, Ti, Ni, Co, V, Nb, Cu, and Mn increase, the corrosion resistance after painting tends to deteriorate. Therefore, the upper limits of the concentration of Cr, Ti, Ni, Co, V, Nb, Cu, and Mn are respectively set at 0.25% or less.

[0043] [Sr, Sb, Pb, and B: from 0% to 0.5%]

Sr, Sb, Pb, and B are elements contributing to sacrificial corrosion protection property. Therefore, the lower limits of the concentrations of Sr, Sb, Pb, and B should be respectively more than 0 (preferably 0.05% or more, and more preferably 0.1% or more).

Meanwhile, when the concentrations of Sr, Sb, Pb, and B increase, the corrosion resistance after painting tends to deteriorate. Therefore, the upper limits of the concentrations of Sr, Sb, Pb, and B are respectively set at 0.5% or less (preferably 0.1% or less).

[0044] [The Balance: Zn and Impurities]

The balance of the chemical composition of the coating layer is Zn and impurities.

Zn is contained in the coating layer at a certain concentration or more in order to properly secure the sacrificial protection performance of the coating layer, the planar part corrosion resistance, and the painting substrate treatment property. From these viewpoints, the chemical composition of the coating layer is mostly occupied by Al and Zn.

The impurities refer to components included in a raw material or components entered in the production process, which are not intentionally added. For example, a small amount of a component such as Fe may be mixed in into the coating layer as an impurity due to mutual atomic diffusion between the steel substrate (steel sheet) and the coating bath.

[0045] For example, when a coating layer is formed by a hot-dip metal coating method, the coating layer may contain Fe at a certain concentration as an impurity. It has been confirmed that the performance is not adversely affected by Fe up to a concentration in the coating layer of 3.0%.

[0046] [Preferred Chemical Composition of Coating Layer]

In the chemical composition of a coating layer, the content of Mg is preferably from 0.5% to 3.0%, and the content of Sn is preferably from 1.0% to 7.5%. When the Mg concentration and Sn concentration are in the above ranges, the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability are further improved.

In particular, it is preferable that the content of Al is from 20% to 60%, the content of Mg is from 1.0% to 2.0%, the content of Sn is from 1.0% to 5.0%, and the content of Si is from 0.05% to 1.0% in the chemical composition of a coating layer. When the Al concentration, Mg concentration, Sn concentration, and Si concentration are in the above ranges, the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability are further improved. In addition, the resistance to seizure is also further improved.

[Formula (1): $\text{Mg \% by mass} \leq \text{Sn \% by mass} \leq 2.5 \times \text{Mg \% by mass}$]

In order to further improve the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability, it is preferable that a granular Mg_2Sn phase-containing structure is sufficiently formed, and the formation of a Zn/Al/MgZn_2 ternary

eutectic structure and a massive MgZn_2 phase is sufficiently suppressed.

For this purpose, the content of Sn and the content of Mg preferably satisfy the following Formula (1), and more preferably satisfy the following Formula (2).

$$\text{Mg} \leq \text{Sn} \leq 2.5 \times \text{Mg} \quad \text{Formula (1)}$$

$$1.5 \times \text{Mg} \leq \text{Sn} \leq 2.0 \times \text{Mg} \quad \text{Formula (2)}$$

In Formula (1) and Formula (2), each atomic symbol indicates the content of the element in terms of % by mass.

[0047] When the Sn concentration does not satisfy Formula (1) and there is a shortage of Sn with respect to Mg, a massive MgZn_2 phase is formed, and the corrosion resistance after painting, and the sacrificial corrosion protection property tend to decrease together with the workability.

Meanwhile, when the Sn concentration does not satisfy Formula (1) and there is a surplus of Sn with respect to Mg, a potentially nobler Sn phase crystallizes, and the corrosion resistance after painting, and the sacrificial corrosion protection property tend to decrease.

[0048] Next, the metallographic structure of a coating layer will be described.

The coating layer has a laminar Mg_2Sn phase-containing structure and a dendritic structure (structure containing a solid solution of Zn and Al).

And, the coating layer has in some cases a massive MgZn_2 phase with an equivalent circle diameter of 1 μm or more, a massive Zn phase with an equivalent circle diameter of 2 μm or more, a Zn/Al/ MgZn_2 ternary eutectic structure, or the like as a structure other than the granular Mg_2Sn phase-containing structure

[0049] Here, a backscattered electron image (BSE image) of an example of the coating layer of the coated steel sheet of the present disclosure taken with an SEM at a magnification of 2000x is shown.

As shown in FIG. 1, the coated steel sheet has, for example, a coating layer 1, a steel sheet 2, and an interfacial alloy layer 3 composed of an Al-Fe intermetallic compound between the coating layer 1 and the steel sheet 2.

The structure of the coating layer 1 is mainly constituted with a laminar Mg_2Sn phase-containing structure 4, and a dendritic structure 5. Further, as shown in FIG. 2, which is an enlarged view of the region A in FIG. 1, the laminar Mg_2Sn phase-containing structure 4 has a structure in which a laminar Mg_2Sn phase 7 with a thickness of less than 1 μm exists in the Zn phase 6 dividing the Zn phase 6 into a plurality of regions.

In FIG. 1, the dendritic structure 5 corresponds to the gray-colored region as well as the black-colored region surrounded by the former region. The difference in color between the two regions is due to the difference in the Al concentrations. Specifically, the dendritic

structure 5 with a low Al concentration is the gray-colored region, and the gray-colored dendritic structure 5 with a high Al concentration is the black-colored region.

In addition to the laminar Mg_2Sn phase-containing structure 4 and the dendritic structure 5, the coating layer 1 may occasionally contain a massive MgZn_2 phase 10 (see FIG. 3), a massive Zn phase 9 (see FIG. 3), and a Zn/Al/ MgZn_2 ternary eutectic structure 8 (see FIG. 3).

[0050] [Laminar Mg_2Sn Phase-containing Structure: Area Fraction from 5 to 65%]

The laminar Mg_2Sn phase-containing structure includes a Zn phase and a laminar Mg_2Sn phase with a thickness of less than 1 μm , and the laminar Mg_2Sn phase exists dividing the Zn phase into a plurality of regions.

When a cross section or a surface of the coating layer is observed, the laminar Mg_2Sn phase-containing structure is, for example, a structure present in the interstices of the dendritic Zn phase. More specifically, it is a structure in which a laminar Mg_2Sn phase having a thickness of less than 1 μm exists in the Zn phase present in the interstices of the dendritic Zn phase structure dividing the Zn phase into a plurality of regions, when a cross section or a surface of the coating layer is observed.

[0051] In this regard, a laminar Mg_2Sn phase is a Mg_2Sn phase present in the interstices between the adjacent Zn phase structures branched in a dendritic shape. The laminar Mg_2Sn phase becomes a layer having a thickness of less than 1 μm due to the close positional relationship between the adjacent dendritic Zn phase structures. The laminar Mg_2Sn phase is shaped to cover each of dendritic Zn phase structures, and as a result, the Zn phase branched in a dendritic shape is divided into a plurality of regions.

[0052] Further, it is essential for attaining the object of the present disclosure that the thickness of a laminar Mg_2Sn phase is less than 1 μm . The more finely the dendritic Zn phase structure is divided, the thinner the thickness of the laminar Mg_2Sn phase becomes. Insofar as the thickness of the laminar Mg_2Sn phase is less than 1 μm , the laminar Mg_2Sn phase-containing structure can sufficiently exhibit plastic deformability. Although there is no particular restriction on the lower limit of the thickness of the laminar Mg_2Sn phase, it is, for example, 10 nm or more.

[0053] In addition, under the cooling conditions of the production method described later, the area fraction of the Mg_2Sn phase in the laminar Mg_2Sn phase-containing structure becomes 10% or more. In this case, it is possible to improve the corrosion resistance while maintaining the plastic deformability. On the other hand, when the cooling is performed outside the appropriate cooling conditions, the area fraction of the Mg_2Sn phase becomes less than 10%, and a plate-like Mg_2Sn phase is formed not in the interstices between the adjacent

dendritic Zn phase structures, rather in a mixed form with coarse Zn phases. In this case, the amount of the Mg_2Sn phase decreases, and as a result adequate corrosion resistance can be hardly obtained. Therefore, when the cooling was not performed under proper cooling conditions, and the area fraction of the Mg_2Sn phase becomes less than 10%, the structure is referred to as a plate-like Mg_2Sn phase-containing structure (Zn phase + plate-like Mg_2Sn phase), and discriminated from a laminar Mg_2Sn phase-containing structure.

[0054] In the plate-like Mg_2Sn phase-containing structure in which a dendritic Zn phase structure becomes coarse, a stress is prone to concentrate on the small amount of Mg_2Sn phase, and therefore such structure is inferior to a laminar Mg_2Sn phase-containing structure in plastic deformability.

The reason for the above is presumed as follows. The laminar Mg_2Sn phases are provided so as to cover each of fine dendritic Zn structures. In contrast, the plate-like Mg_2Sn phases are present in a mixed state with coarse dendritic Zn structures. Therefore, in the laminar Mg_2Sn phase-containing structure, a stress applied to the laminar Mg_2Sn phase is easily dispersed, while in the plate-like Mg_2Sn phase-containing structure, a stress applied to the plate-like Mg_2Sn phase is prone to be concentrated. Therefore, the plate-like Mg_2Sn phase-containing structure is presumably inferior to the laminar Mg_2Sn phase-containing structure in plastic deformability.

[0055] While not wishing to be bound by theory, it is believed that the laminar Mg_2Sn phase-containing structure is a structure formed by allowing a Zn phase to grow rapidly in a dendritic form, and a Mg_2Sn phase to solidify in a laminar form between adjacent branches of a dendritic Zn phase at the time of final solidification in a production process of a coating layer. In fact, in the coating layer according to this disclosure, as shown in the region B of FIG. 2, a Zn phase 6 further grows in a dendrite form in the interstices of the dendritic structures 5, and formation of a structure in which a laminar Mg_2Sn phase 7 is present around this Zn dendrite can be confirmed. When a cross-section or a surface of the coating layer is observed, such a structure is conceivably observed as a structure in which the laminar Mg_2Sn phase 7 exists dividing the Zn phase 6 into a plurality of regions, as shown in FIGs. 1 and 2.

[0056] In other words, the laminar Mg_2Sn phase-containing structure is a structure constituted with dendritic Zn phases and laminar Mg_2Sn phases with a thickness of less than 1 μm existing between the branches of the dendritic Zn phase.

In this case, in the laminar Mg_2Sn phase-containing structure, the area fraction of the laminar Mg_2Sn phase with respect to the laminar Mg_2Sn phase-containing structure (that is, the Zn phase and the laminar Mg_2Sn phase) is preferably from 10 to 50%. Meanwhile, the average thickness of the laminar Mg_2Sn phase is preferably not less than 0.01 but less than 1

μm.

[0057] There is no particular restriction on the average composition of the entire laminar Mg_2Sn phase-containing structure, and, for example, the Mg concentration is from 1 to 10 % by mass, the Sn concentration is from 1 to 25 % by mass, and the Al concentration is from 1 to 8 % by mass, while the balance consists of Zn, and impurities of less than about 2 % by mass. The composition of the entire laminar Mg_2Sn phase-containing structure may also include the above-mentioned optional elements that can be included in the chemical composition of the coating layer.

[0058] In this regard, in the present disclosure, a granular phase of an intermetallic compound corresponding to any of the following (1) to (5) is also regarded as the laminar Mg_2Sn phase.

- (1) Mg_2Sn in which an element such as Si is interstitially dissolved;
- (2) Mg_9Sn_5 formed through transformation of a Mg_2Sn phase;
- (3) Substituted Mg_2Sn and Mg_9Sn_5 (substitution product of Mg_2Sn and Mg_9Sn_5) in which at least one of Bi, In, Cr, Ti, Ni, Co, V, Nb, Cu, and Mn is substituted for part of Sn;
- (4) Substituted Mg_2Sn and Mg_9Sn_5 (substitution product of Mg_2Sn and Mg_9Sn_5) in which at least one of Ca, Y, La and Ce is substituted for part of Mg;
- (5) Substituted Mg_2Sn and Mg_9Sn_5 (substitution product of Mg_2Sn and Mg_9Sn_5) in which at least one of Ca, Y, La, and Ce is substituted for part of Mg, and at least one of Bi, In, Cr, Ti, Ni, Co, V, Nb, Cu, and Mn is substituted for part of Sn.

[0059] A laminar Mg_2Sn phase-containing structure has an effect of improving the corrosion resistance after painting, sacrificial corrosion protection property, and workability.

Although it includes a Mg_2Sn phase which is a brittle Mg-containing intermetallic compound as described above, the Mg_2Sn phase has higher plastic deformability compared to a MgZn_2 phase.

Although the Mg-containing intermetallic compound is a brittle phase as described above, the Mg_2Sn phase has a higher plastic deformability compared to the MgZn_2 phase. When a structure is so constructed that the Mg_2Sn phase exists in a Zn phase with favorable plastic deformability dividing the Zn phase into a plurality of laminar regions, the structure as a whole expresses favorable plastic deformability to contribute to improvement of the workability.

In addition, the Mg_2Sn phase serves as a supply source of Mg ions in a corrosive environment, and the Mg ions make the corrosion product to an insulating film, so that corrosion under the paint film in a painted state may be suppressed. Although the details of the mechanism are not clear, in the case of a structure in which the laminar Mg_2Sn phase

exists dividing the Zn phase into a plurality of regions, the corrosion propagates along the laminar Mg_2Sn phase, and as a result the laminar Mg_2Sn phase functions as a source of Mg ions for a long time period. The Mg_2Sn phase is electrically less noble as compared to the MgZn_2 phase, and is inherently superior in sacrificial corrosion protection property. Therefore, it is presumed that it has the improvement effect on the corrosion resistance after painting and the sacrificial corrosion protection property.

The higher the area fraction of the laminar Mg_2Sn phase-containing structure present in the coating layer is, the higher the improvement effect on the corrosion resistance after painting, sacrificial corrosion protection property, and workability with the laminar Mg_2Sn phase-containing structure becomes.

[0060] When the area fraction of the laminar Mg_2Sn phase-containing structure is less than 5%, the improvement effect on the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability cannot be obtained. Therefore, the lower limit of the area fraction of the laminar Mg_2Sn phase-containing structure is set at 5%. From the viewpoint of reliably improving both the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability, the area fraction of the laminar Mg_2Sn phase-containing structure is preferably 20% or more, and more preferably 30% or more.

Meanwhile, as described above, the higher the area fraction of the laminar Mg_2Sn phase-containing structure becomes, the greater the effect of improving the corrosion resistance after painting, the sacrificial corrosion protection property, and the workability becomes. Although there is no particular restriction on the upper limit value from the viewpoint of performance, the producible area fraction of the laminar Mg_2Sn phase-containing structure is 65% at the maximum due to production restrictions. Therefore, the upper limit of the area fraction of the laminar Mg_2Sn phase-containing structure is set at 65%. From the viewpoint of stable production, the area fraction of the laminar Mg_2Sn phase-containing structure is preferably 60% or less.

That is, the area fraction of the laminar Mg_2Sn phase-containing structure is from 5 to 65%. The area fraction of the laminar Mg_2Sn phase-containing structure is preferably from 20 to 60%, and more preferably from 30 to 60%.

[0061] [Dendritic Structure: Area Fraction from 35% to 95%]

A dendritic structure is a structure containing a solid solution of Zn and Al. Specifically, a dendritic structure is a structure finely separated to Al phases and Zn phases, and is a structure with the Al concentration of from 15 to 85% and the Zn concentration of from 15 to 85%. Therefore, a dendritic structure is a structure which has fundamentally favorable plastic deformability, and can contribute to improvement of the workability of the

coating layer. In addition, it is also a structure contributing to improvement of the seizure resistance.

[0062] In order to ensure excellent workability, the area fraction of the dendritic structure is preferably 35% or more. From the viewpoint of imparting excellent workability to the coating layer, the area fraction of the dendritic structure is more preferably 40% or more. Meanwhile, from the viewpoint of production, the upper limit value with respect to the dendritic structure is preferably 95%. From the viewpoint of improving the corrosion resistance after painting and the workability by the granular phase dispersed phase, the dendritic structure occupies preferably 80% or less, more preferably 70% or less.

That is, the area fraction of the dendritic structure is preferably from 35 to 95%, more preferably from 35 or 40 to 80%, and further preferably from 35 or 40 to 70%.

[0063] [Massive Zn Phase: Area Fraction from 0% to 20%]

A massive Zn phase is present in an irregular form in the coating layer, and is a massive Zn phase having an equivalent circle diameter of 2 μm or more. The upper limit of the equivalent circle diameter of the massive Zn phase is not particularly limited, but is, for example, 10 μm or less.

As the area fraction of the massive Zn phase increases, the resistance to seizure and the corrosion resistance tend to decrease. Therefore, from the viewpoint of securing the resistance to seizure and the corrosion resistance, the area fraction of the massive Zn phase is preferably 20% or less. From the viewpoint of securing sufficient resistance to seizure and corrosion resistance, the area fraction of the massive Zn phase is more preferably 10% or less. The area fraction of the massive Zn phase is most preferably 0% (namely, it is most preferable that a massive Zn phase is not included).

That is, the area fraction of the massive Zn phase is preferably from 0 to 20%, more preferably from 0 to 10%, and further preferably 0%.

[0064] [Massive MgZn_2 Phase: Area Fraction from 0% to 20%]

A massive MgZn_2 phase is present in an irregular form in the coating layer and is a massive Zn phase having an equivalent circle diameter of 2 μm or more. The upper limit of the equivalent circle diameter of a massive MgZn_2 phase is not particularly limited, but is, for example, 10 μm or less.

The massive MgZn_2 phase is a brittle phase and tends to become a starting point of cracking at the time of processing. Corrosion may be accelerated in the vicinity of the crack which may cause decrease in corrosion resistance after painting at a processed part. As the area fraction of the massive MgZn_2 phase increases, the corrosion resistance after painting and the workability tend to decrease. Therefore, from the viewpoint of securing corrosion

resistance after painting and workability, the area fraction of the massive MgZn_2 phase is preferably 20% or less. From the viewpoint of securing sufficient corrosion resistance after painting and workability, the area fraction of the massive MgZn_2 phase is more preferably 5% or less. The area fraction of the massive MgZn_2 phase is most preferably 0% (namely, it is most preferable that a massive MgZn_2 phase is not included).

That is, the area fraction of the massive MgZn_2 phase is preferably from 0 to 20%, more preferably from 0 to 5%, and further preferably 0%.

[0065] [Zn/Al/ MgZn_2 Ternary Eutectic Structure: Area Fraction from 0% to 3%]

The Zn/Al/ MgZn_2 ternary eutectic structure is a structure consisting of an Al phase, a Zn phase, and a MgZn phase. Since the size varies depending on the component composition, the shape of each phase is indeterminate. However, since in a eutectic structure, element movement during solidification is suppressed due to transformation at a constant temperature, the respective phases form an intricate pattern, and ordinarily the respective phases finely precipitate (see FIG. 5).

Ordinarily the respective phases are configured such that the Zn phase is large and forms islands, the MgZn phase is second largest and fills the gaps of the Zn phases, and the Al phase is dispersed in a spot pattern among the MgZn_2 phases. Although the constituent phases are not changed by the component composition, the positional relationship depends on the component variation just before solidification and there are a case where the MgZn_2 phase precipitates to form islands, and a case where the Al phase, or the MgZn_2 phase does so.

The method of identifying a ternary eutectic structure will be described later.

[0066] With respect to a Zn/Al/ MgZn_2 ternary eutectic structure, the MgZn_2 phase in the ternary eutectic structure, which is brittle and susceptible to corrosion, tends to become a starting point of a crack at the time of processing. Corrosion may be accelerated in the vicinity of the crack, which may cause decrease in the corrosion resistance after painting of a processed part. As the area fraction of the Zn/Al/ MgZn_2 ternary eutectic structure increases, the corrosion resistance after painting and the workability tend to decrease. Therefore, from the viewpoint of securing corrosion resistance after painting and workability, the area fraction of the Zn/Al/ MgZn_2 ternary eutectic structure is preferably 3% or less. From the viewpoint of securing sufficient corrosion resistance after painting and workability, the area fraction of the Zn/Al/ MgZn_2 ternary eutectic structure is most preferably 0% (namely, it is most preferable that the Zn/Al/ MgZn_2 ternary eutectic structure is not included).

That is, the area fraction of the Zn/Al/ MgZn_2 ternary eutectic structure is preferably from 0 to 3%, and most preferably 0%.

[0067] The thickness of the coating layer is, for example, about 100 μm or less. Since the

thickness of the entire coating layer depends on the coating conditions, the upper limit and the lower limit of the thickness of the entire coating layer are not particularly restricted. For example, the thickness of the entire coating layer is related to the viscosity and the specific gravity of the coating bath in the conventional hot-dip metal coating method. Further, the coating amount in terms of weight per unit area may be adjusted by the drawing speed of the steel sheet (original sheet for coating) and the intensity of the wiping. Therefore, the lower limit of the thickness of the entire coating layer is, for example, about 2 μm . Meanwhile, the thickness of the coating layer, which can be produced by a hot-dip metal coating method, is about 95 μm due to the own weight and uniformity of the coating metal.

Therefore, the thickness of the coating layer is preferably from 2 to 95 μm .

[0068] Next, an interfacial alloy layer will be described.

The coated steel sheet of the present disclosure may further have an interfacial alloy layer composed of an Al-Fe intermetallic compound between the steel sheet and the coating layer. Generally, an interfacial alloy layer composed of an Al-Fe intermetallic compound of 3 μm or less is formed between the coating layer and the steel sheet. However, an interfacial alloy layer is not necessarily formed depending on the formation conditions of a coating layer.

The interfacial alloy layer preferably has a thickness of 100 nm or more in order to ensure the adhesion between the steel substrate (steel sheet) and the coating layer. Meanwhile, since the Al-Fe intermetallic compound composing the interfacial alloy layer is a brittle intermetallic compound, when the thickness of the interfacial alloy layer exceeds 1.5 μm , the resistance to chipping may be reduced.

Therefore, when the coated steel sheet of the present disclosure has an interfacial alloy layer, the thickness of the interfacial alloy layer is preferably from 100 nm to 1.5 μm .

Since the interfacial alloy layer is in a solid state in which Si is dissolved, it has a role of suppressing an alloying reaction between the coating layer and the steel substrate.

[0069] In this regard, the interfacial alloy layer composed of the Al-Fe intermetallic compound is a layer in which the Al_5Fe phase is the main phase. The Al-Fe alloy layer is formed by mutual atomic diffusion of the steel substrate (steel sheet) and the coating bath. However, the interfacial alloy layer may partially contain only a small amount of an AlFe phase, an Al_3Fe phase, an Al_5Fe_2 phase, or the like.

[0070] The interfacial alloy layer may also contain various elements such as Zn or Si, which are components of the coating layer. In particular, when Si is incorporated into the interfacial alloy layer, an Al-Fe-Si intermetallic compound is formed in the interfacial alloy layer.

Furthermore, when an original sheet for coating out of various kinds of pre-coated

steel sheet is used, the interfacial alloy layer may include a pre-coating component (for example, Ni). When the pre-coating component (for example, Ni) is incorporated into an interfacial alloy layer, an Al-Fe-Ni intermetallic compound is formed in the interfacial alloy layer.

[0071] That is, the interfacial alloy layer composed of an Al-Fe intermetallic compound means a layer which includes the above-described various modes of alloy layers besides the alloy layer constituted mainly with an Al_5Fe phase

[0072] An example of the method of producing the coated steel sheet of the present disclosure will be described below.

The coated steel of the present disclosure is obtained by forming a coating layer on the surface (that is, one side or both sides) of an original sheet for coating by a hot-dip metal coating method.

[0073] As a method of producing a coated steel sheet according to the present disclosure, a Sendzimir method, a pre-coating method, or the like may be applied. When Ni is used as a type of pre-coating, Ni may be contained in an “Interfacial alloy layer composed of an Al-Fe intermetallic compound” which may be formed when the coating layer is heated.

[0074] A coating bath is formed by mixing a pure metal or an alloy into the range of the chemical composition of the above-mentioned coating layer, and melting the same in a range of 450 to 650°C as an initial make-up of electrolytic bath.

Then, an original sheet for coating whose surface is sufficiently reduced is immersed in the coating bath which is kept at a predetermined bath temperature after the initial make-up of electrolytic bath, taken out, and then cooled down thereby completing a coating layer on the surface of the original sheet for coating (steel sheet). For regulating the coating amount of the coating layer, for example, wiping with a N_2 gas is performed immediately after the original sheet for coating is taken out from the coating bath.

[0075] In this regard, the cooling rate in the temperature range from immediately after removal of the original sheet for coating from the coating bath (that is, the coating bath temperature) to 320°C is set at 10°C/s or less, and the cooling rate in the temperature range of from 320°C to 280°C is set at 20°C/s or more.

The backscattered electron image (BSE image) with an SEM of the cross section of the coating layer of the coated steel sheet of the present disclosure shown in FIG. 1 is a backscattered electron image (BSE image) with an SEM of the cross section of the coating layer of the coated steel sheet prepared using the cooling rate of 10°C/s in the temperature range from the temperature of the coating bath to 320°C, and the cooling rate of 40°C/s in the temperature range of from 320°C to 280°C.

As shown in FIG. 1, under the above-described cooling conditions, a structure having a laminar Mg_2Sn phase-containing structure 4 and a dendritic structure 5 in the coating layer is formed.

The regulation of the cooling rates can be achieved by any method known to those skilled in the art. For example, there is a method of regulating the cooling rate by appropriately adjusting the flow rate of a cooling gas. Particularly, when water cooling is utilized, an extremely high cooling rate even exceeding 100°C/s can be also realized.

[0076] Meanwhile, even when the cooling rate in the temperature range from immediately after removal of the original sheet for coating from the coating bath (that is, the coating bath temperature) to 320°C is 10°C/s or less, and the cooling rate in the temperature range of from 320°C to 280°C is 20°C/s or more, unless the Sn concentration is appropriate, a sufficient amount of the laminar Mg_2Sn phase-containing structure 4 is not necessarily formed. For example, as shown in FIG. 3, when Sn is not added, a laminar Mg_2Sn phase-containing structure 4 is not formed in the coating layer, rather, a Zn/Al/MgZn_2 ternary eutectic structure 8 is formed together with a dendritic structure 5.

[0077] In addition, in a case where the cooling rate is not changed between the temperature range from immediately after removal of the original sheet for coating from the coating bath (that is, the coating bath temperature) to 320°C , and the temperature range of from 320°C to 280°C , a sufficient amount of the laminar Mg_2Sn phase-containing structure 4 is not necessarily formed.

For example, in the case of the cooling rate condition where the cooling rate is not changed in the above ranges, as shown in FIG. 4, a granular Mg_2Sn phase-containing structure 4 is not formed in the coating layer 1. Instead, a structure 11 in which a plate-like Mg_2Sn phase (Mg_2Sn phase with a thickness of more than $0.2\text{ }\mu\text{m}$) is mixed in the Zn phase is formed. When the structure 11 is formed, the area fraction of the plate-like Mg_2Zn phase in the structure 11 is not less than 5% but less than 25%.

[0078] Although the detailed formation mechanism of this structure 11 is not clear, the following is conceivable. When the cooling rate A is 10°C/s or less, and the cooling rate B is less than 20°C/s , a Mg_2Sn phase is coarsened from a laminar to plate-like form. When the cooling rate A is less than 10°C/s and the cooling rate B is 20°C/s or more, the solidification behavior that naturally progresses in a nonequilibrium state approaches an equilibrium state, and the Zn phase cannot grow in a dendritic form. As a result, it is considered that a plate-like Mg_2Sn phase having a thickness beyond $0.2\text{ }\mu\text{m}$ and an area fraction below 25% is formed.

[0079] The method of analyzing the structure of the hot-dip Zn coated steel sheet of the

present disclosure will be described below.

[0080] The chemical component of a coating layer is measured by the following method.

Firstly, calibration curves for quantitatively analyzing the respective elements are prepared by GDS (radio-frequency glow discharge-optical emission spectroscopy). Thereafter, the chemical components in the depth direction of the coating layer under test are measured.

Specifically, GDS (radio-frequency glow discharge-optical emission spectroscopy) is performed on each standard sample such as a pure metal plate of each element to obtain in advance a calibration curve showing the relationship between the elemental intensity plotted against each elemental concentration.

Meanwhile, several 30 mm square pieces are taken from a sample of the coated steel sheet under test, and used as test pieces for GDS. Argon ion sputtering is performed from the surface layer of the coating layer to obtain an elemental intensity profile in the depth direction. The obtained intensity profile is converted to the elemental concentration with the calibration curve.

In an analysis of the chemical composition by GDS, an analysis area of 4 mm ϕ or more is measured at 10 positions or more at a sputtering rate in a range of from 0.04 to 0.1 $\mu\text{m}/\text{sec}$. The average value of the elemental concentration at each place is regarded as the elemental concentration of the chemical composition.

However, at each GDS analysis position, in order to eliminate the influence of an oxide layer on the outermost layer, the 1 μm -deep surface layer of the component profile is ignored, and the average value of each elemental concentration in the depth range of from 1 to 10 μm (5 μm width) is adopted.

[0081] The area fraction of a structure (provided, a Zn/Al/MgZn₂ ternary eutectic structure is excluded) of the coating layer is measured by the following method.

For measuring the area fraction of a structure of the coating layer, a FE-SEM equipped with an EDS (energy dispersive X-ray analyzer) is used.

[0082] A test piece having a cross section (cross section cut in the thickness direction of the coating layer) of 25 mm in the C direction and 15 mm in the L direction is cut out from the coated steel sheet. The obtained test piece is embedded in a resin, and CP (cross session polisher) processing is applied to the cross section of the coating layer to be measured. After the CP processing, a backscattered electron image with an SEM and an element mapping image with an EDS of the cross section of the coating layer are created. For the backscattered electron image with an SEM and the element mapping image with an EDS, the magnification is 5000x, and the visual field size is 50 μm long $\times$ 200 μm wide.

Each region in a structure is identified based on the backscattered electron image with an SEM and the element mapping image with an EDS.

[0083] Next, in the backscattered electron image with an SEM, three values of the gray scale lightness, the hue, and the contrast value displayed by each structure in the coating layer are determined. Since the three values of lightness, hue, and contrast value displayed by each structure reflect the atomic number of the element contained in each structure, that having higher contents of Al and Mg having a small atomic number tends to display a black color, and that richer in Zn tends to display a white color.

[0084] A computer image processing is performed such that a range corresponding to the 3 values to be displayed by each structure included in the coating layer exhibits a specific color (for example, only a specific structure is exhibited as a white image, and then the area (number of pixels), *etc.* of each structure in the visual field is calculated). By performing this image processing for each phase, the area fraction of each structure in the coating layer occupied in the backscattered electron image from an SEM is determined.

[0085] The area fraction of each structure of the coating layer is defined as the average value of the area fractions of the structure measured for each of five visual fields in an optional cross section (cross section cut in the thickness direction of the coating layer) according to the above-described operation.

[0086] In this regard, the area fraction of a laminar Mg_2Sn phase-containing structure is the area fraction of a Zn phase, in which a laminar Mg_2Sn phase having a thickness of less than 1 μm exists dividing the Zn phase into a plurality of regions, in a Zn phase region, provided that the area of the laminar Mg_2Sn phase is also counted.

The area fraction of a dendritic structure is the area fraction of the region occupied by of a solid solution of Zn and Al (the structure showing the Al concentration of from 15 to 85%, and the Zn concentration of from 15 to 85%).

The area fraction of a massive MgZn_2 phase is the area fraction of the MgZn_2 phase having an equivalent circle diameter of 1 μm or more.

The area fraction of a massive Zn phase is the area fraction of the Zn phase having an equivalent circle diameter of 2 μm or more.

[0087] The area fraction occupied by the laminar Mg_2Sn phase with respect to the laminar Mg_2Sn phase-containing structure (that is, the Zn phase and the laminar Mg_2Sn phase) is measured in the same manner as above except that the measuring object is changed to an SEM backscattered electron image of a cross section of the coating layer for a visual field in a size of $12\ \mu\text{m} \times 12\ \mu\text{m}$ at a magnification of 10000x.

The average thickness of the laminar Mg_2Sn phase is calculated as an average value

of the thicknesses of the laminar Mg_2Sn phase measured in five visual fields (5 positions in each visual field) of the same SEM backscattered electron image.

[0088] A $\text{Zn}/\text{Al}/\text{MgZn}_2$ ternary eutectic structure in the coating layer is identified and its area fraction is measured by the following method.

[0089] First, a structure in an SEM backscattered electron image, in which three phases of an Al phase, a Zn phase, and a MgZn_2 phase have formed a eutectic, is identified by the same method as the measurement of the area fraction of each structure in the coating layer. A part of the structure is observed by means of a rectangular visual field in a size of $3\ \mu\text{m} \times 4\ \mu\text{m}$ (diagonal: $5\ \mu\text{m}$) at a magnification of 30000x (see FIG. 5). In doing so, when two diagonals are drawn in the rectangular visual field, in a case each diagonal crosses a Zn phase 5 or more times, and a MgZn_2 phase or an Al phase spreading around the Zn phase 5 or more times, the structure is judged as a ternary eutectic structure. This judgment is based on the fact that a ternary eutectic structure is characterized by a “structure in which each of 3 phases is finely dispersed”.

[0090] In this regard, in a case where a ternary eutectic structure cannot extend to cover the region of $3\ \mu\text{m} \times 4\ \mu\text{m}$ due to possible uneven distribution of the ternary eutectic structure, or difficulty in forming a ternary eutectic structure, the structure may be divided into a $1\ \mu\text{m}$ -square grid-like pattern, and when each phase is included within a single grid in a number of 1 or more respectively, it may be judged as a ternary eutectic structure.

[0091] Next, on the same SEM backscattered electron image as the measurement of the area fraction of each structure in the coating layer (magnification of 5000, visual field size: $50\ \mu\text{m}$ long $\times$ $200\ \mu\text{m}$ wide), the above operation is repeated to grasp the outline (region) of the ternary eutectic structure while confirming the continuity of the ternary eutectic structure. Then, the area fraction of the grasped ternary eutectic structure in the coating layer occupied in the SEM backscattered electron image is determined.

The area fraction of the ternary eutectic structure is defined as the average value of the area fraction of the ternary eutectic structure obtained in at least five visual fields in an optional cross section (cross section cut in the thickness direction of the coating layer) according to the above-described operation.

[0092] The average equivalent circle diameters of a massive MgZn_2 phase and a massive Zn phase are measured by the following method.

In the SEM backscattered electron image, in which each structure has been identified in measuring the area fraction of the above structure, the top five equivalent circle diameters are selected with respect to each identified phase type. Then, this operation is performed for five visual fields, and the arithmetic average of totally 25 equivalent circle diameters is

defined as the average equivalent circle diameter of a massive MgZn_2 phase, or a massive Zn phase.

[0093] The thickness of an interfacial alloy layer composed of an Al-Fe intermetallic compound is measured as follows.

In the SEM backscattered electron image, in which each structure has been identified in measuring the area fraction of the above structure (magnification of 5000x, visual field size: 50 μm long $\times$ 200 μm wide, provided that the visual field include a recognizable interfacial alloy layer), the thickness of the identified interfacial alloy layer is measured at each of optional 5 positions. The arithmetic average of the data at 5 positions is defined as the thickness of the interfacial alloy layer.

[0094] A post-treatment applicable to the coated steel sheet of the present disclosure will be described below.

In the coated steel sheet of the present disclosure, a film may be formed on the coating layer. The film may be constituted with one or more layers. Examples of the type of a film directly on the coating layer include a chromate film, a phosphate film, and a chromate-free film. As a chromate treatment, a phosphate treatment, or a chromate-free treatment for forming the above film may be performed by known methods.

[0095] As for the chromate treatment, there are an electrolytic chromate treatment in which a chromate film is formed by electrolysis, a reaction type chromate treatment in which a film is formed utilizing a reaction with a material, and a surplus treatment solution is washed away, and a coating type chromate treatment in which a treatment solution is coated on an object and then dried without washing with water to form a film. Any of the above may be used.

[0096] Examples of the electrolytic chromate treatment include electrolytic chromate treatments using chromic acid, silica sol, a resin (such as phosphoric acid, acrylic resin, vinyl ester resin, vinyl acetate acrylic emulsion, carboxylated styrene butadiene latex, or diisopropanolamine-modified epoxy resin), and hard silica.

[0097] Examples of the phosphate treatment include a zinc phosphate treatment, a calcium zinc phosphate treatment, and a manganese phosphate treatment.

[0098] The chromate-free treatment is particularly preferable because it is environmentally-friendly. In the chromate-free treatment, there are an electrolytic chromate-free treatment in which a chromate film is formed by electrolysis, a reaction type chromate-free treatment in which a film is formed utilizing a reaction with a material, and a surplus treatment solution is washed away, and a coating type chromate-free treatment in which a treatment solution is coated on an object and then dried without washing with water to form a film. Any of the treatments may be adopted.

[0099] Furthermore, one, or two or more layers of organic resin films may be provided on the film directly on the coating layer. The organic resin is not limited to a specific type, and examples thereof include a polyester resin, a polyurethane resin, an epoxy resin, an acrylic resin, a polyolefin resin, and modified products of these resins. In this regard, the modified product refers to a resin to be obtained by reacting a functional group included in the structure of any of the above resins with another compound (monomer, crosslinking agent, or the like) having a functional group reactive with said functional group in the structure.

[0100] As such an organic resin, a single, or a mixture of two or more organic resins (not modified) may be used, or a single, or a mixture of two or more organic resins to be obtained by modifying at least one other organic resin in the presence of at least one organic resin may be used. In addition, the organic resin film may contain an optional coloring pigment or rust prevention pigment. It may be also used after it is formed into an aqueous system by dissolving or dispersing it in water.

Examples

[0101] Example that is an embodiment of the present disclosure will be described below.

[0102] As the coating bath, a coating bath in which the components were so adjusted that the chemical composition of the coating layer had the chemical composition shown in Table 1 was prepared. The coating bath temperature was selected in the range of from 465 to 595°C corresponding to the composition. As an original sheet for coating, a hot rolled steel sheet (carbon concentration 0.2%) having a sheet thickness of 0.8 mm was used. The original sheet was cut into a size of 100 mm × 200 mm, and then coated with a self-made batchwise hot-dip metal coating test machine. The sheet temperature was monitored using a thermocouple spot-welded at the center of the original sheet for coating. In a case where Formula (1), which is relevant to the composition balance between Mg and Sn disclosed herein, was satisfied, OK was entered in Table 1, and when the same was not satisfied, NG was entered.

[0103] Before immersion in the coating bath, the surface of the original sheet for coating was reduced by a N₂-5% H₂ gas at 800°C in a furnace with an oxygen concentration of 20 ppm or less, cooled with a N₂ gas, and when the temperature of the sheet to be immersed reached the bath temperature +20°C, the sheet was immersed in the coating bath for about 3 sec. After immersion in the coating bath, the sheet was pulled up at a pulling rate of 100 mm/sec. At the time of pulling up, the coating amount was adjusted with an N₂ wiping gas.

[0104] After the steel sheet was taking out of the coating bath, the coating layer was cooled from the temperature of the coating bath to room temperature under the conditions written in Table 1 to produce a coated steel sheet.

Further, a commercial hot-dip zinc-coated steel sheet (No. 101 in Table 1), alloyed zinc-coated steel sheet (No. 102 in Table 1), and electrozinc-coated steel sheet (No. 103 in Table 1) were also prepared and subjected to the above evaluation.

[0105]

[Table 1-1]

Table 1-1

Class	No.	Chemical composition of coating layer (% by mass)								Melting point of coating	Coating bath temp.	Cooling condition	
		Zn	Al	Mg	Sn	Si	Total amount of optional elements	Optional element	Formula (1)			Average cooling rate from coating bath temp. to 320°C	Average cooling rate from 320°C to 280°C
C	1	84.3	14	0.5	1.1	0.1	0		OK	440	460	10	40
C	2	83.8	15	0.4	0.7	0.1	0		OK	445	465	10	40
E	3	83.7	15	0.5	0.5	0.1	0.2		OK	445	465	10	40
E	4	83.4	15	0.5	1	0.1	0		OK	445	465	10	40
E	5	83.5	15	0.5	1	0.05	0		OK	445	465	10	40
C	6	83.1	15	0.5	1.2	0.2	0		OK	445	465	10	10
E	7	78.4	20	0.5	1	0.1	0		OK	475	495	10	40
C	8	76.3	22	0.5	1.2	0.01	0		OK	480	500	10	40
E	9	75.3	22	0.5	2	0.2	0		NG	480	500	10	40

E	10	76.1	22	0.5	1.2	0.2	0		OK	480	500	10	40
E	11	76.3	22	0.5	1	0.2	0		OK	480	500	10	40
E	12	76.3	22	0.5	1	0.2	0		OK	480	500	10	40
C	13	76.3	22	0.5	1	0.2	0		OK	480	500	40	40
E	14	73.1	25	0.5	1.2	0.2	0		OK	487	507	10	40
E	15	69.0	25	0.5	1.2	0.2	4.1	Bi:4.1	OK	488	508	10	40
E	16	68.3	30	0.5	1	0.2	0		OK	481	501	10	150
C	17	69.2	30	0.5	0.1	0.2	0		OK	510	530	10	40
E	18	58.3	40	0.5	1	0.2	0		OK	540	560	10	40
E	19	46.0	51	0.5	1	1.5	0		OK	565	585	10	40
E	20	38.1	60	0.5	1.2	0.2	0		OK	573	593	10	40
C	21	36.1	62	0.5	1.2	0.2	0		OK	575	595	10	40
C	22	83.5	14	1	1	0.5	0		OK	430	450	10	40
E	23	82.8	15	1	1	0.2	0		OK	445	465	10	40
C	24	81.8	17	1	0	0.2	0		NG	456	476	10	40
E	25	77.8	20	1	1	0.2	0		OK	475	495	10	40
E	26	75.8	22	1	1	0.2	0		OK	480	500	10	40
E	27	74.3	22	1	2.5	0.2	0		OK	480	500	10	40
C	28	76.8	22	1	0	0.2	0		NG	480	500	10	40
C	29	74.4	22	1	2.4	0.2	0		OK	480	500	10	19
E	30	72.1	24	1	2.4	0.5	0		OK	485	505	10	40

C	31	72.1	24	1	2.4	0.5	0		OK	485	505	20	20
E	32	70.1	26	1	2.4	0.5	0		OK	490	510	10	40
E	33	70.1	26	1	2.7	0.2	0		NG	490	510	10	40
E	34	68.4	28	1	2.4	0.2	0		OK	505	525	10	40
C	35	67.6	29	1	2.4	0	0		OK	505	525	10	40
E	36	66.4	30	1	2.4	0.2	0		OK	510	530	10	40
E	37	65.8	30	1	2.6	0.2	0.4	Pb:0.1, In:0.3	OK	510	530	10	40
E	38	58.4	38	1	2.4	0.2	0		OK	535	555	10	40
E	39	56.4	40	1	2.4	0.2	0		OK	540	560	10	20
E	40	56.2	40	1	2.4	0.1	0.3	B:0.1, V:0.2	OK	540	560	10	20
E	41	51.4	45	1	2.4	0.2	0		OK	555	575	10	20
E	42	45.4	51	1	2.4	0.2	0		OK	565	585	10	20
E	43	36.4	60	1	2.4	0.2	0		OK	573	593	10	20
C	44	34.4	62	1	2.4	0.2	0		OK	575	595	10	40
C	45	34.6	60	1	2.4	2	0		OK	573	593	10	40
C	46	78.8	14	2	5	0.2	0		OK	440	460	10	40
E	47	78.0	15	2	5	0.05	0		OK	445	465	10	40
E	48	70.8	22	2	5	0.2	0		OK	480	500	10	40
C	49	71.0	22	2	5	0.01	0		OK	480	500	10	40

[0106]

[Table 1-2]

Table 1-2

Class	No.	Chemical composition of coating layer (% by mass)									Melting point of coating	Coating bath temp.	Cooling condition	
		Zn	Al	Mg	Sn	Si	Total amount of optional elements	Optional element	Formula (1)	(°C)			(°C/sec)	(°C/sec)
E	50	68.8	22	2	7	0.2	0		NG	480	500	10	40	
E	51	62.8	30	2	5	0.2	0		OK	510	530	10	40	
E	52	57.8	35	2	5	0.2	0		OK	528	548	10	40	
C	53	52.6	40	2	4	1.4	0		OK	540	560	30	30	
E	54	51.6	40	2	5	1.4	0		OK	540	560	10	40	
E	55	47.8	45	2	5	0.2	0		OK	555	575	10	40	
E	56	41.8	51	2	5	0.2	0		OK	565	585	10	40	

E	57	32.8	60	2	5	0.2	0		OK	573	593	10	40
C	58	30.8	62	2	5	0.2	0		OK	575	595	10	40
E	59	74.8	15	3	7	0.2	0		OK	445	465	10	40
E	60	69.8	20	3	7	0.2	0		OK	475	495	10	40
E	61	67.8	22	3	7	0.2	0		OK	480	500	10	40
E	62	64.8	22	4	9	0.2	0		OK	480	500	10	40
E	63	65.8	22	3	9	0.2	0		NG	480	500	10	40
E	64	64.8	25	3	7	0.2	0		OK	488	508	10	40
C	65	64.8	25	3	7	0.2	0		OK	488	508	40	40
E	66	59.8	30	3	7	0.2	0		OK	510	530	10	40
E	67	54.8	35	3	7	0.2	0		OK	528	548	10	40
E	68	49.8	40	3	7	0.2	0		OK	555	575	10	40
E	69	44.8	45	3	7	0.2	0		OK	555	575	10	40
E	70	29.8	60	3	7	0.2	0		OK	573	593	10	40
C	71	27.6	62	3	7.2	0.2	0		OK	575	595	10	40
C	72	74.8	14	5	6	0.2	0		OK	440	460	10	20
E	73	71.8	15	5	8	0.2	0		OK	445	465	10	20
E	74	73.1	20	5	1.5	0.2	0.2	La:0.1, Ca:0.1	OK	475	495	10	20
E	75	69.1	25	4	1.5	0.2	0.2	Ce:0.2	OK	488	508	10	40
C	76	62.8	25	5	7	0.2	0		OK	488	508	40	40

E	77	57.8	30	5	7	0.2	0		OK	510	530	10	40
E	78	48.8	40	5	6	0.2	0		OK	555	575	10	40
E	79	38.5	50	4	7	0.2	0.3	Cr:0.1, Cu:0.2	OK	565	585	10	40
E	80	27.8	60	5	7	0.2	0		OK	573	593	10	40
C	81	27.8	62	5	5	0.2	0		OK	575	595	10	40
E	82	77.3	15	6	1.5	0.2	0		OK	445	465	10	40
E	83	71.3	20	7	1.5	0.2	0		OK	475	495	10	40
E	84	67.3	25	6	1.5	0.2	0		NG	488	508	10	40
C	85	64.8	25	6	4	0.2	0		OK	488	508	40	40
C	86	63.5	25	6	5	0.2	0.3	Y:0.2, Sb:0.1	NG	488	508	10	40
E	87	58.8	30	6	5	0.2	0		NG	510	530	10	40
E	88	48.8	40	7	4	0.2	0		NG	555	575	10	40
E	89	36.6	50	7	6	0.2	0.2	Sr:0.2	NG	565	585	10	40
E	90	26.8	60	6	7	0.2	0		OK	573	593	10	40
C	91	74.8	14	6	5	0.2	0		NG	575	595	10	40
E	92	69.6	15	7	8	0.2	0.2	Mn:0.1, Ni:0.1	OK	445	465	10	40
E	93	63.8	20	7	9	0.2	0		OK	475	495	10	40
E	94	54.8	25	8	12	0.2	0		OK	488	508	10	40

C	95	59.8	25	8	7	0.2	0		OK	488	508	20	20
E	96	52.6	30	8	9	0.2	0.2	Co:0.1, Ti:0.1	OK	510	530	10	40
E	97	36.8	40	8	15	0.2	0		OK	555	575	10	40
E	98	23.8	50	8	18	0.2	0		OK	565	585	10	40
E	99	11.8	60	8	20	0.2	0		OK	573	593	10	40
C	100	12.8	60	9	18	0.2	0		OK	573	593	10	40
C	101	Commercial Zn- coated steel sheet											
	102	Alloyed Zn-coated steel sheet											
	103	ElectroZn-coated steel sheet											

[0107]

[Table 1-3]

Table 1-3

Class	No.	Structural constitution of coating layer						
		Laminar phase containing structure	Dendritic structure	Zn/Al/MgZn ₂ ternary eutectic structure	Massive MgZn ₂ phase		Massive Zn phase	
		Area fraction (%)	Area fraction (%)	Area fraction (%)	Equivalent circle	Area fraction	Equivalent circle	Area fraction

					diameter (μm)	(%)	diameter (μm)	(%)
C	1	54	28	0	-	0	4	18
C	2	40	36	0	-	0	5	24
E	3	47	36	0	-	0	8	17
E	4	47	38	0	-	0	8	15
E	5	45	35	0	-	0	4	20
C	6	4	37	0	-	0	2	19
E	7	39	45	0	-	0	5	16
C	8	51	38	0	-	0	4	11
E	9	28	56	0	-	0	4	10
E	10	28	61	0	-	0	11	11
E	11	29	62	0	-	0	5	9
E	12	26	64	0	-	0	4	10
C	13	0	60	0	-	0	8	13
E	14	23	69	0	-	0	3	8
E	15	24	68	0	-	0	3	8
E	16	24	71	0	-	0	7	5
C	17	2	68	25	-	0	2	5
E	18	23	72	0	-	0	5	5
E	19	17	80	0	-	0	7	3

E	20	5	95	0	-	0	-	0	-	0
C	21	4	96	0	-	0	-	0	-	0
C	22	59	34	0	-	0	-	0	5	7
E	23	65	35	0	-	0	-	0	-	0
C	24	0	42	39	-	13	-	2	6	
E	25	55	45	0	-	0	-	0	-	0
E	26	39	60	1	-	0	-	0	-	0
E	27	35	65	0	-	0	-	0	-	0
C	28	0	54	44	-	0	-	3	2	
C	29	0	63	0	-	0	-	0	-	0
E	30	32	68	0	-	0	-	0	-	0
C	31	0	60	0	-	0	-	8	13	
E	32	30	70	0	-	0	-	0	-	0
E	33	25	72	0	-	0	-	0	-	0
E	34	26	74	0	-	0	-	0	-	0
C	35	33	67	0	-	0	-	0	-	0
E	36	30	70	0	-	0	-	0	-	0
E	37	29	71	0	-	0	-	0	-	0
E	38	27	72	0	-	0	-	2	1	
E	39	23	77	0	-	0	-	0	-	0
E	40	23	77	0	-	0	-	0	-	0

E	41	22	77	0	-	0	1	1	1
E	42	11	89	0	-	0	-	-	0
E	43	5	95	0	-	0	-	-	0
C	44	2	98	0	-	0	-	-	0
C	45	5	93	0	-	0	-	-	0
C	46	60	33	0	-	0	2	7	7
E	47	61	36	0	1	2	-	-	1
E	48	35	65	0	-	0	-	-	0
C	49	50	40	0	-	0	3	10	10

[0108]

[Table 1-4]

Table 1-4

Class	No.	Structural constitution of coating layer						
		Laminar phase containing structure	Dendritic structure	Zn/Al/MgZn ₂ ternary eutectic structure	Massive MgZn ₂ phase		Massive Zn phase	
		Area fraction (%)	Area fraction (%)	Area fraction (%)	Equivalent circle diameter (μm)	Area fraction (%)	Equivalent circle diameter (μm)	Area fraction (%)

E	50	25	58	0	-	0	4	9
E	51	29	71	0	-	0	-	0
E	52	25	74	0	1	1	-	0
C	53	0	60	0	-	0	8	13
E	54	24	73	0	1	2	-	0
E	55	20	77	0	2	3	-	0
E	56	9	87	0	2	4	-	0
E	57	5	92	0	1	3	-	0
C	58	5	95	0	-	0	-	0
E	59	60	35	0	1	5	-	0
E	60	50	49	0	2	1	-	0
E	61	31	65	0	2	4	-	0
E	62	29	60	0	2	9	-	0
E	63	25	70	0	-	0	-	0
E	64	37	61	0	2	2	-	0
C	65	0	60	0	-	0	8	13
E	66	32	68	0	-	0	-	0
E	67	29	71	0	-	0	-	0
E	68	27	72	0	1	1	-	0
E	69	23	73	0	2	4	-	0
E	70	5	92	0	2	3	-	0

C	71	3	97	0	-	0	-	0
C	72	55	37	0	2	8	-	0
E	73	57	35	0	4	8	-	0
E	74	42	51	0	3	7	-	0
E	75	38	55	0	3	7	-	0
C	76	0	75	0	2	0	-	0
E	77	31	61	0	2	8	-	0
E	78	24	69	0	5	7	-	0
E	79	6	84	0	2	8	-	0
E	80	5	86	0	2	9	-	0
C	81	3	88	0	3	9	-	0
E	82	60	29	0	1	11	-	0
E	83	50	39	0	2	11	-	0
E	84	36	52	0	2	12	-	0
C	85	0	65	0	5	11	-	0
C	86	29	62	0	5	9	-	0
E	87	27	61	0	6	12	-	0
E	88	22	67	0	8	11	-	0
E	89	6	78	0	8	14	-	0
E	90	5	82	1	8	12	-	0
C	91	51	38	0	5	11	-	0

E	92	53	30	0	9	17	-	0
E	93	47	39	0	5	14	-	0
E	94	32	51	0	9	17	-	0
C	95	0	59	0	11	15	-	0
E	96	25	56	0	8	19	-	0
E	97	22	59	0	4	19	-	0
E	98	6	72	0	12	20	-	0
E	99	5	75	0	15	20	-	0
C	100	5	70	0	15	25	-	0
C	101	Commercial Zn-coated steel sheet						
	102	Alloyed Zn-coated steel sheet						
	103	ElectroZn-coated steel sheet						

[0109]

[Table 1-5]

Table 1-5

Class	No.	Structural constitution of coating layer				Interfacial alloy layer
		Zn phase +plate-like Mg ₂ Sn phase	Sn phase	Si phase	Mg ₂ Si phase	Other phase

		Area fraction (%)	Equivalent circle diameter (μm)	Area fraction (%)	Equivalent circle diameter (μm)	Area fraction (%)	Equivalent circle diameter (μm)	Area fraction (%)	Area fraction (%)	Thickness (μm)
C	1	0	-	0	-	0	-	0	0	0.3
C	2	0	-	0	-	0	-	0	0	0.3
E	3	0	-	0	-	0	-	0	0	0.3
E	4	0	-	0	-	0	-	0	0	0.3
E	5	0	-	0	-	0	-	0	0	0.3
C	6	40	-	0	-	0	-	0	0	0.5
E	7	0	-	0	-	0	-	0	0	0.6
C	8	0	-	0	-	0	-	0	0	1.7
E	9	0	1	6	-	0	-	0	0	0.2
E	10	0	-	0	-	0	-	0	0	0.5
E	11	0	-	0	-	0	-	0	0	0.4
E	12	0	-	0	-	0	-	0	0	0.3
C	13	27	-	0	-	0	-	0	0	0.3
E	14	0	-	0	-	0	-	0	0	0.2
E	15	0	-	0	-	0	-	0	0	0.2
E	16	0	-	0	-	0	-	0	0	0.8
C	17	0	-	0	-	0	-	0	0	0.4

E	18	0	-	0	-	0	-	0	0	0	0.7
E	19	0	-	0	-	0	-	0	0	0	1.2
E	20	0	-	0	-	0	-	0	0	0	1.1
C	21	0	-	0	-	0	-	0	0	0	1.8
C	22	0	-	0	-	0	-	0	0	0	0.2
E	23	0	-	0	-	0	-	0	0	0	0.1
C	24	0	-	0	-	0	-	0	0	0	0.4
E	25	0	-	0	-	0	-	0	0	0	0.1
E	26	0	-	0	-	0	-	0	0	0	0.2
E	27	0	-	0	-	0	-	0	0	0	0.1
C	28	0	-	0	-	0	-	0	0	0	0.2
C	29	37	-	0	-	0	-	0	0	0	0.4
E	30	0	-	0	-	0	-	0	0	0	0.1
C	31	27	-	0	-	0	-	0	0	0	0.1
E	32	0	-	0	-	0	-	0	0	0	0.3
E	33	0	1	3	-	0	-	0	0	0	0.5
E	34	0	-	0	-	0	-	0	0	0	0.6
C	35	0	-	0	-	0	-	0	0	0	1.7
E	36	0	-	0	-	0	-	0	0	0	0.9
E	37	0	-	0	-	0	-	0	0	0	0.9
E	38	0	-	0	-	0	-	0	0	0	1.1

E	39	0	-	0	-	0	-	0	0	0	1
E	40	0	-	0	-	0	-	0	0	0	1
E	41	0	-	0	-	0	-	0	0	0	1.1
E	42	0	-	0	-	0	-	0	0	0	1.2
E	43	0	-	0	-	0	-	0	0	0	1.4
C	44	0	-	0	-	0	-	0	0	0	2
C	45	0	-	0	1	0	-	0	0	0	0.1
C	46	0	-	0	-	0	-	0	0	0	0.3
E	47	0	-	0	-	0	-	0	0	0	0.2
E	48	0	-	0	-	0	-	0	0	0	0.1
C	49	0	-	0	-	0	-	0	0	0	1.9

[0110]

[Table 1-6]

Table 1-6

Class	No.	Structural constitution of coating layer					Interfacial alloy layer
		Zn phase +plate-like Mg ₂ Sn phase	Sn phase	Si phase	Mg ₂ Si phase	Other phase	

		Area fraction (%)	Equivalent circle diameter (μm)	Area fraction (%)	Equivalent circle diameter (μm)	Area fraction (%)	Equivalent circle diameter (μm)	Area fraction (%)	Thickness (μm)
E	50	0	1	8	-	0	-	0	0.2
E	51	0	-	0	-	0	-	0	0.1
E	52	0	-	0	-	0	-	0	0.3
C	53	27	-	0	-	0	-	0	0.3
E	54	0	-	0	-	0	1	0	0.5
E	55	0	-	0	-	0	-	0	0.9
E	56	0	-	0	-	0	-	0	0.8
E	57	0	-	0	-	0	-	0	1.3
C	58	0	-	0	-	0	-	0	2.1
E	59	0	-	0	-	0	-	0	0.1
E	60	0	-	0	-	0	-	0	0.2
E	61	0	-	0	-	0	-	0	0.5
E	62	0	2	2	-	0	-	0	0.5
E	63	0	1	5	-	0	-	0	0.5
E	64	0	-	0	-	0	-	0	0.2
C	65	27	-	0	-	0	-	0	0.2
E	66	0	-	0	-	0	-	0	0.3

E	67	0	-	0	-	0	-	0	-	0	0	0.8
E	68	0	-	0	-	0	-	0	-	0	0	0.9
E	69	0	-	0	-	0	-	0	-	0	0	1.5
E	70	0	-	0	-	0	-	0	-	0	0	1.3
C	71	0	-	0	-	0	-	0	-	0	0	2.2
C	72	0	-	0	-	0	-	0	-	0	0	0.3
E	73	0	-	0	-	0	-	0	-	0	0	0.1
E	74	0	-	0	-	0	-	0	-	0	0	0.2
E	75	0	-	0	-	0	-	0	-	0	0	0.2
C	76	25	-	0	-	0	-	0	-	0	0	0.7
E	77	0	-	0	-	0	-	0	-	0	0	0.3
E	78	0	-	0	-	0	-	0	-	0	0	1.3
E	79	0	-	0	-	0	-	0	1	2	0	1.4
E	80	0	-	0	-	0	-	0	-	0	0	1.3
C	81	0	-	0	-	0	-	0	-	0	0	1.7
E	82	0	-	0	-	0	-	0	-	0	0	0.1
E	83	0	-	0	-	0	-	0	-	0	0	0.2
E	84	0	-	0	-	0	-	0	-	0	0	0.2
C	85	24	-	0	-	0	-	0	-	0	0	0.7
C	86	0	-	0	-	0	-	0	-	0	0	0.2
E	87	0	-	0	-	0	-	0	-	0	0	0.3

E	88	0		-	0	-	0	-	0	0	0	1.3
E	89	0		-	0	-	0	1	2	0	0	1.4
E	90	0		-	0	-	0	-	0	0	0	1.3
C	91	0		-	0	-	0	-	0	0	0	0.3
E	92	0		-	0	-	0	-	0	0	0	0.1
E	93	0		-	0	-	0	-	0	0	0	0.2
E	94	0		-	0	-	0	-	0	0	0	0.2
C	95	26		-	0	-	0	-	0	0	0	0.7
E	96	0		-	0	-	0	-	0	0	0	0.3
E	97	0		-	0	-	0	-	0	0	0	1.3
E	98	0		-	0	-	0	1	2	0	0	1.4
E	99	0		-	0	-	0	-	0	0	0	1.3
C	100	0		-	0	-	0	-	0	0	0	1.5
C	101	Commercial Zn-coated steel sheet										
	102	Alloyed Zn-coated steel sheet										
	103	ElectroZn-coated steel sheet										

[0111]

[Table 1-7]

Table 1-7

Class	No.	Bending	Corrosion resistance after	Sacrificial corrosion protection	Resistance	Resistance
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		workability			painting				property				to chipping	to seizure
		2T	4T	6T	30 cycles	60 cycles	90 cycles	150 cycles	60 cycles	120 cycles	240 cycles	360 cycles		
C	1	C	C	C	B	B	C	D	B	B	C	D	B	D
C	2	B	B	B	B	B	B	C	B	B	B	C	A	D
E	3	B	B	B	A	A	A	B	A	A	A	B	A	B
E	4	B	B	B	A	A	A	B	A	A	A	B	A	B
E	5	B	B	B	A	A	A	B	A	A	A	B	A	B
C	6	C	C	C	A	A	B	C	A	A	B	C	B	B
E	7	A	A	A	A	A	A	B	A	A	A	B	A	B
C	8	D	D	D	C	C	D	D	C	C	D	D	D	A
E	9	A	A	A	A	B	C	D	A	B	C	D	A	A
E	10	A	A	A	A	A	A	B	A	A	A	B	A	B
E	11	A	A	A	A	A	A	B	A	A	A	B	A	B
E	12	A	A	A	A	A	A	B	A	A	A	B	A	A
C	13	C	C	C	A	A	B	C	A	A	B	C	B	A
E	14	A	A	A	A	A	A	B	A	A	A	B	A	A
E	15	A	A	A	A	A	A	B	A	A	A	B	A	A
E	16	A	A	A	A	A	A	B	A	A	A	B	A	A

C	17	D	D	D	C	C	C	D	D	C	D	D	B	A
E	18	A	A	A	A	A	A	A	A	A	A	B	A	A
E	19	A	A	A	A	A	A	A	A	A	B	B	A	A
E	20	A	A	A	A	A	A	B	B	A	B	B	A	A
C	21	C	C	C	A	A	A	B	C	A	B	C	C	A
C	22	C	C	C	B	B	B	C	D	B	C	D	B	D
E	23	B	B	B	A	A	A	A	A	A	A	A	A	B
C	24	D	D	D	C	C	C	D	D	C	D	D	B	A
E	25	A	A	A	A	A	A	A	A	A	A	A	A	A
E	26	A	A	A	A	A	A	A	A	A	A	A	A	A
E	27	A	A	A	A	A	A	A	A	A	A	A	A	A
C	28	D	D	D	C	C	C	D	D	C	D	D	B	A
C	29	C	C	C	A	A	A	B	C	A	B	C	B	B
E	30	A	A	A	A	A	A	A	A	A	A	A	A	A
C	31	C	C	C	A	A	A	B	C	A	B	C	B	A
E	32	A	A	A	A	A	A	A	A	A	A	A	A	A
E	33	A	A	A	A	A	B	C	D	A	C	D	A	A
E	34	A	A	A	A	A	A	A	B	A	A	B	A	A
C	35	C	C	C	A	A	A	B	C	A	B	C	C	A
E	36	A	A	A	A	A	A	A	B	A	A	B	A	A
E	37	A	A	A	A	A	A	A	A	A	A	B	A	A

E	38	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A
E	39	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A
E	40	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A
E	41	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A
E	42	A	A	A	A	A	A	A	A	B	B	A	A	B	B	A	A	A	A
E	43	A	A	A	A	A	A	A	B	B	B	A	A	B	B	A	A	A	A
C	44	C	C	C	C	C	A	A	B	C	C	A	A	B	C	C	A	A	A
C	45	C	C	C	C	C	B	C	C	D	B	B	B	C	D	A	A	A	A
C	46	C	C	C	C	C	B	C	C	D	B	B	C	C	D	B	D	D	D
E	47	B	B	B	A	A	A	A	A	A	A	A	A	A	A	A	A	B	B
E	48	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A
C	49	D	D	D	C	C	C	D	D	D	C	C	D	D	D	D	A	A	A

[0112]

[Table 1-8]

Table 1-8

Class	No.	Bending workability	Corrosion resistance after painting	Sacrificial corrosion protection property	Resistance to	Resistance to seizure
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		2T	4T	6T	30 cycles	60 cycles	90 cycles	150 cycles	60 cycles	120 cycles	240 cycles	360 cycles	chipping	
E	50	A	A	A	A	B	C	D	A	B	C	D	A	A
E	51	A	A	A	A	A	A	B	A	A	A	B	A	A
E	52	A	A	A	A	A	A	B	A	A	A	B	A	A
C	53	C	C	C	A	A	B	C	A	A	B	C	B	A
E	54	A	A	A	A	A	A	B	A	A	A	B	A	A
E	55	A	A	A	A	A	A	B	A	A	A	B	A	A
E	56	B	B	B	A	A	B	B	A	A	B	B	A	A
E	57	A	A	A	A	A	B	B	A	A	B	B	A	A
C	58	C	C	C	A	A	B	C	A	A	B	C	C	A
E	59	B	B	B	A	A	A	A	A	A	A	A	A	B
E	60	A	A	A	A	A	A	A	A	A	A	A	A	A
E	61	A	A	A	A	A	A	A	A	A	A	A	A	A
E	62	D	B	A	A	B	C	D	A	B	C	D	B	A
E	63	A	A	A	A	B	C	D	A	B	C	D	A	A
E	64	A	A	A	A	A	A	A	A	A	A	A	A	A
C	65	D	C	C	B	B	C	D	B	B	C	D	B	A
E	66	A	A	A	A	A	A	A	A	A	A	A	A	A
E	67	A	A	A	A	A	A	A	A	A	A	A	A	A

E	89	D	B	A	A	A	A	B	B	B	A	A	A	A	A	A	A	A
E	90	D	B	A	A	A	A	B	B	B	A	A	A	A	A	A	A	A
C	91	D	C	B	B	B	B	C	D	D	B	B	B	B	B	B	D	D
E	92	D	B	A	A	A	A	A	A	A	A	A	A	A	A	A	B	B
E	93	D	B	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A
E	94	D	B	A	A	A	A	A	A	A	A	A	A	A	A	A	A	A
C	95	D	D	C	A	A	A	B	C	B	B	B	B	B	B	B	A	A
E	96	D	B	A	A	A	A	A	B	A	A	A	A	A	A	A	A	A
E	97	D	B	A	A	A	A	A	B	A	A	A	A	A	A	A	A	A
E	98	D	B	A	A	A	A	B	B	A	A	A	A	A	A	A	A	A
E	99	D	B	A	A	A	A	B	B	B	A	A	A	A	A	A	A	A
C	100	D	D	C	A	A	A	B	C	C	C	C	C	C	C	C	A	A
C	101	C	C	C	C	C	C	C	D	B	B	B	B	B	B	B	D	D
	102	D	D	D	C	D	D	D	D	D	D	D	D	D	D	D	A	A
	103	B	B	B	C	C	C	C	D	C	C	C	C	C	C	C	D	D

[0113] The following measurements and evaluations were carried out for the coated steel sheets produced in the respective examples, which are summarized in Table 1 above.

[0114] - Measurement of Area Fraction of Each Structure -

The area fractions of the following structures of the coating layer of the obtained coated steel sheet were measured according to the method described above.

- Laminar Mg_2Sn phase-containing structure (denoted as "laminar phase-containing structure" in the Table)

- Dendritic structure

- Zn/Al/ $MgZn_2$ ternary eutectic structure

- Massive $MgZn_2$ phase with an equivalent circle diameter of 1 μm or more

- Massive Zn phase with an equivalent circle diameter of 2 μm or more

- Plate-like Mg_2Sn phase-containing structure in which a plate-like Mg_2Sn phase is mixed in a Zn phase (denoted as "Zn phase + plate-like Mg_2Sn phase" in the Table)

- Sn phase

- Si phase

- Mg_2Si phase

- Intermetallic compound phase other than the above structures (denoted as "other phase" in the Table)

[0115] - Measurement of Average Equivalent Circle Diameter of Each Structure -

The average equivalent circle diameters of the following structures of the coating layer of the obtained coated steel sheet were measured according to the method described above. In this regard, in Table 1, the average equivalent circle diameter is denoted as "equivalent circle diameter".

- Massive $MgZn_2$ phase with an equivalent circle diameter of 1 μm or more

- Massive Zn phase with an equivalent circle diameter of 2 μm or more

- Sn phase

- Si phase

- Mg_2Si phase

[0116] - Measurement of Thickness of Interfacial Alloy Layer -

The thickness of the interfacial alloy layer of the obtained coated steel sheet was measured according to the method described above.

[0117] - Average Thickness and Area Fraction of Laminar $MgSn$ Phase of Laminar Mg_2Sn Phase-containing Structure -

An SEM backscattered electron image (BSE image) of No. 26 shown in Table 1 was

obtained. The SEM backscattered electron image (BSE image) of No. 26 shown in Table 1 is shown in FIG. 1 and FIG. 2. As apparent from FIG. 1, the coating layer 1 was mainly constituted with granular Mg_2Sn phase-containing structures 4 and dendritic structures 5. Then, the average thickness and the area fraction (the area fraction of the laminar Mg_2Sn phase with respect to the laminar Mg_2Sn phase-containing structure (that is, the Zn phase and the laminar Mg_2Sn phase) of a laminar Mg_2Sn phase 7 formed in the laminar Mg_2Sn phase-containing structure 4 shown in FIG. 2 were examined.

Similarly, for other samples, the average thickness and the area fraction of the laminar Mg_2Sn phase were examined. As a result, typical numerical values of the average thickness and the area fraction of the laminar Mg_2Sn phase formed in the laminar Mg_2Sn phase-containing structure were as shown in the following Table 2.

[0118]

[Table 2]

Thickness (nm)	Area fraction (%)
40	10
50	25
80	30
75	45
100	36
150	40
200	45

[0119] - Bending Workability -

Evaluation of the bending workability of the coating layer was performed as follows.

From the obtained coated steel sheet, a test piece of 30 mm in C direction x 60 mm in L direction (L) was cut out. The test piece was bent by 180° in the C direction (1T bending), and the crest of the worked part of the coating layer was observed with an SEM, and the number of cracks present at the crest ($1.6 \text{ mm} \times 30 \text{ mm}$) was counted.

A test piece in which four test pieces with the same thickness were sandwiched inside, and a test piece in which six test pieces with the same thickness were sandwiched inside were respectively bent in the C direction by 180° (6T bending and 6T bending). Similarly, the numbers of cracks were counted.

In this regard, at least three samples of each coated steel sheet were prepared, and the bending workability was evaluated by calculating the average number of the existing cracks. It can be so evaluated that the smaller average number of the cracks indicates the better plastic

deformability and therefore the better bending workability.

The rating criteria were: in a case where the average number of crack was 0, namely there was no crack, it was rated as "A"; in a case where the average number of cracks was from 1 to 20, it was rated as "B"; in a case where the average number of cracks was from 21 to 100, it was rated as "C"; and in a case where the average number of cracks was 101 or more, it was rated as "D".

[0120] - Evaluation of Corrosion Resistance after Painting -

Evaluation of the corrosion resistance after painting of the coating layer was performed as follows.

From the obtained coated steel sheet, a test piece of 50 mm in C direction × 100 mm in L direction was cut out. A Zn phosphoric acid treatment (SD5350 system: Specifications of Nipponpaint Industrial Coatings Co., Ltd.) was applied to the surface of the coating layer of the test piece.

Next, a 20 μm-thick paint film was formed on the Zn phosphoric acid-treated surface of the coating layer of the test piece by electropainting (PN110 POWERNIX Gray: Specifications of Nipponpaint Industrial Coatings Co., Ltd.), and baked at a baking temperature of 150°C for 20 min to form an electrodeposited film.

Next, cross cuts (two cuts of $40 \times \sqrt{2}$) reaching the steel substrate (steel sheet) were made in the electrodeposited film of the test piece.

The obtained test piece was subjected to a combined cyclic corrosion test according to JASO (M609-91). And the maximum blistering widths at 8 positions around the cross cuts respectively after execution of 30, 60, 90, and 150 cycles were measured, and the average value was calculated.

The corrosion resistance after painting was rated by this blistering width. The rating criteria were: respectively after execution of 30, 60, 90, and 150 cycles according to JASO (M609-91), in a case where the blistering width from the cross cut was 1 mm or less, it was rated as "A"; in a case where the same was more than 1 mm but not more than 2 mm, it was rated as "B"; in a case where the same was more than 2 mm but not more than 4 mm, it was rated as "C"; and in a case where red rust appeared, it was rated as "D".

[0121] - Evaluation of Corrosion Resistance after Painting -

Evaluation of the sacrificial corrosion protection property of the coating layer was performed as follows.

From the obtained coated steel sheet, a test piece of 50 mm in C direction x 100 mm in L direction was cut out. A Zn phosphoric acid treatment (SD5350 system: Specifications of Nipponpaint Industrial Coatings Co., Ltd.) was applied to the surface of the coating layer

of the test piece.

Next, electropainting (PN110 POWERNIX Gray: Specifications of Nipponpaint Industrial Coatings Co., Ltd.) was performed at 20 μm on the Zn phosphoric acid-treated surface of the coating layer of the test piece and the film was baked at a baking temperature of 150°C for 20 min to form an electrodeposited film.

Next, cross cuts (two cuts of $40\times\sqrt{2}$) reaching the steel substrate were made in the electrodeposited film of the test piece.

The obtained test piece was subjected to a combined cyclic corrosion test according to JASO (M609-91). And the erosion depth of the steel substrate was measured with a micrometer after each test of 30, 60, 90, or 150 cycles and the average value was calculated.

The corrosion resistance after painting was rated by this erosion depth. The rating criteria were: respectively after execution of 60, 120, 240, and 360 cycles according to JASO (M609-91), in a case where the erosion depth from the cross cut was less than 0.1 mm, it was rated as "A"; in a case where the same was not less than 0.1 mm but less than 0.3 mm, it was rated as "B"; in a case where the same was not less than 0.3 mm but less than 0.4 mm, it was rated as "C"; and in a case where the same was not less than 0.4 mm, it was rated as "D".

[0122] - Evaluation of Resistance to Chipping -

Evaluation of the resistance to chipping of a coating layer was performed as follows.

A test piece with a coating layer, which surface was provided with an electrodeposition coating, was prepared in the same manner as in the evaluation of corrosion resistance after painting. On the electrodeposition coating surface, further intermediate painting, top coat painting, and clear painting were conducted to form the respective paint films, such that the total film thickness became 40 μm .

Using a Gravel Test Instrument (manufactured by Suga Test Instruments Co., Ltd.) 100 g of No.7 crushed stone was blasted against the paint film of the test piece cooled to -20°C at a collision angle of 90° with an air pressure of 3.0 kg/cm^2 from a distance of 30 cm. Then detached regions of the coating layer in the collided area were exposed using an adhesive tape, and the diameters of the detached regions were measured. The top five largest detachment diameters were selected and the average value thereof was regarded as the average detachment diameter.

The resistance to chipping was evaluated by this average detachment diameter. The smaller average detachment diameter means the better resistance to chipping.

The rating criteria were: in a case where the average detachment diameter was less than 1.0 mm, it was rated as "A"; in a case where the average detachment diameter was not less than 1.0 mm but less than 1.5 mm, it was rated as "B"; in a case where the average

detachment diameter was not less than 1.5 mm but less than 3.0, it was rated as "C"; and in a case where the average detachment diameter was not less than 3.0 mm, it was rated as "D".

[0123] - Evaluation of Resistance to Seizure -

Evaluation of the resistance to seizure of a coating layer was performed as follows.

Each two test pieces of 80 mm in the C direction and 350 mm in the L direction were cut out from the obtained coated steel sheet. A draw-bead working was applied to the two test pieces using jigs that simulate a die and a bead, such that sliding occurred over the length of 150 mm or more between the coating forming layer forming surface of the test piece and the die shoulder as well as the bead portion. In this case, the radii of curvature of the die shoulder and the bead portion, which were used as jigs in the test, were 2 mmR and 5 mmR respectively, the pushing pressure of the die was 60 kN/m^2 , and the drawing rate in the draw-bead working was 2 m/min. Further, at the time of the test, a lubricating oil (550S, produced by Nihon Parkerizing Co., Ltd.) was applied on to both the surfaces of the test piece at, in total, 10 mg/m^2 .

[0124] Then, each two primary test pieces of 80 mm wide $\times$ 350 mm long were sampled, and a draw-bead working was applied to them using jigs that simulate a die and a bead, such that sliding occurred over the length of 150 mm or more between a surface treated surface of the steel sheet and the die shoulder as well as the bead portion for evaluation of the resistance to seizure. In this case, the radii of curvature of the die shoulder and the bead portion, which were used as jigs in the test, were 2 mmR and 5 mmR respectively, the pushing pressure of the die was 60 kN/m^2 , and the drawing rate in the draw-bead working was 2 m/min. Further, at the time of the test, a lubricating oil (550S, produced by Nihon Parkerizing Co., Ltd.) was applied on to both the surfaces of the test piece at, in total, 0.5 g/m^2 .

The rating criteria were: in a case where there was no visually recognizable seizure between the coating layer and the die or bead, it was rated as "A"; in a case where there was visually recognizable mild seizure between the coating layer and the die or bead, it was rated as "B"; and in a case where there was visually recognizable significant seizure between the coating layer and the die or bead, it was rated as "D".

Reference Signs List

- | | | |
|--------|---|---|
| [0125] | 1 | Coating layer |
| | 2 | Steel sheet |
| | 3 | Interfacial alloy layer |
| | 4 | Laminar Mg_2Sn phase-containing structure |
| | 5 | Dendritic structure |
| | 6 | Zn phase |

- 7 Laminar Mg_2Sn phase
- 8 $\text{Zn}/\text{Al}/\text{MgZn}_2$ ternary eutectic structure
- 9 Massive Zn phase
- 10 Massive MgZn_2 phase
- 11 Structure in which plate-like Mg_2Sn phase is mixed in Zn phase
- 20 Zn phase in $\text{Zn}/\text{Al}/\text{MgZn}_2$ ternary eutectic structure
- 21 MgZn_2 phase in $\text{Zn}/\text{Al}/\text{MgZn}_2$ ternary eutectic structure
- 22 Al phase in $\text{Zn}/\text{Al}/\text{MgZn}_2$ ternary eutectic structure

[0126] The disclosure of Japanese Patent Application 2017-053148 is incorporated herein by reference in its entirety.

All the literature, patent application, and technical standards cited herein are also herein incorporated to the same extent as provided for specifically and severally with respect to an individual literature, patent application, and technical standard to the effect that the same should be so incorporated by reference.

CLAIMS

[Claim 1]

A coated steel sheet comprising a steel sheet and a coating layer provided on at least a part of a surface of the steel sheet, wherein:

the coating layer has a chemical composition comprising in terms of % by mass:

Al: from 15% to 60%
Mg: from 0.5% to 8.0%
Sn: from 0.5% to 20.0%
Si: from 0.05% to 1.50%
Bi: from 0% to 5.0%,
In: from 0% to 2.0%,
Ca: from 0% to 3.0%,
Y: from 0% to 0.5%,
La: from 0% to 0.5%,
Ce: from 0% to 0.5%,
Cr: from 0% to 0.25%,
Ti: from 0% to 0.25%,
Ni: from 0% to 0.25%,
Co: from 0% to 0.25%,
V: from 0% to 0.25%,
Nb: from 0% to 0.25%,
Cu: from 0% to 0.25%,
Mn: from 0% to 0.25%,
Sr: from 0% to 0.5%,
Sb: from 0% to 0.5%,
Pb: from 0% to 0.5%,
B: from 0% to 0.5%, and

a balance consisting of Zn and impurities, wherein:

the coating layer has a laminar Mg_2Sn phase-containing structure in an area fraction of from 5 to 65%, and a structure containing a solid solution of Zn and Al, and

the laminar Mg_2Sn phase-containing structure is a structure constituted with a Zn phase and a laminar Mg_2Sn phase having a thickness of less than 1 μm , and wherein the laminar Mg_2Sn phase exists dividing the Zn phase into a plurality of regions.

[Claim 2]

The coated steel sheet according to claim 1, wherein a content of Mg is from 0.5% to 3.0%, and a content of Sn is from 1.0% to 7.5% in terms of % by mass.

[Claim 3]

The coated steel sheet according to claim 1 or 2, wherein a content of Al is from 20% to 60%, a content of Mg is from 1.0% to 2.0%, a content of Sn is from 1.0% to 5.0%, and a content of Si is from 0.05% to 1.0% in terms of % by mass.

[Claim 4]

The coated steel sheet according to any one of claims 1 to 3, wherein a content of Sn and a content of Mg satisfy the following Formula (1):

$$\text{Mg} \leq \text{Sn} \leq 2.5 \times \text{Mg} \quad \text{Formula (1)}$$

wherein, in Formula (1), each atomic symbol indicates a content of the element in terms of % by mass.

[Claim 5]

The coated steel sheet according to any one of claims 1 to 4, wherein the area fraction of the laminar Mg_2Sn phase-containing structure is from 20% to 60%.

[Claim 6]

The coated steel sheet according to any one of claims 1 to 5, wherein the area fraction of the laminar Mg_2Sn phase-containing structure is from 30% to 60%.

[Claim 7]

The coated steel sheet according to any one of claims 1 to 6, wherein an area fraction of the structure containing a solid solution of Zn and Al is from 35% to 95%.

[Claim 8]

The coated steel sheet according to any one of claims 1 to 7, wherein the coating layer has a massive MgZn_2 phase with an equivalent circle diameter of 1 μm or more in an area fraction of from 0% to 20%.

[Claim 9]

The coated steel sheet according to any one of claims 1 to 8, wherein the coating

layer has a massive MgZn_2 phase with an equivalent circle diameter of 1 μm or more in an area fraction of from 0% to 5%.

[Claim 10]

The coated steel sheet according to any one of claims 1 to 9, wherein the coating layer has a massive Zn phase with an equivalent circle diameter of 2 μm or more in an area fraction of from 0% to 20%.

[Claim 11]

The coated steel sheet according to any one of claims 1 to 10, wherein the coating layer has a massive Zn phase with an equivalent circle diameter of 2 μm or more in an area fraction of from 0% to 10%.

[Claim 12]

The coated steel sheet according to any one of claims 1 to 11, further comprising an interfacial alloy layer with a thickness of from 100 nm to 1.5 μm consisting of an Al-Fe intermetallic compound between the steel sheet and the coating layer.