

**Metallic and other inorganic coatings -
Electroplated coatings of cadmium with
supplementary treatments on iron or steel**

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 2082:2009 sisaldab Euroopa standardi EN ISO 2082:2008 ingliskeelset teksti.

Standard on kinnitatud Eesti Standardikeskuse 29.01.2009 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.

Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on 15.12.2008.

Standard on kättesaadav Eesti standardiorganisatsioonist.

This Estonian standard EVS-EN ISO 2082:2009 consists of the English text of the European standard EN ISO 2082:2008.

This standard is ratified with the order of Estonian Centre for Standardisation dated 29.01.2009 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.

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Võtmesõnad:

Standardite reprodutseerimis- ja levitamiseõigus kuulub Eesti Standardikeskusele

Andmete paljundamine, taastekitamine, kopeerimine, salvestamine elektroonilisse süsteemi või edastamine ükskõik millises vormis või millisel teel on keelatud ilma Eesti Standardikeskuse poolt antud kirjaliku loata.

Kui Teil on küsimusi standardite autorikaitse kohta, palun võtke ühendust Eesti Standardikeskusega:
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English Version

Metallic and other inorganic coatings - Electroplated coatings of cadmium with supplementary treatments on iron or steel (ISO 2082:2008)

Revêtements métalliques et autres revêtements
inorganiques - Dépôts électrolytiques de cadmium avec
traitements supplémentaires sur fer ou acier (ISO
2082:2008)

Metallische Überzüge - Galvanische Cadmiumüberzüge auf
Eisenwerkstoffen mit zusätzlicher Behandlung (ISO
2082:2008)

This European Standard was approved by CEN on 19 December 2008.

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Foreword

This document (EN ISO 2082:2008) has been prepared by Technical Committee ISO/TC 107 "Metallic and other inorganic coatings" in collaboration with Technical Committee CEN/TC 262 "Metallic and other inorganic coatings", the secretariat of which is held by BSI.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by June 2009, and conflicting national standards shall be withdrawn at the latest by June 2009.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 12330:2000.

WARNING — Because of regulations, the alteration of which is for the time being outside the competence of the CEN members, this European Standard contains an A-deviation as detailed in Annex ZA (informative).

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

Endorsement notice

The text of ISO 2082:2008 has been approved by CEN as a EN ISO 2082:2008 without any modification.

Annex ZA (informative)

A–deviations

A-deviation: National deviation due to regulations, the alteration of which is for the time being outside the competence of the CEN/ CENELEC member.

This European Standard does not fall under any Directive of the EU. In the relevant CEN/CENELEC countries these A-deviations are valid instead of the provisions of the European Standard until they have been removed.

<u>Clause</u>	<u>Deviation</u>
General	Germany (Gefahrstoffverordnung; Chemikalien-Verbotsverordnung) In Germany, the Gefahrstoffverordnung and the Chemikalien-Verbotsverordnung are applicable and cadmium electroplating is permitted only for special purposes, for which special standards exist.

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Introduction

Electrodeposits of cadmium are used to protect iron and steel from corrosion. Cadmium is anodic and corrodes sacrificially, thus protecting ferrous basis metals even when exposed through pores or pits in the cadmium. Electrodeposited cadmium coatings have traditionally been applied to iron or steel from alkaline cyanide solutions, but in recent years, environmental concerns and regulations have led to increased use of acid sulphate, neutral chloride and acid fluoborate cadmium solutions.

Because the appearance and serviceability of electroplated cadmium coatings are influenced by the surface condition of the basis metal, agreement should be reached between the interested parties that the surface of the basis metal is satisfactory for electroplating.

Cadmium is highly toxic and health, safety and environmental concerns are eliminating its non-essential uses. There remain, nevertheless, critical applications, often aerospace-related, where the unique properties of electrodeposited cadmium coatings, for example, their corrosion resistance, intrinsic lubricity, ductility, electrical conductivity and low contact resistance, make continued use of cadmium coatings necessary.

The corrosion resistance of electroplated cadmium coatings and their tendency to tarnish when handled can be improved by applying chromate conversion and other supplementary coatings.

Chemical conversion coatings that do not contain hexavalent chromium are commercially available and their use is becoming more and more popular. The appearance of these substitutes may be different from those produced with hexavalent chromium. Other conversion coatings that are chromium-free are also available. Substitutes are required to satisfy the corrosion requirements given in this International Standard.

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DANGER — Cadmium vapour is highly toxic by inhalation. During heat treatment, all precautions should be taken to ensure that no person is exposed to it. Attention is also drawn to the danger arising from welding, soldering or heating and other operations, in which the possibility that cadmium will be vaporised exists. Because of its toxicity, cadmium should not be employed as a coating for any article that will come in contact with food or beverages or containers in contact with these items or any household goods.

WARNING — This International Standard may not be compliant with some countries' health, safety and environmental legislations and calls for the use of substances and/or procedures that may be injurious to health if adequate safety measures are not taken. This International Standard does not address any health hazards, safety or environmental matters and legislations associated with its use. It is the responsibility of the producers, purchasers and/or user of this International Standard to establish appropriate health, safety and environmentally acceptable practices and take appropriate actions to comply with any national, regional and/or international rules and regulations. Compliance with this International Standard does not, of itself, confer immunity from legal obligations.

1 Scope

This International Standard specifies the requirements of electroplated coatings of cadmium with supplementary treatments on iron and steel. It includes information that is to be supplied by the purchaser to the electroplater, and describes coating requirements, including those for heat treatment before and after electroplating.

It is not applicable to coatings applied

- to sheet, strip or wire in the non-fabricated form,
- to close-coiled springs, or
- for purposes other than protective, intrinsic lubricity, ductility, electrical conductivity and low contact resistance use.

This International Standard does not specify requirements for the surface condition of the basis metal prior to electrodeposition with cadmium.

The coating thickness that can be applied to threaded components can be limited by dimensional requirements, including class or fit.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1463, *Metallic and oxide coatings — Measurement of coating thickness — Microscopical method*

ISO 2064, *Metallic and other inorganic coatings — Definitions and conventions concerning the measurement of thickness*

ISO 2080, *Metallic and other inorganic coatings — Surface treatment, metallic and other inorganic coatings — Vocabulary*

ISO 2177, *Metallic coatings — Measurement of coating thickness — Coulometric method by anodic dissolution*

ISO 2178, *Non-magnetic coatings on magnetic substrates — Measurement of coating thickness — Magnetic method*

ISO 2819, *Metallic coatings on metallic substrates — Electrodeposited and chemically deposited coatings — Review of methods available for testing adhesion*

ISO 3497, *Metallic coatings — Measurement of coating thickness — X-ray spectrometric methods*

ISO 3543, *Metallic and non-metallic coatings — Measurement of thickness — Beta backscatter method*

ISO 3613, *Chromate conversion coatings on zinc, cadmium, aluminium-zinc alloys and zinc-aluminium alloys — Test methods*

ISO 3892, *Conversion coatings on metallic materials — Determination of coating mass per unit area — Gravimetric methods*

ISO 4518, *Metallic coatings — Measurement of coating thickness — Profilometric method*

ISO 4519, *Electrodeposited metallic coatings and related finishes — Sampling procedures for inspection by attributes*

ISO 9587, *Metallic and other inorganic coatings — Pretreatment of iron or steel to reduce the risk of hydrogen embrittlement*

ISO 9588, *Metallic and other inorganic coatings — Post-coating treatments of iron or steel to reduce the risk of hydrogen embrittlement*

ISO 10289, *Methods for corrosion testing of metallic and other inorganic coatings on metallic substrates — Rating of test specimens and manufactured articles subjected to corrosion tests*

ISO 10587, *Metallic and other inorganic coatings — Test for residual embrittlement in both metallic-coated and uncoated externally-threaded articles and rods — Inclined wedge method*

ISO 15724, *Metallic and other inorganic coatings — Electrochemical measurement of diffusible hydrogen in steels — Barnacle electrode method*

ASTM B117, *Standard Practice for Operating Salt Spray (Fog) Apparatus*