



National Standards Authority of Ireland

IRISH STANDARD

I.S. EN 15311:2007

ICS 25.220.20

**THERMAL SPRAYING - COMPONENTS WITH
THERMALLY SPRAYED COATINGS -
TECHNICAL SUPPLY CONDITIONS**

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EUROPEAN STANDARD
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EUROPÄISCHE NORM

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English Version

**Thermal spraying - Components with thermally sprayed coatings
- Technical supply conditions**

Projection thermique - Eléments traités par projection
thermique - Conditions techniques de livraison

Thermisches Spritzen - Bauteile mit thermisch gespritzten
Schichten - Technische Lieferbedingungen

This European Standard was approved by CEN on 17 February 2007.

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Foreword

This document (EN 15311:2007) has been prepared by 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of an identical text or by endorsement, at the latest by September 2007, and conflicting national standards shall be withdrawn at the latest by September 2007.

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, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

EN 15311:2007 (E)

1 Scope

This European Standard specifies technical supply conditions when using thermally sprayed coatings for manufacturing or repair of components.

2 Normative references

The following referenced documents are indispensable for the application 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.

EN 473, *Non destructive testing — Qualification and certification of NDT personnel — General principles*

EN 582,, *Thermal spraying — Determination of tensile adhesive strength*

EN 657:2005, *Thermal spraying — Terminology, classification*

EN 1395, *Thermal spraying — Acceptance inspection of thermal spraying equipment*

EN 13214, *Thermal spraying — Thermal spray coordination — Tasks and responsibilities*

EN ISO 2063, *Thermal spraying — Metallic and other inorganic coatings — Zinc, aluminium and their alloys (ISO 2063:2005)*

EN ISO 4288, *Geometrical Product Specifications (GPS) — Surface texture: Profile method — Rules and procedures for the assessment of surface texture (ISO 4288:1996)*

EN ISO 8503-1, *Preparation of steel substrates before application of paints and related products — Surface roughness characteristics of blast-cleaned steel substrates — Part 1: Specifications and definitions for ISO surface profile comparators for the assessment of abrasive blast-cleaned surfaces (ISO 8503-1:1988)*

EN ISO 14918, *Thermal spraying — Approval testing of thermal sprayers (ISO 14918:1998)*

EN ISO 14923, *Thermal spraying — Characterization and testing of thermally sprayed coatings (ISO 14923:2003)*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 657:2005 apply.

4 Requirements

4.1 General requirements

4.1.1 Indication

This European Standard specifying the general requirements for supply conditions should be indicated in the parts list or in delivery instructions.

4.1.2 Qualification of the manufacturer

The manufacturer of the thermally sprayed coating for a component shall fulfil all requirements stipulated in the coating specification, should possess a quality management system, shall employ qualified personnel and is responsible to keep the spraying equipment in proper condition. The following standards shall be used to fulfil the requirements according to the quality requirements of the coated component:

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