



National Standards Authority of Ireland

IRISH STANDARD

**I.S. EN ISO 14922-4:1999**

ICS 25.220.20

**THERMAL SPRAYING - QUALITY  
REQUIREMENTS OF THERMALLY SPRAYED  
STRUCTURES - PART 4: ELEMENTARY  
QUALITY REQUIREMENTS (ISO 14922-4:1999)**

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English version

Thermal spraying - Quality requirements of thermally sprayed  
structures - Part 4: Elementary quality requirements (ISO 14922-  
4:1999)

Projection thermique - Exigences qualité des constructions  
obtenues par projection thermique - Partie 4: Exigences  
qualité élémentaires (ISO 14922-4:1999)

Thermisches Spritzen - Qualitätsanforderungen an  
thermisch gespritzte Bauteile - Teil 4: Elementar-  
Qualitätsanforderungen (ISO 14922-4:1999)

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.



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## **Foreword**

The text of EN ISO 14922-4:1999 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of an identical text or by endorsement, at the latest by December 1999, and conflicting national standards shall be withdrawn at the latest by December 1999.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 other than EN ISO 9001 or EN ISO 9002.

### – Case 2

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

### – Case 3

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.

## 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 adhesive tensile strength

EN 657

Thermal spraying – terminology – Classification

EN 1274

Thermal spraying – Powders – Composition – Technical supply conditions

EN ISO 9001

Quality systems – Model for quality assurance in design/development, production, installation and servicing (ISO 9001 : 1994)

EN ISO 9002

Quality systems – Model for quality assurance in production, installation and servicing (ISO 9002 : 1994)

prEN ISO 14919

Thermal spraying – Wires, rods and cords for flame and arc spraying – Classification – Technical supply conditions

EN ISO 14922-1

Quality requirements of thermally sprayed structures – Part 1: Guidelines for selection and use

ISO 8402 : 1994

Quality management and quality assurance – Vocabulary

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