



SLOVENSKI STANDARD
SIST EN 22063:1999
01-junij-1999

Metalic and other inorganic coatings - Thermal spraying - Zinc, aluminium and their alloys (ISO 2063:1991)

Metallische und andere anorganische Schichten - Thermische Spritzen - Zink, Aluminium und ihre Legierungen (ISO 2063:1991 geändert)

Revetements métalliques et inorganiques - Projection thermique - Zinc, aluminium et alliages de ces métaux (ISO 2063:1991 modifiée)

Ta slovenski standard je istoveten z: EN 22063:1993

ICS:

25.220.20	Površinska obdelava	Surface treatment
25.220.40	Kovinske prevleke	Metallic coatings

SIST EN 22063:1999

en

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EUROPEAN STANDARD

EN 22063:1993

NORME EUROPÉENNE

EUROPÄISCHE NORM

September 1993

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Descriptors: Iron and steel products, coatings, protective coatings, metal spraying, zinc coatings, aluminium plating, classification, specifications, tests

English version

Metallic and other inorganic coatings - Thermal spraying - Zinc, aluminium and their alloys (ISO 2063:1991 modified)

Revêtements métalliques et inorganiques - Projection thermique - Zinc, aluminium et alliages de ces métaux (ISO 2063:1991 modifiée) **Metallische und andere anorganische Schichten - Thermisches Spritzen - Zink, Aluminium und ihre Legierungen (ISO 2063:1991 geändert)**

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This European Standard was approved by CEN on 1993-09-27. 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, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and 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

This European Standard has been taken over by the Technical Committee CEN/TC 240 "Thermal spraying and thermally sprayed coatings" from the work of ISO/TC 107 "Metallic and other inorganic coatings" of the International Organization for Standardization (ISO)

CEN/TC 240 has decided to submit the final draft for formal vote by its resolution 19/1992. The result was positive.

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 March 1994, and conflicting national standards shall be withdrawn at the latest by March 1994.

According to the CEN/CENELEC Internal Regulations, the following countries are bound to implement this European Standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, United Kingdom.

Endorsement notice

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The text of the International Standard ISO 2063:1991 was approved by CEN as a European Standard with the following common modifications.

Common modifications:

[SIST EN 22063:1999](https://standards.iteh.ai/catalog/standards/sist/b191b352-a1f9-46d4-9fa6-0279c30958c0/sist-en-22063-1999)

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- In table 1 the U.S. milli-inches are deleted.
- In A.2 of Annex A, a note was added with a reference to EN 582.

NOTE: A description of the method to determine the tensile adhesive strength is given in EN 582 "Thermal spraying - Determination of tensile adhesive strength"



INTERNATIONAL STANDARD

ISO
2063

Second edition
1991-11-01

Metallic and other inorganic coatings — Thermal spraying — Zinc, aluminium and their alloys

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*Revêtements métalliques et inorganiques — Projection thermique — Zinc,
aluminium et alliages de ces métaux*
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Reference number
ISO 2063:1991(E)

ISO 2063:1991(E)

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.

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.

International Standard ISO 2063 was prepared by Technical Committee ISO/TC 107, *Metallic and other inorganic coatings*, Sub-Committee SC 5, *Metal spraying*.

This second edition cancels and replaces the first edition (ISO 2063:1973), of which it constitutes a technical revision.

Annex A forms an integral part of this International Standard. Annex B is for information only.

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Introduction

Thermal sprayed metallic coatings are produced by projecting the coating metal heated to its molten state, in a stream of gas, onto the surface to be coated.

It is essential that the purchaser specifies the coating metal or alloy and the thickness of the coating required: merely to ask for thermal metal spraying to be carried out in accordance with ISO 2063, without this information, is insufficient.

It is essential that the design of the article enables it to be coated properly.

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Metallic and other inorganic coatings — Thermal spraying — Zinc, aluminium and their alloys

1 Scope

This International Standard deals with characteristic properties and gives test methods for coatings obtained by the spraying of zinc and aluminium and their alloys for the general purpose of corrosion protection.

It gives firstly the definition, classification and symbols for these coatings in relation to their thickness.

It then deals with the preparation of surfaces, application of coatings and their characteristic properties: namely, thickness, appearance and adhesion.

Finally it gives test methods for checking these properties.

It does not deal with repairs to damaged metal areas.

This International Standard applies to thermal-sprayed metallic coatings for the protection of iron and steel against corrosion by applying zinc or aluminium or their alloys to the surface to be protected.

It does not, in general, apply to coatings obtained by the application of metals other than zinc or aluminium, although for other metals some of the provisions are valid and may be adopted by agreement between the interested parties.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO/R 115:1968, *Classification and composition of unalloyed aluminium ingots for remelting.*

ISO 209-1:1989, *Wrought aluminium and aluminium alloys — Chemical composition and forms of products — Part 1: Chemical composition.*

ISO 752:1981, *Zinc ingots.*

ISO 1463:1982, *Metallic and oxide coatings — Measurement of coating thickness — Microscopical method.*

ISO 2064:1980, *Metallic and other non-organic coatings — Definitions and conventions concerning the measurement of thickness.*

ISO 2178:1982, *Non-magnetic coatings on magnetic substrates — Measurement of coating thickness — Magnetic method.*

ISO 8501-1:1988, *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.*

3 Definitions

For the purposes of this International Standard, the definitions given in ISO 2064 and in particular the following, apply.

3.1 significant surface: The part of the article covered or to be covered by the coating and for which the coating is essential for serviceability and/or appearance.

3.2 minimum local thickness: The lowest value of the local thickness found on the significant surface of a single article.