



National Standards Authority of Ireland

IRISH STANDARD

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**THERMAL SPRAYING - QUALITY
REQUIREMENTS OF THERMALLY SPRAYED
STRUCTURES - PART 1: GUIDANCE FOR
SELECTION AND USE (ISO 14922-1:1999)**

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**Thermal spraying - Quality requirements of thermally sprayed
structures - Part 1: Guidance for selection and use (ISO 14922-
1:1999)**

Projection thermique - Exigences qualité des constructions
obtenues par projection thermique - Partie 1: Lignes
directrices pour leur sélection et utilisation (ISO 14922-
1:1999)

Thermisches Spritzen - Qualitätsanforderungen an
thermisch gespritzte Bauteile - Teil 1: Richtlinien zur
Auswahl und Verwendung (ISO 14922-1:1999)

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 14922-1:1999 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of an identical text or by endorsement, at the latest by December 1999, and conflicting national standards shall be withdrawn at the latest by December 1999.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.

Introduction

Thermal spraying processes are widely applied for producing industrial products. Thermal spraying has become increasingly important in parts of industrial application, manufacturing, maintenance and repair. It is applied on constructions in automotive industry, aerospace gasturbines, machinery construction, printing industry, chemical industry for anticorrosive purposes, antiwear, high temperature protection and against chemical attack, to mention some of the applications.

Consequently the thermal spraying process has a great influence on the production costs and completion of the product. Therefore it is important to apply the thermal spraying process in an effective way and to carry out quality management and assurance on any point of the production.

In the standard EN ISO 9000 and series for quality management systems for instance, the processes for protecting surfaces are pointed out as special processes, because most of the processes for surface protection cannot be NDT-controlled during the production in that way to guaranty that the required standard of quality has been fulfilled.

Quality cannot be put into a product by testing afterwards, but it has to be created in it by quality assurance during its manufacturing. Even the most developed and complete nondestructive testing procedures do not improve the quality of a thermal sprayed coating afterwards, they only give records upon its quality.

To use the thermal sprayed coating adequately and to avoid severe problems during the production and during operational time, controlling and supervising are necessary including the phases of construction, the choice of material, the production and the succeeding testing procedures.

To assure perfect thermal spraying manufacturing and to recognize sources of possible problems, the manufacturer's management has to introduce an adequate quality management.

1 Scope

This standard specifies guidelines to describe thermal spraying quality requirements suitable for application by the manufacturers using the thermal spraying process for coating new parts, for repair and maintenance. They are structured in the way that they can be used for any type of construction to be sprayed. These guidelines relate only to those aspects of the quality of the final construction to be sprayed which may be influenced by thermal spraying and allied processes (pre- and posttreatment, etc.).

The guidelines define various approaches to quality requirements for thermal spray works, both in workshops and on sites and to provide guidance for describing the capability of a manufacturer on producing thermally sprayed structures of the specified quality. They also can be used by any interested party as a basis for assessing a manufacturer's thermal spraying quality arrangements.

The guidelines are intended as a guide for the preparation of regulatory or contractual requirements and for a manufacturer's management to define the thermal spraying requirements for quality system related to the type of thermally sprayed construction. The guidelines are not structured to be used in isolation as a part of any regulatory contractual or managerial requirement.

These guidelines are intended to be used for the following purposes:

- a) providing interpretation of the requirements in the EN ISO 9000 series of standards, as a guideline for specification and establishment of the part of the quality system related to control of thermal spraying as a "Special Process";
- b) providing guidelines to establish specifications and thermal spraying quality requirements, where a quality system according to EN ISO 9001 and EN ISO 9002 is not involved;
- c) assessment of the thermal spraying quality requirements mentioned in a) and b) above.

The application of this standard would typically occur in the following circumstances:

- in contractual situation: specification of thermal spraying requirements for quality systems;
- by manufacturers: establishment and maintenance of thermal spraying quality requirements;
- by committees preparing structural codes or other application standards: specification of thermal spraying requirements;
- by interested parties, e.g. third parties, customers or manufacturers management. assessment of thermal spraying requirements.

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