INTERNATIONAL STANDARD

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Thermal spraying — Post-treatment and finishing of thermally sprayed coatings

Projection thermique — Traitement et finition des revêtements obtenus par projection thermique

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Foreword

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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 14924 was prepared by the European Committee for Standardization (CEN) in collaboration with Technical Committee ISO/TC 107, *Metallic and other inorganic coatings*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

Throughout the text of this document, read "...this European Standard..." to mean "...this International Standard...".

Contents

Foreword

This European Standard (EN ISO 14924:2005) 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of an identical text or by endorsement, at the latest by February 2006, and conflicting national standards shall be withdrawn at the latest by February 2006.

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.

Introduction

The successful service of a thermally sprayed component depends decisively on the right choice of procedure for post treatment and/or finishing after spraying. In order to work and/or to treat a thermally sprayed coating especially the property of the lamellae structure needs to be taken into account. The structure is quite different from those of the same materials in the cast or wrought state and finishing techniques which may be suitable in these latter cases would be likely to damage thermally sprayed coatings.

1 Scope

This European Standard specifies the treatment and finishing of thermally sprayed coatings. It is applicable to different types of mechanical post treatment, chemical treatment, and thermal treatment, including chip cutting and other mechanical processes, to sealing, pickling and painting, and fusing, diffusion annealing and hot isostatic pressing.

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 ISO 2063, *Thermal spraying - Metallic and other inorganic coatings - Zinc, aluminium and their alloys (ISO 2063:2005)*

EN ISO 12944-5, *Paints and varnishes – Corrosion protection of steel structures by protective paint systems – Part 5: Protective paint systems (ISO 12944- 5:1998)*

EN ISO 14920, *Thermal spraying – Spraying and fusing of self-fluxing alloys (ISO 14920:1999)*

ISO 504, *Turning tools with carbide tips – Designation and marking*

3 Mechanical post treatment

3.1 Chip cutting

3.1.1 General

For the reasons stated in the Introduction, the common basis of chip cutting techniques cannot be applied to thermally sprayed coatings because of their different properties. There are many different hard phases in sprayed coatings such as oxides, carbides, borides, silicides and others. These require specific attention to the geometry of the cutting edge to prevent high wear of the flank.

3.1.2 Turning

The possibility of turning a thermally sprayed metal coating depends upon the specific property of a thermal spray coating e.g. structure and hardness as well as any previously applied thermal spray process.

a) Tool selection:

Due to hard phases in metallic thermal spray coatings and the partly extremely hardening spray particle the turning tool is more heavily loaded compared to cast or forged material consisting out of the same or similar material.

Because of this reason hard metals and ceramic cutting materials are required. The ones commonly used for turning grey cast iron, chilled cast iron and short cutting chip malleable cast iron. In contrast thermally sprayed aluminium or copper coatings can be turned economically using high speed steel cutting tools. Good operation times are achieved by using hard metal quality K01 and K10 according to ISO 504.

Thermally sprayed coatings with hardnesses x > 700 HV (60 HRC) may be turned satisfactorily using boron nitride tools, consisting of poly-crystalline, cubic boron nitride (CBN), which are sintered to a hard metal body.

Thermally sprayed copper and aluminium coatings can be turned economically using high-speed steel.

b) Cutting speed:

The optimum cutting speeds for thermal spray coatings are different. They are lower because of embedded hard phases compared to homogeneous materials and require sharp cutting tools with cutting radius R 0,4 mm - 1,2 mm.

Tables A.1 to A.4 show approximate values which may be adjusted from case to case. A test cut is recommended in order to avoid unfavourable results.

NOTE Applying excessive cutting velocities the thermal spray coating acts like a lapping tool causing an uneconomic lifetime of the tool. The blunt cutting tool generates a high surface load and can lead to coating damage.

c) Traverse feed:

Traverse feed per revolution shall be of the order of particle diameter of thermal spray coating. Tables A.1 to A.4 show approximate values for turning of thermally sprayed metal coatings which may be adjusted from case to case.

3.1.3 Milling

In some cases thermal spray coatings may be machined also by milling. Concerning selection of tool and choice of feed and speed the same considerations as for turning shall be taken into account.

3.1.4 Cooling during chip cutting operations

When coatings of self-fluxing alloys, which are fused to provide a dense structure, are machined, a coolant may be used in order to prevent overheating (This does not apply when CBN cutting tools are used).

Otherwise a coolant shall not be used when 'as sprayed' coatings (which are not fused) are being machined. The micro porosity of the coating permits penetration of the coolant causing discolouration and other problems.

If coolant is used areas of high hydraulic pressure can wholly or partially remove particle giving a poor surface finish.

3.1.5 Grinding

3.1.5.1 General

Wet grinding shall be preferred to dry grinding in order to avoid over heating of the thermally sprayed coating as well as of the work piece.

3.1.5.2 Preparation

It is advantageous to seal the coating before grinding. This will prevent penetration of the coolant to the interface with the substrate material causing possible corrosion problems (see 4.1). It will also minimise the generation of grinding debris which may contaminate the returned coolant.

Care should be taken to the choice of sealant, so that the sealant do not get burnt or smeared onto the grinding wheel, due to the sometimes high contact temperatures during grinding.

Additionally, sealing of ceramic coatings is also preferred before grinding to prevent unsightly staining of the coating due to penetration of the coolant.

3.1.5.3 Selection of grinding process

All thermally sprayed coatings may be ground. The loading of the thermally sprayed coating is lower compared with that of turning. Tables B.1 and B.2 show details for grinding.

3.1.5.4 Selection of grinding wheel

The shape of the grinding wheel will vary depending on the geometry of the component to be ground. e.g. cup wheels may be used where appropriate. Dry grinding may be carried out although the use of a coolant, where possible, is preferred.

Tables B.1 to B.3 show the kind of wheels to be used, which will depend on the thermal spray material used.

3.1.5.5 Belt grinding

Where a smooth finish is required and dimensional accuracy is not important, belt grinding may be used. Typically silicon carbide or diamond belts are used for this purpose.

3.1.6 Other cutting processes

3.1.6.1 Chip cutting with geometrically defined tool edges (drilling)

Certain thermal spray coatings can be drilled using sharp spiral drills.

3.1.6.2 Planning, sawing, reaming, broaching

Precautions shall be taken when using these processes due to the risk of damaging the coatings.

3.1.6.3 Chip cutting with geometrically undefined but hard tool edges

a) Abrasive cutting, honing:

For these cutting processes the same recommendations as for grinding shall be taken into account.

b) Applying loose grains:

– Polishing, lapping: Polishing of ground or turned metallic thermally sprayed coatings may be carried out by using polishing machines and applying polishing filler materials. A heat build up shall be avoided to prevent coating damage.

– Super finishing: Thermal Spray coatings especially ceramic coatings (e.g. Cr_2O_3, Al_2O_3/TiO_2, blends of these respectively alloys with other ceramics as well as hard materials) can be super finished in order to achieve very low coating roughness (R_a down to 0,05). These results can be achieved by using appropriate powders, thermal spray equipment and wet operating finishing procedures.

3.2 Other mechanical processes

3.2.1 Shot peening

In special case metallic thermal sprayed coatings can be post-treated by shot peening. The shot peening process densifies the coating and can generate a compressive stress. This post-treatment can increase the corrosion resistance of especially arc and flame sprayed coatings. Care has to be taken that the thermally sprayed coating is not too highly loaded locally during shot peening to avoid spalling.

3.2.2 Brushing

Thermal sprayed coatings can be brushed in order e.g. to smooth the surface, to remove spray dust to achieve clean surfaces or decorative effects.

4 Chemical treatment

4.1 Sealing

4.1.1 General

Untreated thermally sprayed coatings contain micro porosity. In many cases it is desirable to close the pores using specially formulated sealing materials which will penetrate the pores and not simply lie on the surface. Control of the viscosity of the sealant is vitally important in this respect. It is also important that the coating does not take up moisture or become otherwise contaminated between spraying and sealing.