

Thermal spraying - Wires, rods and cords for flame and arc spraying - Classification - Technical supply conditions (ISO 14919:2015)

EESTI STANDARDI EESSÕNA

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English Version

Thermal spraying - Wires, rods and cords for flame and arc
spraying - Classification - Technical supply conditions (ISO
14919:2015)

Projection thermique - Fils, baguettes et cordons pour
projection thermique à l'arc et au pistolet dans une flamme -
Classification - Conditions techniques d'approvisionnement
(ISO 14919:2015)

Thermisches Spritzen - Drähte, Stäbe und Schnüre zum
Flammspritzen und Lichtbogenspritzen - Einteilung -
Technische Lieferbedingungen (ISO 14919:2015)

This European Standard was approved by CEN on 25 October 2014.

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EUROPÄISCHES KOMITEE FÜR NORMUNG

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Foreword

This document (EN ISO 14919:2015) has been prepared by Technical Committee CEN/TC 240 "Thermal spraying and thermally sprayed coatings" the secretariat of which is held by DIN, in collaboration with Technical Committee ISO/TC 107 "Metallic and other inorganic coatings".

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of an identical text or by endorsement, at the latest by July 2015, and conflicting national standards shall be withdrawn at the latest by July 2015.

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Endorsement notice

The text of ISO 14919:2015 has been approved by CEN as EN ISO 14919:2015 without any modification.

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Introduction

Requests for official interpretations of any aspect of this standard should be directed to the secretariat of ISO/TC 107/WG 1 via your national standards body; a complete listing can be found at www.iso.org.

Thermal spraying — Wires, rods and cords for flame and arc spraying — Classification — Technical supply conditions

1 Scope

This International Standard specifies requirements for classification of metal and non-metal wires (solid and cored), rods, cords processed by means of thermal spraying, especially by arc and flame spraying.

2 Normative references

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

ISO 10474:2013, *Steel and steel products — Inspection documents*

ISO 544:2011, *Welding consumables — Technical delivery conditions for filler materials and fluxes — Type of product, dimensions, tolerances and markings*

3 Classification

3.1 Classification according to the manufacturing process and resulting structure

The thermal spray materials are classified according to the manufacturing process and the resulting structure, as given in [Table 1](#).

Table 1 — Classification of thermal spraying material and resulting structure

Number	Term	Manufacturing process	Structure
1	solid wire/rod	metallurgical manufacturing and forming	homogeneous composition
2	solid wire/rod	powder metallurgical manufacturing and forming	homogeneous composition
3	cored wire (tube shaped wire)	filling up a metal tube and compressed by means of forming	seamless metal shell with powder filling
4	cored wire (folded wire)	forming a metal sheet with powder filling, binder and compressed by means of drawing	metal shell with powder filling
5	cords	simultaneous extruding of powder, binder and organic sheath	plastic shell with powder filling
6	oxide ceramic rods	extruding and sintering respectively drying of ceramic material	porous rod consisting of bonded ceramic particles

3.2 Classification according to material groups and chemical composition

The material groups are given in [Table 2](#), and the chemical composition shall comply with [Tables 3](#) to [10](#).