



National Standards Authority of Ireland

IRISH STANDARD

I.S. EN ISO 14922-2:1999

ICS 25.220.20

**THERMAL SPRAYING - QUALITY  
REQUIREMENTS OF THERMALLY SPRAYED  
STRUCTURES - PART 2: COMPREHENSIVE  
QUALITY REQUIREMENTS (ISO 14922-2:1999)**

National Standards  
Authority of Ireland  
Glasnevin, Dublin 9  
Ireland

Tel: +353 1 807 3800  
Fax: +353 1 807 3838  
<http://www.nsai.ie>

**Sales**  
<http://www.standards.ie>

*This Irish Standard was  
published under the  
authority of the National  
Standards Authority of  
Ireland and comes into  
effect on:*

*November 5, 1999*

**NO COPYING WITHOUT NSAI  
PERMISSION EXCEPT AS  
PERMITTED BY COPYRIGHT  
LAW**

© NSAI 1999

**Price Code F**

Údarás um Chaighdeáin Náisiúnta na hÉireann



EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN ISO 14922-2**

June 1999

ICS 25.220

English version

**Thermal spraying - Quality requirements of thermally sprayed structures - Part 2: Comprehensive quality requirements (ISO 14922-2:1999)**

Projection thermique - Exigences qualité des constructions obtenues par projection thermique - Partie 2: Exigences qualité complètes (ISO 14922-2:1999)

Thermisches Spritzen - Qualitätsanforderungen an thermisch gespritzte Bauteile - Teil 2: Umfassende Qualitätsanforderungen (ISO 14922-2:1999)

This European Standard was approved by CEN on 19 February 1999.

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, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.



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

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

**Contents**

	Page
<b>Foreword</b> .....	3
<b>1 Scope</b> .....	4
<b>2 Normative references</b> .....	4
<b>3 Definitions</b> .....	5
<b>4 Contract and design review</b> .....	5
4.1 General .....	5
4.2 Application – Contract review .....	5
4.3 Application – Design review .....	6
<b>5 Sub-contracting</b> .....	6
<b>6 Personnel for thermal spraying</b> .....	6
6.1 General .....	6
6.2 Qualified thermal sprayer .....	6
6.3 Thermal spraying coordinator .....	6
<b>7 Personnel for quality testing</b> .....	6
7.1 General .....	6
7.2 Non-destructive testing .....	7
<b>8 Equipment</b> .....	7
8.1 Equipment for manufacturing .....	7
8.2 Description of equipment .....	7
8.3 Suitability of equipment .....	7
8.4 New equipment .....	7
8.5 Maintenance .....	7
8.6 Health and safety and environmental aspects .....	8
<b>9 Thermal spraying activities</b> .....	8
9.1 Production plan .....	8
9.2 Thermal spraying procedure specification .....	8
9.3 Work instructions .....	8
9.4 Pre- and post-treatment .....	8
9.5 Documentation .....	8
<b>10 Consumables for thermal spraying</b> .....	8
10.1 General .....	8
10.2 Batch testing .....	9
10.3 Storage and handling .....	9
<b>11 Storage and handling of substrate materials</b> .....	9
<b>12 Thermal spraying related inspection and testing</b> .....	9
12.1 General .....	9
12.2 Inspection and testing before thermal spraying .....	9
12.3 Inspection and testing during thermal spraying .....	9
12.4 Inspection and testing after thermal spraying .....	9
12.5 Inspection and test status .....	10
<b>13 Non-conformance and corrective actions</b> .....	10
<b>14 Calibration</b> .....	10
<b>15 Identification and traceability</b> .....	10
<b>16 Quality records</b> .....	10
<b>Annex ZA (informative) Bibliography</b> .....	11

## Foreword

The text of EN ISO 14922-2:1999 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 December 1999, and conflicting national standards shall be withdrawn at the latest by December 1999.

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

## 1 Scope

This standard specifies requirements so that:

- It is independent of the type of the thermally sprayed structure.
- It defines quality requirements for thermal spraying both in workshops and on site.
- It provides guidance for describing a manufacturer's capability to produce thermally sprayed constructions to meet specified requirements.
- It may also be used as a basis for assessing the manufacturer in respect to his thermal spraying capability.

This standard is appropriate when demonstration of a manufacturer's capability to produce thermally sprayed construction, fulfilling specified quality requirements, are specified in one or more of the following:

- a contract between involved parties;
- an application standard;
- a regulatory requirement.

The requirements contained within this standard may be adopted in full or may be selectively deleted by the manufacturer if not applicable to the construction concerned. They provide a flexible framework for the control of thermal spraying in the following cases:

– Case 1

To provide specific requirements for thermal spraying in contracts which require the manufacturer to have a quality system in accordance with EN ISO 9001 or EN ISO 9002.

– Case 2

To provide specific requirements for thermal spraying in contracts which require the manufacturer to have a quality system other than EN ISO 9001 or EN ISO 9002.

– Case 3

To provide specific requirements for thermal spraying in contracts which require the manufacturer developing a quality system.

– Case 4

To provide specific requirements for thermal spraying in application standards which uses thermal spraying as part of its requirements or in a contract between relevant parties. It may however be more appropriate for EN ISO 14922-3 or EN ISO 14922-4 to be used in such cases.

## 2 Normative references

This European standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 473

Non-destructive testing – Qualification and certification of personnel

EN 582

Thermal spraying – Determination of the tensile adhesive strength

EN 657

Thermal spraying – Terminology – Classification

EN 1274

Thermal spraying – Powders – Composition – Technical supply conditions

EN 1395

Thermal spraying – Acceptance inspection of thermal spraying equipment

prEN 13214

Thermal spraying – Thermal spray coordination – Tasks and responsibilities

This is a free preview. Purchase the entire publication at the link below:

[Product Page](#)

- 
- [Looking for additional Standards? Visit Intertek Inform Infostore](#)
  - [Learn about LexConnect, All Jurisdictions, Standards referenced in Australian legislation](#)
-