



NSAI
Standards

Irish Standard
I.S. EN ISO 2063-1:2017

Thermal spraying - Zinc, aluminium and their alloys - Part 1: Design considerations and quality requirements for corrosion protection systems (ISO 2063-1:2017)

I.S. EN ISO 2063-1:2017

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National Foreword

I.S. EN ISO 2063-1:2017 is the adopted Irish version of the European Document EN ISO 2063-1:2017, Thermal spraying - Zinc, aluminium and their alloys - Part 1: Design considerations and quality requirements for corrosion protection systems (ISO 2063-1:2017)

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EUROPEAN STANDARD

EN ISO 2063-1

NORME EUROPÉENNE

EUROPÄISCHE NORM

October 2017

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Supersedes EN ISO 2063:2005

English Version

Thermal spraying - Zinc, aluminium and their alloys - Part 1: Design considerations and quality requirements for corrosion protection systems (ISO 2063-1:2017)

Projection thermique - Zinc, aluminium et alliages de
ces métaux - Partie 1: Considérations de conception et
exigences de qualité pour les systèmes de protection
contre la corrosion (ISO 2063-1:2017)

Thermisches Spritzen - Zink, Aluminium und ihre
Legierungen - Teil 1: Bauteilgestaltung und
Qualitätsanforderungen für Korrosionsschutzsysteme
(ISO 2063-1:2017)

This European Standard was approved by CEN on 31 August 2017.

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EN ISO 2063-1:2017 (E)

Contents	Page
European foreword.....	3

European foreword

This document (EN ISO 2063-1:2017) has been prepared by Technical Committee ISO/TC 107 “Metallic and other inorganic coatings” in collaboration with Technical Committee CEN/TC 240 “Thermal spraying and thermally sprayed coatings” the secretariat of which is held by DIN.

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of an identical text or by endorsement, at the latest by April 2018, and conflicting national standards shall be withdrawn at the latest by April 2018.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 2063:2005.

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

Endorsement notice

The text of ISO 2063-1:2017 has been approved by CEN as EN ISO 2063-1:2017 without any modification.

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INTERNATIONAL STANDARD

**ISO
2063-1**

First edition
2017-09

Thermal spraying — Zinc, aluminium and their alloys —

Part 1: Design considerations and quality requirements for corrosion protection systems

*Projection thermique — Zinc, aluminium et alliages de ces métaux —
Partie 1: Considérations de conception et exigences de qualité pour les
systèmes de protection contre la corrosion*



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Contents

	Page
Foreword	v
Introduction	vi
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Criteria for corrosion and corrosion protection by thermal-sprayed coatings	3
4.1 General.....	3
4.2 Corrosivity categories and environment conditions.....	3
4.3 Corrosion rate.....	3
4.4 Coating materials and corrosion behaviour.....	3
4.4.1 General.....	3
4.4.2 Zinc and zinc alloys.....	4
4.4.3 Aluminium and aluminium alloys.....	4
5 Requirements for the corrosion protection systems and their planning	4
5.1 General rules — Technical requirements.....	4
5.2 Used spray materials and coating thickness.....	5
5.2.1 Spray materials.....	5
5.2.2 Coating thickness.....	5
5.3 Construction design requirements for iron and steel components for thermal spraying.....	6
5.3.1 General.....	6
5.3.2 Recommendations for the design of the part — Avoidance of corrosion creating areas.....	6
5.3.3 Requirements for welding in combination with thermal-sprayed protective coatings.....	6
5.3.4 Thermal spraying of corrosion protected fastenings.....	6
6 Pre-conditions and requirements for the manufacturing process	6
6.1 General — Requirements.....	6
6.2 Reference areas.....	6
6.3 Preparation of the surface to be coated.....	7
6.4 Thermal spraying.....	7
6.5 Sealing of thermal-sprayed coatings.....	7
6.6 Metallic coatings and additional organic top coatings.....	8
6.7 Requirements for the tests — Test procedures.....	8
6.7.1 General.....	8
6.7.2 Visual inspection — Appearance.....	8
6.7.3 Coating thickness.....	8
6.7.4 Adhesion strength.....	9
6.7.5 Metallographic investigation.....	9
7 Requirements for the manufacturer	9
7.1 General.....	9
7.2 Coating specification — Requirements for the spray coating.....	9
8 Documentation	10
Annex A (informative) Corrosivity categories — Environment conditions — Exposure	11
Annex B (informative) Summary of the corrosion behaviour of thermal-sprayed coatings of zinc, aluminium and their alloys	13
Annex C (informative) Recommended values for the thickness of the metallic coating	15
Annex D (informative) Examples of design and explanations	17
Annex E (informative) Example test certificate for work specimen for thermal sprayer used on-site in accordance with ISO 2063-2	23

ISO 2063-1:2017(E)

Annex F (informative) Appearance of surfaces in different treated conditions	25
Annex G (informative) Checklist for this document — Work and test steps and connection to relevant standards or recommendations	26
Bibliography	28

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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 107, *Metallic and other inorganic coatings*.

This document, together with ISO 2063-2:2017, cancels and replaces ISO 2063:2005, which has been technically revised.

A list of all the parts in the ISO 2063 series can be found on the ISO website.

ISO 2063-1:2017(E)**Introduction**

In order to protect iron- and steel-based structures (e.g. for steel construction, bridge construction, steel structures for water construction, onshore and offshore wind energy constructions, petrol and natural gas industry) against corrosion, protective coatings are usually deposited. Corresponding to type, shape and required functionality of the part, numerous procedures are available. The deposition of corrosion protection coatings or coating systems can be done by applying hot-dip galvanizing, organic coatings or thermal spraying of zinc, aluminium and their alloys. Using combinations of metallic and organic coatings, duplex corrosion protection coating systems can be produced.

Thermal-sprayed corrosion protection coatings made of zinc, aluminium and their alloys can be sprayed onto all steels which make up the components used in the relevant industrial application. This may be carried out on-site, as well as in the workshop, regardless of the article's size. Due to the usually low heat input into the surface of the part, only a slight thermal loading of the substrate occurs, so that changes in steel properties and deformation of the part do not occur.

Corrosion protection coatings can be used as repairs or rework of defects of other coatings (e.g. uncoated hot-dip zinc galvanized areas) or worn coatings where thermal spraying can be applied on the spot. Due to relative low investment costs, thermal spraying can also be economically applied for single parts.

The ISO 2063 series applies to thermal-sprayed metallic coatings to protect iron and steel against corrosion by deposition of zinc, aluminium or their alloys onto the uncoated surface to be protected.

This document targets designers of components. It covers the planning engineering of the corrosion protection system and deals with the basic rules for planning of corrosion protection systems and for the constructive design of the components to be protected, if the protection system is based upon a thermal-sprayed metallic coating.

ISO 2063-2 targets manufacturers of corrosion protection systems. It deals with the requirements for the execution of the corrosion protection works by thermal spraying in the workshop and on-site.

Thermal spraying — Zinc, aluminium and their alloys —

Part 1:

Design considerations and quality requirements for corrosion protection systems

1 Scope

This document specifies requirements for the protection of iron and steel surfaces against corrosion by applying thermal-sprayed metallic coatings of zinc, aluminium or their alloys.

In this document, requirements for the planning of the corrosion protection system and for the constructive design of the component to be protected are specified, where thermal spraying is intended to be the process for the deposition of the metallic corrosion protection.

Some field-related basic terms are defined and instructions for corrosion behaviour of the zinc and aluminium materials under different environment conditions are provided.

Characteristic properties of the coating, e.g. coating thickness, minimum adhesive strength and surface appearance, are specified and test procedures for thermal-sprayed corrosion protection coatings of zinc, aluminium or their alloys are determined.

This document is valid for applying thermal-sprayed zinc and aluminium protection coatings against corrosion in the temperature range between $-50\text{ }^{\circ}\text{C}$ to $+200\text{ }^{\circ}\text{C}$, taking into consideration the service conditions of any sealants used. Heat-resistant protective coatings of aluminium are covered by ISO 17834 and are not in the scope of this document.

Other corrosion protection processes, e.g. hot-dip galvanizing (galvanic coating), sherardizing, electroplating or selection and deposition of organic coatings/paints are not in the scope of this document.

Requirements for the manufacturing of thermal-sprayed coatings are specified in ISO 2063-2.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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.

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

ISO 2063-2:2017, *Thermal spraying — Zinc, aluminium and their alloys — Part 2: Execution of corrosion protection systems*

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

ISO 4624, *Paints and varnishes — Pull-off test for adhesion*

ISO 8044, *Corrosion of metals and alloys — Basic terms and definitions*

ISO 8501-1, *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*

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