
**Paints and varnishes — Guidelines for
the introduction of scribe marks through
coatings on metallic panels for corrosion
testing**

*Peintures et vernis — Lignes directrices pour la production de rayures
au travers du revêtement de panneaux métalliques en vue des essais
de corrosion*



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ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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ISO 17872 was prepared by Technical Committee ISO/TC 35, *Paints and varnishes*, Subcommittee SC 9, *General test methods for paints and varnishes*.

Introduction

Many International Standards deal with corrosion testing, where scribe marks are introduced through a coating to a metallic substrate. However, the method of scribe-mark introduction (scribing pattern, tools, etc.) is not standardized across these standards.

The main purposes of an intentionally inflicted damage in a coating prior to corrosion testing are as follows:

- a) to simulate and to investigate how a specific type of damage behaves during exposure;
- b) to obtain an accelerated response during a corrosion test, e.g. at quality control during production;
- c) to investigate the general durability of a coating by observation of the rate of corrosion spread after exposure.

Preliminary investigations have shown that several variants, both in terms of shape and dimensions, of scribing tools are used. This variation occurs both across countries and within countries. The effect of using different tools is the production of scribe marks with different cross-sectional shape, depth and exposed metal area. These differences will greatly affect test results obtained during corrosion tests, as the intention of introducing scribe marks into a coating system is such that oxygen and the electrolyte present during exposure testing can obtain access to a well defined and active metal surface.

The actual method used to introduce a scribe mark depends on the coating type and thickness. However, in all cases it is preferable if the cross-section is as smooth as possible, the metallic substrate is exposed evenly and no coating remains on the exposed substrate. Additionally, it is desirable that scribing methods are consistent across related International Standards.

The scribing method greatly affects how the corrosion process occurs and the reproducibility when tests are repeated under the same conditions. In order to obtain anticorrosive results with high accuracy and reproducibility, accurate and consistent scribing is required.

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1 Scope

This International Standard describes methods of scribing coated steel or test-pieces for corrosion tests, where the coating system is applied at dry film thicknesses of less than 500 µm. It is intended as a guideline only, being based on the results of a collaborative trial with no subsequent corrosion testing having been carried out to determine the suitability of the introduced scribe marks for such tests.

This International Standard covers the scribing of metallic panels or test pieces made from

- steel,
- chemically treated steel,
- aluminium or aluminium alloy, and
- chemically treated aluminium.

It does not cover the scribing of galvanized or electroplated metal or clad aluminium panels.

2 Scribe marks

If not otherwise agreed or specified, a scribe mark is made as an X-shape, T-shape or single-line, through the coating to the metal substrate according to the agreed conditions. Examples of X-shaped, T-shaped and a single-line scribe mark are given in Figure 1. Typically, the suitable length of the scribed lines is in the range of 50 mm to 70 mm, depending on the coating thickness and the expected amount of corrosion.

The length of the scribe mark should be significantly more than the expected creep resulting from the corrosion test carried out.

The width of the scribe mark can also affect the result of a corrosion test. The smaller the width, the stronger is the tendency for the exposed metal surface to be passivated by deposition of sparingly soluble corrosion products. It is therefore important to select a scribing tool which will provide a suitable scribe width for the corrosion test being carried out.

The orientation of the scribed lines is often significant in terms of affecting corrosion test results. On panels with a slight inclination from the vertical, e.g. for salt-spray tests, more salt is collected in a horizontally exposed scribe mark. Also, a horizontally exposed scribe mark will generate an even salt distribution, whereas a diagonal, or more particularly a vertical, scribe mark tends to generate a gradient, with an increasing amount of salt along the lower edge of the scribe mark. An increased amount of salt usually leads to an increased corrosion rate, but on coated steel, high salt concentration might have an inhibiting effect on corrosion since the formed corrosion products are very dense.

The cross-section of the scribe mark should be as uniform as possible along its entire length. The coating should be cut smoothly along the direction of the scribe mark. The cross-sectional shape of the scribe may be either “V” or “U” shaped, depending upon the tool used, and should be such that for a “V”-shaped cut $a > b > c$ and for a “U”-shaped cut $a > b$, with the width (b) of both “V” and “U” shapes such that $b \geq 0,2$ mm (see Figure 2 for an explanation of the symbols). Certain scribing tools may also produce a rectangular cross-section, where a , b and c are approximately equal.

NOTE The shape, depth and uniformity of scribe marks resulting from the use of manual scribing tools will also depend on the operator carrying out the scribing procedure. To reduce this operator dependency, and hence variability in