



# UL 870

## STANDARD FOR SAFETY

Wireways, Auxiliary Gutters, and  
Associated Fittings

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UL Standard for Safety for Wireways, Auxiliary Gutters, and Associated Fittings, UL 870

Ninth Edition, Dated March 3, 2016

### **Summary of Topics**

***This revision of ANSI/UL 870 dated November 29, 2023 is being issued to update the title page to reflect the most recent designation as a Reaffirmed American National Standard (ANS). No technical changes have been made.***

Text that has been changed in any manner or impacted by ULSE's electronic publishing system is marked with a vertical line in the margin.

The requirements are substantially in accordance with Proposal(s) on this subject dated October 13, 2023.

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## **UL 870**

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The Department of Defense (DoD) has adopted UL 870 on April 14, 1987. The publication of revised pages or a new edition of this Standard will not invalidate the DoD adoption.

Comments or proposals for revisions on any part of the Standard may be submitted to ULSE at any time. Proposals should be submitted via a Proposal Request in the Collaborative Standards Development System (CSDS) at <https://csds.ul.com>.

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## INTRODUCTION

### 1 Scope

1.1 These requirements cover wireways, auxiliary gutters, and associated fittings to be employed in accordance with the National Electrical Code, NFPA 70.

1.2 These requirements do not cover rigid or flexible conduit, surface raceways, underfloor raceways, nor other products of a similar nature that are covered by individual requirements.

### 2 Glossary

2.1 For the purpose of this standard the following definitions apply.

2.2 ACCESSIBLE EDGES – Edges that are subject to contact by persons installing, using or maintaining the product.

2.3 ASSOCIATED FITTING – A part that is used in the assembly of a complete wireway system, such as an elbow, tee, cross, end closer, or hanger.

2.4 AUXILIARY GUTTER – A section of wireway used to supplement the wiring space at a distribution center, switchboard, or similar location in a wiring system.

2.5 WIREWAY, METAL – A sheet-metal trough with a hinged or removable cover for housing and protecting electric wires and cables and in which conductors are laid in place after the wireway system has been installed as a complete system.

2.6 WIREWAY, NONMETALLIC – A flame-retardant, nonmetallic trough with removable covers for housing and protecting electric wires and cables in which conductors are laid in place after the wireway has been installed as a complete system.

### 3 Units of Measurement

3.1 If a value for measurement is followed by a value in other units in parentheses, the first stated value is the requirement. The second value may be only approximate.

### 4 Undated References

4.1 Any undated reference to a code or standard appearing in the requirements of this standard shall be interpreted as referring to the latest edition of that code or standard.

## CONSTRUCTION

### 5 General

5.1 Construction requirements identified for wireways, auxiliary gutters and associated fittings apply to both nonmetallic and metal devices, unless specifically noted.

5.2 Wireways, auxiliary gutters, and associated fittings shall employ materials that are acceptable for the particular use, and shall be made and finished with the degree of uniformity and grade of workmanship practicable in a well-equipped factory.

5.3 A wireway system shall include all wireways and fittings required to make a complete installation in accordance with the National Electrical Code, ANSI/NFPA 70.

5.4 Unless otherwise noted, auxiliary gutters and fittings shall comply with all of the requirements for wireways.

5.5 Nonmetallic wireways, auxiliary gutters and fittings shall additionally comply with construction requirements in the Standard for Nonmetallic Surface Raceways and Fittings, UL 5A.

5.6 Wireways, auxiliary gutters and fittings marked for use with an environmental rating, including enclosure types, shall comply with the applicable requirements specified in the Standard for Enclosures for Electrical Equipment, Environmental Considerations, UL 50E.

5.7 Ferrous steel enclosures with an opening/openings for connection of a wiring system closed with a knockout (see [11.1](#)) shall comply with the UL 514A requirements for Strength of knockouts, (See 12.6) and Flat areas surrounding knockouts, (See 12.7).

## 6 Design

6.1 A metal wireway shall be constructed, such that the interconnection of sections, covers, and fittings will provide a rigid mechanical assembly and provide electrical conductivity complying with the requirements for the Electrical Continuity Test – Metal Wireways, Auxiliary Gutters, Covers, and Associated Fittings, Section [19](#).

6.2 A wireway shall be formed and assembled so that it will have the strength and rigidity necessary to resist the abuses to which it is likely to be subjected, without resulting in a risk of fire, electric shock, or injury to persons due to total or partial collapse with resulting damage to conductors, loosening or displacement of parts, or other serious defects.

6.3 The wireway and associated fittings shall be free from burrs and sharp corners or edges that may abrade the insulation on conductors or otherwise damage wiring or constitute a risk of injury to persons. Screws and bolts, however used, shall not project into the wireway unless sharp ends and threaded sections are covered or otherwise prevented from coming in contact with wires.

*Exception: A threaded section of a screw or bolt not having a sharp point need not be prevented from coming in contact with wires provided the screw or bolt does not project more than 1/32 in (0.8 mm) into the wireway.*

6.4 With reference to [6.3](#), a metal wireway and the associated metal fittings shall not have accessible edges that are sharp or pointed such that they constitute a risk of injury to persons in normal installation, maintenance and use. When considering sharp edges and points, all stages of the installation process must be considered.

*Exception No. 1: This requirement does not apply to accessible edges protected by guards or the use of handles to minimize access to sharp edges or points.*

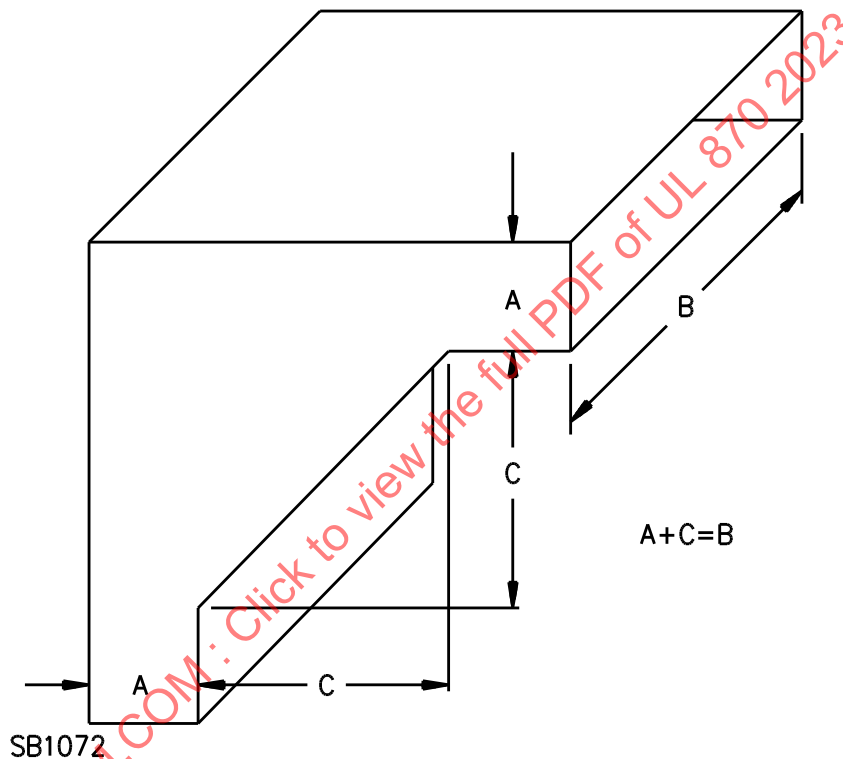
*Exception No. 2: This requirement does not apply to an accessible edge or portion of an accessible edge that is required to be sharp in order to perform a working function.*

*Exception No. 3: If sharp edges are present, but it is possible to avoid the hazard through proper procedures, then signs, labels or the manufacturer's instructions shall describe the procedure to avoid the hazard during installation, maintenance, and use.*

6.5 When determining compliance with [6.4](#), the Standard for Tests for Sharpness of Edges on Equipment, UL 1439, shall be used.

6.6 A flatwise elbow or tee or a similar fitting for a wireway having a rectangular cross section shall be of the sweep type; that is, such a fitting for a right-angle bend shall have the internal corner replaced by a diagonal wall – see [Figure 6.1](#) – to permit a larger bending radius for installed conductors. Sweep fittings may also be used in wireways of square cross section.

**Figure 6.1**  
**Flatwise sweep elbow**



6.7 In a flatwise sweep fitting for a wireway of rectangular cross section, dimension A plus dimension C (the length of leg cut off by the diagonal wall) shall be equal to or exceed dimension B. See [Figure 6.1](#).

6.8 For metal wireways, metal straps not less than 1/2-in (12.7-mm) wide and of the same thickness as the wireway, or metal rods not less than 1/4 inch (6.4 mm) in diameter may be provided at intervals across the width of the wireway to serve as wire-retaining means.

## 7 Conductor Size

7.1 The maximum conductor size for which a wireway is constructed is to be based on the bending space for conductors that enter or leave the wireway through connections in the sides or bottom in accordance with [Table 7.1](#).

**Table 7.1**  
**Conductor size based on bending space**

Smaller inside dimension of wireway <sup>a</sup>		Maximum conductor size	
in	(mm)	AWG or MCM	(mm <sup>2</sup> )
2	(50.8)	3	(26.7)
2-1/2	(63.5)	2	(33.6)
3	(76.2)	1	(42.4)
3-1/2	(88.9)	2/0	(67.4)
4	(102)	4/0	(107.2)
4-1/2	(114)	250	(127)
5	(127)	350	(177)
6	(152)	500	(253)
8	(203)	900	(456)
10	(254)	1250	(633)
12	(305)	2000	(1013)

<sup>a</sup> A minus tolerance of 1/8 in (3.2 mm) is allowed for manufacturing variations. The inside dimensions of the wireway are to be measured at a point where there is no fitting or fastening.

## 8 Material

### 8.1 Metal wireways, auxiliary gutters, and associated fittings

8.1.1 A wireway shall be of metal and shall be constructed to provide sufficient strength and rigidity so that the wireway will retain its shape and the covers will fit as intended.

8.1.2 In an auxiliary gutter, the use of insulating material to replace a portion of one wall of the auxiliary gutter where the wiring goes through meets the intent of the requirement in [8.1.1](#) when the insulating material and the assembly of the material to the auxiliary gutter supplies strength and rigidity equivalent to that of the auxiliary gutter without the substitution.

### 8.2 Nonmetallic wireways, auxiliary gutters, and associated fittings

8.2.1 The material used for nonmetallic wireways, auxiliary gutters, and associated fittings shall comply with the Standard for Nonmetallic Surface Raceways and Fittings, UL 5A.

8.2.2 In an auxiliary gutter, the use of insulating material to replace a portion of one wall of the auxiliary gutter where the wiring goes through meets the intent of the requirement in [8.2.1](#) when the insulating material and the assembly of the material to the auxiliary gutter supplies strength and rigidity equivalent to that of the auxiliary gutter without the substitution.

## 9 Thickness of Metal – Metal Wireways, Auxiliary Gutters, and Associated Fittings

9.1 A sheet-metal enclosure shall have a thickness not less than that specified in [Table 9.1](#). If a metal other than steel, aluminum, or copper is used, it shall be of sufficient thickness to provide strength and rigidity equivalent to that of steel in the thickness specified.

**Table 9.1**  
**Minimum acceptable thickness of sheet metal**

Maximum inside width of widest surface				Steel				Aluminum or copper	
More than		Not more than or equal to		Uncoated		Galvanized <sup>a</sup>			
in	(mm)	in	(mm)	in	(mm)	in	(mm)		
0	(0)	6	(152)	0.053	(1.35)	0.056	(1.42)	0.075	(1.91)
6	(152)	12	(305)	0.060	(1.52)	0.063	(1.60)	0.095	(2.41)
12	(305)	18	(457)	0.067	(1.70)	0.070	(1.78)	0.095	(2.41)
18	(457)	30	(762)	0.093	(2.36)	0.097	(2.46)	0.122	(3.10)
30	(762)	—	—	0.123	(3.12)	0.126	(3.20)	0.153	(3.89)

<sup>a</sup> See [16.8](#) for requirements for sheet steel that employs hot-dipped mill galvanized A60, G60, or G90 coatings.

## 10 Flanges and Reinforcing Strips – Metal Wireways, Auxiliary Gutters, and Associated Fittings

10.1 All seams, joints, or splices at a corner or a back edge of a wireway, or between abutting wireway sections or fittings shall be closed and reinforced by flanges formed of the material from which the wireway is made, or by separate strips, angles, or continuous welding so as to produce a construction substantially equivalent in strength to an integral flanged construction.

10.2 Reinforcing strips or angles shall have a thickness not less than that specified in [Table 10.1](#).

**Table 10.1**  
**Minimum acceptable thickness of sheet metal for reinforcing strips or angles**

Maximum inside width of widest surface			Steel				Aluminum or copper		
More than		Not more than or equal to	Uncoated		Galvanized				
in	(mm)	in	(mm)	in	(mm)	in	(mm)	in	(mm)
0	(0)	6	(152)	0.043	(1.09)	0.047	(1.19)	0.060	(1.52)
6	(152)	18	(457)	0.054	(1.37)	0.058	(1.47)	0.077	(1.96)
18	(457)	30	(762)	0.068	(1.73)	0.071	(1.80)	0.098	(2.49)
30	(762)	—	—	0.097	(2.46)	0.100	(2.54)	0.124	(3.15)

10.3 A flange, separate strip, or angle shall overlap at least 1/2 in (12.7 mm), and shall extend approximately the full length of the seam, joint, or splice.

10.4 A flange, separate strip, or angle at a seam, joint, or splice between abutting wireway sections or between a wireway section and an attached fitting shall have fastenings located not more than 1-1/2 in (38.1 mm) from each end of the seam and at points not more than 6 in (152 mm) apart between these end fastenings.

*Exception: A single fastening may be employed for a seam not more than 4-in (102-mm) long if it is located within 1/2 in (12.7 mm) of the center if in the bottom of the wireway, or between the center of the seam and the top if on the side of the wireway.*

10.5 With reference to [10.4](#) and its exception, if separate strips are employed, fastenings shall be provided on both sides of the seam.

10.6 Rivets, spot-welds, bolts, and screws are considered to be acceptable forms of fastenings. See also [6.1](#) and [15.1.1](#).

10.7 At least two full threads shall be provided in metal into which screws are to be threaded. Fastenings in sheet metal shall have a diameter at least fifty percent greater than the thickness of the finished sheet metal with which they are used.

10.8 Sheet metal may be extruded at a tapped hole to provide at least two full threads, if the thickness of the metal before extrusion is not less than the pitch of a single thread.

## 11 Openings in Enclosure – Metal Wireways, Auxiliary Gutters, and Associated Fittings

### 11.1 Connections for wiring systems

11.1.1 An opening for connection of a wiring system in a wireway intended for stock and not for a particular installation shall be closed with a knockout, cover, or plug having a thickness not less than 0.053 in (1.35 mm) if of uncoated steel, 0.056 in (1.42 mm) if of galvanized steel, and no less than 0.077 in (1.96 mm) if of aluminum or copper. The knockout, cover, or plug shall be so secured in place that it can be readily removed but will not be displaced with ordinary handling. For a raintight wireway see [17.2](#).

11.1.2 A hole or a knockout shall be located so that adequate space will be provided for the installation of a locknut, a conduit bushing, an armored-cable connector, or other similar fitting.

### 11.2 Other openings

11.2.1 An open hole or a slot shall not be provided unless it will be closed in the final assembly and installation of the wireway.

*Exception:* See [17.2](#) and [17.3](#).

## 12 Covers – Metal Wireways, Auxiliary Gutters, and Associated Fittings

12.1 A cover shall be provided with means for securely holding it in place on the trough.

12.2 Fastenings for a flat or flanged cover shall comply with the requirements in [10.7](#) and [10.8](#) for screws and tapped holes or nuts, and with the requirements in [12.3](#) for other types of fastenings. The fastenings shall be located not more than 6 in (152 mm) from each end of the cover and spaced not more than 12 in (305 mm) apart at points between the end fastenings.

*Exception: If the straps or rods mentioned in [6.8](#) are spaced not more than 30 in (762 mm) apart along the length of the wireway after assembly, a flat or flanged cover may be held by fastenings located not more than 6 in (152 mm) from each end of the cover and spaced not more than 24 in (160 mm) apart at points between these end fastenings.*

12.3 A fastening device other than a tapped hole or nut may be employed with a screw. A type of fastening other than a screw may be employed if it is of adequate strength and is otherwise suitable for the application.

12.4 Unless a cover complies with the requirements in [12.5](#), a hinged or screw-on cover shall have flanges that overlap the side walls of the trough not less than 7/16 in (11.1 mm) throughout the full length of the cover. The ends of such a cover shall:

- a) Be flanged or otherwise formed to overlap the trough at least 1/2 in (12.7 mm),

- b) Provide a 1/4-in (6.4-mm) rabbet, or
- c) Employ a construction affording an equivalent closure of the trough.

12.5 A flat, unhinged cover may be used if:

- a) Each side wall of the trough is flanged at right angles to the wall to overlap the cover not less than 1/2 in (12.7 mm),
- b) Each end of the cover forms a 1/4-in (6.4-mm) rabbet with the adjoining cover, and
- c) The cover is fastened to the trough as required by [12.2](#).

### 13 Hinges and Latches – Metal Wireways, Auxiliary Gutters, and Associated Fittings

13.1 A hinge for a door or cover shall be of metal not less than 0.054-in (1.37-mm) thick if made of steel, and not less than 0.077-in (1.96-mm) thick if made of copper or aluminum.

*Exception: A wireway cover may employ a continuous piano-type hinge made of steel not less than 0.047-in (1.2-mm) thick.*

13.2 Hinges shall not be spaced more than 24 in (610 mm) apart, measured center to center, and not more than 15 in (381 mm) from each end of the cover. At least two hinges shall be used for each cover.

*Exception: A single hinge that extends the full length of the cover may be used.*

13.3 A hinged door or cover shall be provided with at least one latch or the equivalent for each 30 in (762 mm) or less of cover length. Latches shall not be located more than 12 in (305 mm) from each end of the cover and shall be evenly spaced not more than 36 in (914 mm) apart at points between the end latches.

13.4 Latches shall be positive in action.

13.5 A screw fastening is considered to be equivalent to a latch.

13.6 A button latch consisting of a projection stamped on the edge of the trough and engaging a corresponding indentation in the cover flange is not acceptable.

13.7 A spring latch consisting of a strip of steel fastened to the wall of a trough and cooperating with a slot in the cover shall be formed and attached so that the latch engages the edge of the cover slot away from the trough wall.

13.8 An arrangement of hinges or latches, or both, that does not fully comply with the requirements in [13.1](#) – [13.5](#), may be acceptable if, when subjected to an appropriate investigation, it is found to provide the necessary mechanical strength and rigidity of the complete assembly.

### 14 Expansion Joints and Telescoping Sections – Metal Wireways, Auxiliary Gutters, and Associated Fittings

14.1 An expansion joint or telescoping section shall have the necessary mechanical strength to support the conductors that may be installed in it and shall be provided with one or more bonding conductors to provide electrical continuity.

*Exception: A telescoping section that can be made immovable at the time of installation by bolted fastenings equivalent to the fastenings required between straight lengths of wireway need not be provided with a bonding conductor.*

14.2 The size of the bonding conductors, or the total cross section of the conductors if two or more are in parallel, shall be in compliance with [Table 14.1](#).

*Exception: A smaller conductor may be used if the expansion joint or telescoping section is marked to indicate a maximum circuit ampere rating for which the smaller conductor is adequate in accordance with [Table 14.2](#). See [25.7](#).*

**Table 14.1**  
**Full-size bonding conductor**

Cross section of wireway				Minimum size of bonding conductor				Minimum cross section of bonding means			
More than		Not more than		Copper		Aluminum		Copper		EC aluminum	
in <sup>2</sup>	(cm <sup>2</sup> )	in <sup>2</sup>	(cm <sup>2</sup> )	AWG or MCM	(mm <sup>2</sup> )	AWG or MCM	(mm <sup>2</sup> )	in <sup>2</sup>	(cm <sup>2</sup> )	in <sup>2</sup>	(cm <sup>2</sup> )
—	—	4	(26)	3	(26.7)	1	(42.4)	0.041	(0.26)	0.068	(0.44)
4	(26)	6.25	(40.3)	1	(42.4)	2/0	(67.4)	0.068	(0.44)	0.104	(0.67)
6.25	(40.3)	9	(58)	1/0	(53.5)	3/0	(85.0)	0.083	(0.54)	0.138	(0.84)
9	(58)	11.11	(71.7)	2/0	(67.4)	4/0	(107.2)	0.104	(0.67)	0.166	(1.07)
11.11	(71.7)	20.25	(130.6)	4/0	(107.2)	350	(177)	0.166	(1.07)	0.274	(1.77)
20.25	(130.6)	25	(161)	350	(177)	500	(253)	0.274	(1.77)	0.393	(2.53)
25	(161)	36	(232)	400	(203)	600	(304)	0.314	(2.02)	0.471	(3.04)
36	(232)	64	(413)	700	(355)	1000	(507)	0.550	(3.55)	0.785	(5.06)
64	(413)	100	(645)	800	(405)	1200	(608)	0.628	(4.05)	0.942	(6.08)
100	(645)	144 <sup>a</sup>	(929)	800	(405)	1200	(608)	0.628	(4.05)	0.942	(6.08)

<sup>a</sup> it is assumed no circuit rating will exceed 6000 A.

**Table 14.2**  
**Reduced-size bonding conductor**

Maximum circuit ampere rating marked on wireway	Minimum size of bonding conductor			
	Copper		Aluminum	
A	AWG or MCM	(mm <sup>2</sup> )	AWG or MCM	(mm <sup>2</sup> )
15	14	(2.1)	12	(3.3)
20	12	(3.3)	10	(5.3)
30	10	(5.3)	8	(8.4)
40	10	(5.3)	8	(8.4)
60	10	(5.3)	8	(8.4)
100	8	(8.4)	6	(13.3)
200	6	(13.3)	4	(21.2)
400	3	(26.7)	1	(42.4)

Table 14.2 Continued on Next Page



Table 14.2 Continued

Maximum circuit ampere rating marked on wireway  A	Minimum size of bonding conductor			
	Copper		Aluminum	
	AWG or MCM	(mm <sup>2</sup> )	AWG or MCM	(mm <sup>2</sup> )
600	1	(42.4)	2/0	(67.4)
800	1/0	(53.5)	3/0	(85.0)
1000	2/0	(67.4)	4/0	(107.2)
1200	3/0	(85.0)	250	(127)
1600	4/0	(107.2)	350	(177)
2000	250	(127)	400	(203)
2500	350	(177)	500	(253)
3000	400	(203)	600	(304)
4000	500	(253)	800	(405)
5000	700	(355)	1000	(507)
6000	800	(405)	1200	(608)

14.3 The connection of a bonding conductor shall have metal-to-metal contact with the enclosure over an area not less than the cross section of the conductor.

## 15 Supports

### 15.1 General

15.1.1 Fastening means for supports may consist of factory drilled holes in the enclosure for use with screws or bolts, or the wireway may be provided with instructions for drilling and spacing such holes (see [15.2.1](#)) in the field, provided that the resulting construction will not result in any sharp corners or edges in the wireway. See [6.3](#).

### 15.2 Metal wireways

15.2.1 A metal wireway shall be provided with means for support at intervals not exceeding 5 ft (1.5 m) along its length.

*Exception No. 1: The means for support (excluding auxiliary gutters) may be at intervals not exceeding 15 ft (4.6 m) if the wireway is intended for vertical installation.*

*Exception No. 2: The means for supporting a wireway (excluding auxiliary gutters) intended for horizontal installation may be at intervals exceeding 5 ft but not exceeding 10 ft (3.0 m), if the wireway complies with the Support Test, Section [22](#), and the wireway is marked in accordance with [25.8](#).*

### 15.3 Nonmetallic wireways

15.3.1 A nonmetallic wireway shall be provided with means for support at intervals not exceeding 3 ft (900 mm) along its length.

*Exception No. 1: The means for support (excluding auxiliary gutters) may be at intervals not exceeding 4 ft (1.2 m) if the wireway is intended for vertical installation.*

*Exception No. 2: The means for supporting a wireway (excluding auxiliary gutters) intended for horizontal installation may be at intervals exceeding 3 ft but not exceeding 10 ft (3.0 m), if the wireway complies with the Support Test, Section [22](#), and the wireway is marked in accordance with [25.9](#).*

## **16 Protection Against Corrosion – Metal Wireways, Auxiliary Gutters, and Associated Fittings**

16.1 Unless a wireway enclosure is made of metal that will resist corrosion, both inside and outside surfaces of the trough and the cover shall be protected against corrosion by enameling, galvanizing, plating, or other equivalent means.

16.2 For a wireway made of iron or steel, both inside and outside surfaces of each length of wireway shall be thoroughly cleaned of all scale and rust. The cleaning process shall leave the surface of the wireway in a condition such that the protective coating (see [16.1](#), [16.4](#), and [16.5](#)) will adhere firmly and have a smooth surface.

16.3 A hinge or other attachment of a raintight wireway shall be resistant to corrosion. Metals shall not be used in combinations as to cause galvanic action that will adversely affect any part of the wireway.

16.4 The enclosure of a raintight wireway shall be protected against corrosion by one of the following coatings:

a) Hot-dipped mill-galvanized sheet steel conforming with the coating Designation G90 in the Weight [Mass] of Coating Requirements Table in the Standard Specification for Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy-Coated (Galvannealed) by the Hot-Dip Process, ASTM A653, with not less than 40% of the zinc on any side, based on the minimum single-spot test requirement in this ASTM designation. The weight of the zinc coating may be determined by any suitable method; however, in case of question, the weight of coating is to be established in accordance with the Test Method of the Standard Test Method for Weight [Mass] of Coating on Iron and Steel Articles with Zinc or Zinc-Alloy Coatings, ASTM A90. See [16.7](#) and [16.8](#).

b) A zinc coating, other than that provided on hot-dipped mill-galvanized sheet steel, uniformly applied to an average thickness of not less than 0.00061 in (15.5  $\mu\text{m}$ ) on each surface with a minimum thickness of 0.00054 in (13.7  $\mu\text{m}$ ). The thickness of coating shall be established by the Metallic Coating Thickness Test – Metal Wireways, Auxiliary Gutters, and Associated Fittings, Section [21](#). An annealed coating shall comply with [16.5](#) and [16.6](#).

c) A zinc coating conforming with item 1 or 2 below and with one coat of an organic finish of the epoxy or alkyd-resin type or other outdoor paint applied after forming on each surface. The suitability of the paint may be determined by consideration of its composition or by corrosion tests if these are considered necessary.

1) Hot-dipped mill-galvanized sheet steel conforming with the coating Designation G60 or A60 in the Weight [Mass] of Coating Requirements Table in the Standard Specification for Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy-Coated (Galvannealed) by the Hot-Dip Process, ASTM A653, with not less than 40% of the zinc on any side, based on the minimum single-spot test requirement in this ASTM designation. The weight of zinc coating may be determined by any suitable method; however, in case of question the weight of coating is to be established in accordance with the Test Method of the Standard Test Method for Weight [Mass] of Coating on Iron and Steel Articles with Zinc or Zinc-Alloy Coatings, ASTM A90.

2) A zinc coating, other than that provided on hot-dipped mill-galvanized sheet steel, uniformly applied to an average thickness of each surface with a minimum thickness of 0.00034 in (8.6  $\mu\text{m}$ ). The thickness of the coating shall be established in accordance with the Metallic Coating Thickness Test – Metal Wireways, Auxiliary Gutters, and Associated Fittings, Section [21](#).

d) A cadmium coating not less than 0.0010 in (25  $\mu\text{m}$ ) thick on both surfaces. The thickness of coating shall be established in accordance with the Metallic Coating Thickness Test – Metal Wireways, Auxiliary Gutters, and Associated Fittings, Section [21](#).

e) A cadmium coating not less than 0.00075-in (19.1- $\mu\text{m}$ ) thick on both surfaces with one coat of outdoor paint on both surfaces; or not less than 0.00051-in (13.0- $\mu\text{m}$ ) thick on both surfaces with two coats of outdoor paint on both surfaces. The thickness of the cadmium coating shall be established in accordance with the Metallic Coating Thickness Test – Metal Wireways, Auxiliary Gutters, and Associated Fittings, Section [21](#).

f) Other finishes, including paints, metallic finishes, or combination of the two may be accepted when comparative tests with galvanized sheet steel – without annealing, wiping, or other surface treatment – conforming with (a), indicate they provide equivalent protection. Among the factors that are taken into consideration when judging the suitability of such coating systems are exposure to salt spray, moist carbon dioxide-sulphur dioxide-air mixtures, moist hydrogen sulfide-air mixtures, ultraviolet light, and water.

16.5 An annealed coating on sheet steel that is bent or similarly formed or extruded or rolled at the edge of a hole after annealing shall be additionally painted in the affected area if the process damages the zinc coating.

16.6 If flaking or cracking of the zinc coating at the outside radius of the bent or formed section is visible at 25 power magnification, the zinc coating is considered to be damaged. Simple sheared or cut edges and punched holes are not required to be additionally protected.

16.7 A hot-dipped mill-galvanized A60, G60, or G90 coating shall not be damaged during handling or fabrication to the extent that the base steel is exposed.

*Exception: Uncoated cross-section surfaces at cut edges and drilled openings are acceptable.*

16.8 Sections of sheet steel that employ hot-dipped mill-galvanized A60, G60, or G90 coatings and formed, extruded, or rolled shall not be less than 90% of the minimum thickness specified in [Table 9.1](#).

## 17 Raintight Wireways

17.1 A raintight wireway shall be constructed to exclude a beating rain.

17.2 A hole in the top, side, or back of a raintight wireway shall be suitable for use with an acceptable raintight hub.

17.3 There shall be provision for drainage of a raintight wireway.

*Exception: Instructions for drilling holes in the field may be provided with a wireway. Such instructions shall indicate the proper positioning of the wireway.*

17.4 A raintight wireway shall be provided with external fastening means for mounting.

*Exception: A wireway may be provided with internal fastening means for mounting if the resulting construction prevents water from entering the enclosure.*

## PERFORMANCE

### 18 General

18.1 Performance requirements identified for wireways, auxiliary gutters and associated fittings apply to both nonmetallic and metal devices, unless specifically noted.

18.2 Nonmetallic wireways, auxiliary gutters and fittings shall additionally comply with performance requirements in the Standard for Nonmetallic Surface Raceways and Fittings, UL 5A.

### 19 Electrical Continuity Test – Metal Wireways, Auxiliary Gutters, Covers, and Associated Fittings

19.1 The resistance of the connection between adjacent sections of wireway or auxiliary gutter, between a wireway or auxiliary gutter and a cover, between a wireway or auxiliary gutter and a fitting, and the connection between a fitting and cover shall not be more than 0.005  $\Omega$ .

19.2 The wireway or gutter and fittings with covers are to be installed in the intended manner. A direct current of 30 A is then to be passed between adjacent sections of wireway or gutter, between the wireway or gutter and the cover, and between the wireway or gutter and the fitting. The resulting voltage drop is to be measured between a point (file mark) on the wireway 1/16 in (1.6 mm) from the connection and a similar point on the far end of an adjacent wireway or on the fitting, if of the ending-fitting type. In the case of a fitting of the feed-through type, the resulting drop in potential is to be measured between points on the two adjacent pieces of wireway or gutter 1/16 in (1.6 mm) from the connections. The voltage drop is to be measured between a point (file mark) on the cover 1/16 in (1.6 mm) from the connection and a similar point on the wireway, gutter, or the base of the fitting. The resistance in ohms is to be determined by dividing the drop in potential in volts by the current in amperes passing through the raceway.

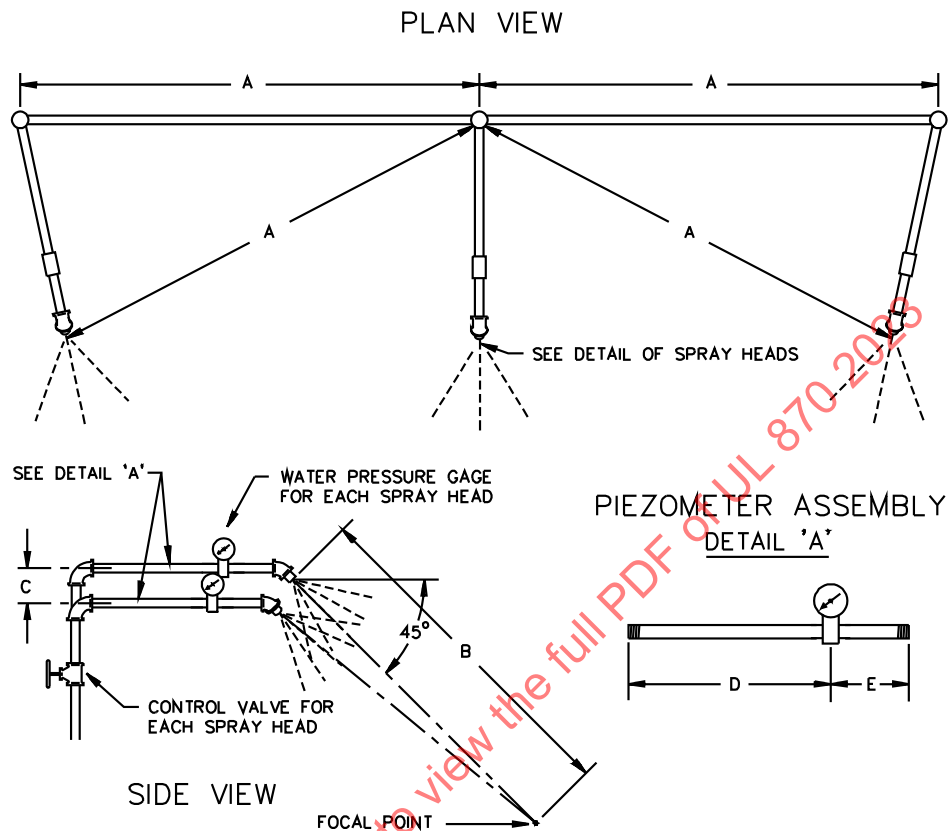
### 20 Raintightness Test

#### 20.1 General

20.1.1 To determine if a raintight wireway complies with the requirement in [17.1](#), two sections of the wireway are to be assembled in the intended manner if the wireway is designed to be so assembled; otherwise, the test is to be performed on a single section. Conduit connections, without pipe-thread compound, are to be as in actual service. When a water spray as described in [20.1.2](#) is applied to the wireway for 1 h, there shall be no entrance of water.

20.1.2 The water spray test apparatus is to consist of three spray heads mounted in a water supply pipe rack as shown in [Figure 20.1](#). The spray heads are to be constructed in accordance with the details shown in [Figure 20.2](#). The water pressure for all tests is to be maintained at 5 psi (34 kPa) at each spray head. The distance between the center nozzle and the unit is to be approximately 5 ft (1.5 m). The wireway is to be brought into the focal area of the three spray heads in such a position and under such conditions that are most likely to result in entrance of water into the wireway. The spray is to be directed at an angle of 45° to the vertical toward the joints and openings of the wireway.

Figure 20.1  
Rain-test spray-head piping



Item	inch	mm
A	28	710
B	55	1400
C	2-1/4	55
D	9	230
E	3	75

RT101E