Termopihustamine. Termopihustite katsetamine tüübikinnituse jaoks

Thermal spraying - Approval testing of thermal sprayers

EESTI STANDARDI EESSÕNA **NATIONAL FOREWORD**

Käesolev Eesti standard EVS-EN ISO 14918:1999 sisaldab Euroopa standardi EN ISO 14918:1998 ingliskeelset teksti. Käesolev dokument on jõustatud 12.12.1999 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes. Standard on kättesaadav Eesti standardiorganisatsioonist.	This Estonian standard EVS-EN ISO 14918:1999 consists of the English text of the European standard EN ISO 14918:1998. This document is endorsed on 12.12.1999 with the notification being published in the official publication of the Estonian national standardisation organisation. The standard is available from Estonian standardisation organisation.

Käsitlusala: Standard esitab termopihustite tüübikinnituskatsete korra. Standard määrab peamised nõuded, tüübikinnitusliigid, katsetingimused, tehnilistele tingimustele vastavuse nõuded ja sertifitseerimise kuumpihustatavuse tüübikinnituse andmiseks.	**Scope:**

ICS 25.220.20

Võtmesõnad: katsed, kontrollimine, personal, sertifitseerimine, termopihustamine, tähistamine, tüübikinnitus, vastuvõetavus, üldpõhimõtted

EUROPEAN STANDARD
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EN ISO 14918

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Descriptors: Thermal spraying, testing.

English version

Thermal spraying

Approval testing of thermal sprayers

(ISO 14918 : 1998)

Projection thermique – Qualification des agents en projection thermique (ISO 14918 : 1998)

Thermisches Spritzen – Prüfung thermischen Spritzern (ISO 14918 : 1998)

This European Standard was approved by CEN on 1998-08-02.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

The European Standards exist in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, the Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, the Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart 36, B-1050 Brussels

Foreword

International Standard

ISO 14918 : 1998 Thermal spraying – Approval testing of thermal sprayers,

which was prepared by ISO/TC 107 'Metallic and other inorganic coatings' of the International Organization for Standardization, has been adopted by Technical Committee CEN/TC 240 'Thermal spraying and thermally sprayed coatings', the Secretariat of which is held by DIN, as a European Standard.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, and conflicting national standards withdrawn, by April 1999 at the latest.

In accordance with the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard:

Austria, Belgium, the Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, the Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

Endorsement notice

The text of the International Standard ISO 14918 : 1998 was approved by CEN as a European Standard without any modification.

NOTE: Normative references to international publications are listed in Annex ZA (normative)

Contents

Introduction

This standard covers the principles of the approval testing of sprayer performance for thermal spraying.

The quality of work involved in thermal spraying depends on the skill and job knowledge of the thermal sprayer.

The ability of the thermal sprayer to follow verbal and written instructions and testing of his skill are therefore important factors in ensuring the quality of the thermally sprayed product.

This standard is intended to provide the basis for the mutual recognition by examining bodies for approval relating to thermal sprayer's competence in the various fields of application. Tests shall be carried out in accordance with this standard unless more severe tests are specified by the relevant application standards when these shall be applied.

The thermal sprayer's skill and job knowledge continue to be approved only if the thermal sprayer is working with reasonable continuity on thermal spraying work within the extent of approval.

All new approvals are to be in accordance with this standard from the date of this issue.

1 Scope

This standard gives procedural instructions for approval testing of thermal sprayers. It defines essential requirements, ranges of approval, test conditions, acceptance requirements and certification for approval testing of thermal spray performance.

During the approval test the thermal sprayer shall be required to show adequate practical experience and job knowledge of thermal spraying processes, materials and safety requirements for which he is to be approved; information on these aspects is given in Annex A.

This standard shall be used when the thermal sprayer's approval is required by the standard, the purchaser, by inspection authorities or by other organisations.

The thermal spraying processes referred to in this standard include those spraying processes which are designated as manual or mechanized.

Due to the variety and specialisation of automatic systems for thermal spraying where the thermal sprayer has no direct influence on the spraying process, this standard is not applicable in those circumstances.

The certificate of approval testing is issued under the sole responsibility of the examiner or test body.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 582
Testing of thermally sprayed coatings – Determination of adhesive tensile strength

EN 657
Thermal spraying – Terminology, classification

EN 1274
Powders for thermal spraying – Composition – Technical supply conditions

EN 1395
Acceptance inspection of thermal spraying equipment

EN 22063
Metallic and other inorganic coatings – Thermal spraying – Zinc, aluminium and their alloys

ISO 6507-1
Metallic materials – Hardness test – Vickers test – Part 1: HV 5 to HV 100

ISO 6508
Metallic materials – Hardness tests – Rockwell test (scales A – B – C – D – E – F – G – H – K)

ISO 8501-1
Preparation of steel substrates before application of paints and related products – Visual assessment of surface cleanliness – Part 1: Rust grades and preparation grades of uncoated steel substrates and of steel substrates after overall removal of previous coatings