NSAI Standards

Irish Standard
I.S. EN ISO 14922:2021

Thermal spraying - Quality requirements for manufacturers of thermal sprayed coatings (ISO 14922:2021)

I.S. EN ISO 14922:2021

Incorporating amendments/corrigenda/National Annexes issued since publication:

The National Standards Authority of Ireland (NSAI) produces the following categories of formal documents:

I.S. xxx: Irish Standard — national specification based on the consensus of an expert panel and subject to public consultation.

S.R. xxx: Standard Recommendation — recommendation based on the consensus of an expert panel and subject to public consultation.

SWiFT xxx: A rapidly developed recommendatory document based on the consensus of the participants of an NSAI workshop.

This document replaces/revises/consolidates the NSAI adoption of the document(s) indicated on the CEN/CENELEC cover/Foreword and the following National document(s):

NOTE: The date of any NSAI previous adoption may not match the date of its original CEN/CENELEC document.

This document is based on:	*Published:*
EN ISO 14922:2021	2021-10-06

This document was published under the authority of the NSAI and comes into effect on:	ICS number:
2021-10-25	25.220.20
	NOTE: If blank see CEN/CENELEC cover page

NSAI	T +353 1 807 3800	Sales:
1 Swift Square,	F +353 1 807 3838	T +353 1 857 6730
Northwood, Santry	E standards@nsai.ie	F +353 1 857 6729
Dublin 9	W NSAI.ie	W standards.ie

Údarás um Chaighdeáin Náisiúnta na hÉireann

National Foreword

I.S. EN ISO 14922:2021 is the adopted Irish version of the European Document EN ISO 14922:2021, Thermal spraying - Quality requirements for manufacturers of thermal sprayed coatings (ISO 14922:2021)

This document does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

For relationships with other publications refer to the NSAI web store.

Compliance with this document does not of itself confer immunity from legal obligations.

In line with international standards practice the decimal point is shown as a comma (,) throughout this document.

This page is intentionally left blank

EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN ISO 14922

October 2021

ICS 25.220.20

Supersedes EN ISO 14922-1:1999, EN ISO 14922-2:1999, EN ISO 14922-3:1999, EN ISO 14922-4:1999

English Version

Thermal spraying - Quality requirements for manufacturers of thermal sprayed coatings (ISO 14922:2021)

Projection thermique - Exigences qualité pour les fabricants de revêtement projeté thermiquement (ISO 14922:2021)

Thermisches Spritzen - Qualitätsanforderungen für Hersteller von thermisch gespritzten Schichten (ISO 14922:2021)

This European Standard was approved by CEN on 31 August 2021.

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 CEN-CENELEC Management Centre 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 CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

Ref. No. EN ISO 14922:2021 E

Contents

Page

European foreword

This document (EN ISO 14922:2021) 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 2022, and conflicting national standards shall be withdrawn at the latest by April 2022.

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 14922-1:1999, EN ISO 14922-2:1999, EN ISO 14922-3:1999 and EN ISO 14922-4:1999.

Any feedback and questions on this document should be directed to the users’ national standards body/national committee. A complete listing of these bodies can be found on the CEN website.

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, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 14922:2021 has been approved by CEN as EN ISO 14922:2021 without any modification.

This page is intentionally left blank

INTERNATIONAL STANDARD

ISO 14922

First edition
2021-09

Thermal spraying — Quality requirements for manufacturers of thermal sprayed coatings

Projection thermique — Exigences qualité pour les fabricants de revêtement projeté thermiquement

Reference number
ISO 14922:2021(E)

ISO copyright office
CP 401 • Ch. de Blandonnet 8
CH-1214 Vernier, Geneva
Phone: +41 22 749 01 11
Email: copyright@iso.org
Website: www.iso.org

Published in Switzerland

Contents

Page

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).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of 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 www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 107, *Metallic and other inorganic coatings*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 240, *Thermal spraying and thermally sprayed coatings,* in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This first edition of ISO 14922 cancels and replaces ISO 14922-1:1999, ISO 14922-2:1999, ISO 14922-3:1999 and ISO 14922-4:1999, which have been technically revised. The main changes compared with the previous editions are as follows:

— the four parts have been consolidated into one document;

— the requirements for the manufacturer now correspond to those of the parts;

— the weighting of requirements with +++ / ++ / + have been updated and are now requirements;

— the requirements have been separated: the quality assurance requirements former classified in 1, 2, 3 now clear as QRC and QAL C, S, E, the three assessment groups as comprehensive requirements, standard (normal) requirements, elementary requirements titled and presented in direct comparison in three columns in Annex C;

— the dependence on ISO 9001 has been removed;

— decision on QAL C, S, E by customer or manufacturer itself.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

Thermal spraying processes are widely applied for producing industrial products and are mainly applied for preventive protection of surfaces. The application can take place both within the workshop as well as on site. Measures for the maintenance of worn coatings or of surfaces on components are also in the field of use. Thermal spraying can be found in all industries, but especially in the aerospace, stationary gas turbine, automotive, machinery construction, printing and chemical, and oil extraction and refining fluid control industries, as well as for medical purposes and for steel construction in the field of off-shore and on-shore, etc. Usually coatings are applied for anticorrosive and/or anti-wear purposes, high temperature protection and against chemical attack, as well as for aesthetic or electrical reasons.

Thermal spraying belongs to the so-called "special processes", where the quality of the coating cannot be unambiguously determined by testing without damaging the component. For an adequate use of thermal sprayed coatings and in order to avoid quality or cost-intensive problems when manufacturing and during service time, conditions and processes must be controlled. Therefore, a functional quality assurance system is made available for the coating factory, if necessary, in additional to a quality management system (e.g. ISO 9001).

This document provides three different levels of quality requirements (comprehensive level C, standard level S and elementary level E). These requirements can be defined by the customer's design engineering relating to the thermal sprayed coating or to the component.

The main elements of the quality assurance of the entire thermal spraying process for different applications in accordance with quality assurance levels C, S and E are listed in Annex B or Annex C. They can be used to check the proper function of the quality assurance system when applying a quality audit.

This document specifies requirements, tests and the scope of tests when qualifying the manufacturer. The specific requirements of the qualifying procedure in accordance with the quality assurance level C, S or E can be given by the general requirements of the quality management system of the company or a contract.

This document together with the relevant quality level can be stipulated by the customer/designer in order to require a minimum of quality assurance measures for the manufacturing of his or her component.

The requirements specified in this document can be helpful when a quality assurance system is being established.

Thermal spraying — Quality requirements for manufacturers of thermal sprayed coatings

1 Scope

This document specifies quality requirements for manufacturers of thermal sprayed coatings to ensure quality assurance for activities in the field of production.

NOTE It is independent of the availability of a quality management system, e.g. ISO 9001, ISO 14001 and ISO 45001, which concern the concept and organization of the quality management.

This document defines the quality requirements that are of importance for the manufacturing route.

This document is applicable to thermal spraying including all the pre- and post-treatments of the whole coating process for new parts, for repairs and maintenance (e.g. after service) at the workshop or on site.

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 9712, *Non-destructive testing — Qualification and certification of NDT personnel*

ISO 12690, *Metallic and other inorganic coatings — Thermal spray coordination — Tasks and responsibilities*

ISO 14917, *Thermal spraying — Terminology, classification*

ISO 14918, *Thermal spraying — Qualification testing of thermal sprayers*

ISO 14923, *Thermal spraying — Characterization and testing of thermally sprayed coatings*

EN 1395-1, *Thermal spraying — Acceptance inspection of thermal spraying equipment — Part 1: General requirements*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 14917 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at https://www.iso.org/obp

— IEC Electropedia: available at http://www.electropedia.org/

3.1
contract
requirements for the coating or for the component to be coated agreed between the contracting parties, e.g. by specification, drawing, manufacturing instructions.

Note 1 to entry: In order to avoid coordination problems between the contracting parties, it is essential to indicate a reference to the standard, including the publication date, according to which a contract was defined