



SLOVENSKI STANDARD
SIST EN ISO 17836:2005
01-februar-2005

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Thermal spraying - Determination of the deposition efficiency for thermal spraying (ISO 17836:2004)

Thermisches Spritzen - Bestimmung der Auftragsrate beim thermischen Spritzen (ISO 17836:2004)

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Projection thermique - Détermination du rendement de dépôt en projection thermique (ISO 17836:2004)

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Ta slovenski standard je istoveten z: EN ISO 17836:2004

ICS:

25.220.20 Površinska obdelava Surface treatment

SIST EN ISO 17836:2005 **en**

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

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November 2004

ICS 25.220.20

English version

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This European Standard was approved by CEN on 1 July 2004.

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.

This European Standard exists 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, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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Foreword

This document (EN ISO 17836:2004) 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of an identical text or by endorsement, at the latest by May 2005, and conflicting national standards shall be withdrawn at the latest by May 2005.

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

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Introduction

This document includes the definitions for determining the deposition efficiency for thermal spraying. The document describes the test implementation procedure to determine the deposition efficiency for an individual spray process and a spray material when using a defined test piece.

The deposition efficiency calculated on a test piece according to this document needs not to correspond to the deposition efficiency on a component.

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1 Scope

It is essential to apply this document if data concerning the deposition efficiency of a spray process in connection with a defined spray material are required.

This document defines the procedure for determining the deposition efficiency for a thermal spray process in connection with a spray material and related equipment and auxiliary materials. It is applicable for all thermal spray processes (see EN 657) and all wire, rod, cord and powder spray materials.

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.

EN 657, *Thermal spraying — Terminology, classification.*

EN 1274, *Thermal spraying — Powders — Composition — Technical supply conditions.*

EN 13507, *Thermal spraying — Pre-treatment of surfaces of metallic parts and components for thermal spraying.*

EN ISO 14919, *Thermal spraying — Wires, rods and cords for flame and arc spraying — Classification — Technical supply conditions (ISO 14919:2001).*

3 Terms and definitions

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For the purposes of this document, the following term and definition applies.

3.1

deposition efficiency (DE)

ratio of the mass of the spray material deposited on the test piece under standard conditions to the mass of the spray material required and fed through for this purpose in %

4 Test pieces, equipment, working and auxiliary materials

a) Test pieces can be selected from:

- 1) a test pipe, dimensions according to Annex A;
- 2) a test plate, dimensions according to Annex B.

b) Equipment/working materials:

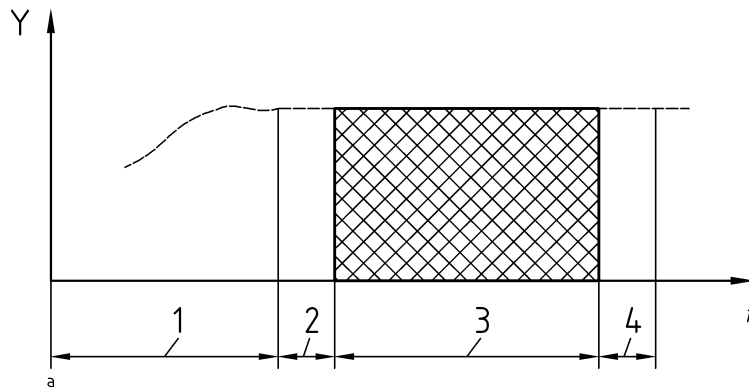
- 1) spray equipment;
- 2) handling system (if spray process is mechanised);
- 3) metering device (feeder for wire, rod, cord or powder);
- 4) fuel gases/fuel/electric energy;
- 5) plasma gases;
- 6) spray cabin;

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- 7) filter/exhaust system.
- c) Auxiliary materials:
 - 1) clamping device for test piece;
 - 2) scales (minimum accuracy 1 g).

5 Test implementation

- The test pieces shall be prepared according to specifications, e.g. degreased and grit-blasted (see also EN 13507). This procedure shall be documented.
- The mass of the prepared test piece shall be determined and documented.
- The feed rate of the spray material shall be determined in g/min in at least two run-throughs in order to calculate the mean value.
- The test pieces shall be coated applying the spray parameters selected. If risk of overheating exists, suitable cooling steps shall be taken. All parameters shall be documented in a record.
- The coating shall be carried out on a minimum of two test pieces of the same type with a coating time for each test piece of 30 s. Here the torch shall be swung in and swung out at high speed using the shortest possible way. The swing-in shall not take place until the spray jet is fully formed and stabilised (see Figure 1).
- After each spray test the change in mass of the test pieces shall be determined and documented (see Annex C).
- The mass of the spray material required is calculated using the spray time and feed rate. The mass shall be documented (see Annex C).



Key

- Y Feed rate
 t Time
 a Torch position
 1 Stabilisation
 2 Swing in
 3 on test piece
 4 Swing out

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Figure 1 — Test procedure

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6 Determination of deposition efficiency

The calculation of the deposition efficiency shall be carried out for each individual test piece and the mean value calculated.

$$\eta_D = \frac{\Delta m_{tp}}{m_{sm}} \times 100\%$$

where

- η_D deposition efficiency, in %;
 Δm_{tp} mass difference of test piece, in g;
 m_{sm} mass of spray material fed through, in g;
 (It is the product of feed rate, in g/min, and spray time, in s, divided by 60).

7 Test report

The test results shall be entered in the record (see Annex C). The mean value shall be calculated from the test results.

The test report for determining the deposition efficiency shall include the following minimum of information:

- type of spray equipment and gun;
- feed mechanism of spray material;
- type of spray process;