



NSAI
Standards

Irish Standard
I.S. EN ISO 14647:2016

Metallic coatings - Determination of porosity in gold coatings on metal substrates - Nitric acid vapour test (ISO 14647:2000)

I.S. EN ISO 14647:2016

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:

EN ISO 14647:2016

Published:

2016-04-20

*This document was published
under the authority of the NSAI
and comes into effect on:*

2016-05-08

ICS number:

25.220.40

NOTE: If blank see CEN/CENELEC cover page

NSAI
1 Swift Square,
Northwood, Santry
Dublin 9

T +353 1 807 3800
F +353 1 807 3838
E standards@nsai.ie
W NSAI.ie

Sales:
T +353 1 857 6730
F +353 1 857 6729
W standards.ie

Údarás um Chaighdeáin Náisiúnta na hÉireann

National Foreword

I.S. EN ISO 14647:2016 is the adopted Irish version of the European Document EN ISO 14647:2016, Metallic coatings - Determination of porosity in gold coatings on metal substrates - Nitric acid vapour test (ISO 14647:2000)

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

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

EN ISO 14647

NORME EUROPÉENNE

EUROPÄISCHE NORM

April 2016

ICS 25.220.40

English Version

**Metallic coatings - Determination of porosity in gold
coatings on metal substrates - Nitric acid vapour test (ISO
14647:2000)**

Revêtements métalliques - Détermination de la
porosité des revêtements d'or sur les substrats de
métal - Essai à la vapeur d'acide nitrique (ISO
14647:2000)

Metallische Überzüge - Bestimmung der Porosität in
Goldbeschichtungen auf Metallsubstraten -
Salpetersäure-Dampftest (ISO 14647:2000)

This European Standard was approved by CEN on 2 April 2016.

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, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, 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: Avenue Marnix 17, B-1000 Brussels

EN ISO 14647:2016 (E)

Contents	Page
European foreword.....	3

European foreword

The text of ISO 14647:2000 has been prepared by Technical Committee ISO/TC 107 “Metallic and other inorganic coatings” of the International Organization for Standardization (ISO) and has been taken over as EN ISO 14647:2016 by Technical Committee CEN/TC 262 “Metallic and other inorganic coatings” the secretariat of which is held by BSI.

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 October 2016, and conflicting national standards shall be withdrawn at the latest by October 2016.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

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

Endorsement notice

The text of ISO 14647:2000 has been approved by CEN as EN ISO 14647:2016 without any modification.

This page is intentionally left blank

INTERNATIONAL STANDARD

**ISO
14647**

First edition
2000-03-15

Metallic coatings — Determination of porosity in gold coatings on metal substrates — Nitric acid vapour test

*Revêtements métalliques — Détermination de la porosité des revêtements
d'or sur les substrats de métal — Essai à la vapeur d'acide nitrique*



Reference number
ISO 14647:2000(E)

© ISO 2000

ISO 14647:2000(E)

PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

© ISO 2000

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 734 10 79
E-mail copyright@iso.ch
Web www.iso.ch

Printed in Switzerland

Contents

Page

Foreword.....	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Apparatus	2
5 Reagent	3
6 Safety	3
7 Procedure	3
8 Precision	5
9 Test report	5
Annex A (informative) Time of exposure to nitric acid vapour	6
Annex B (informative) Procedure recommended for avoiding the use of chlorinated hydrocarbons	7
Bibliography	8

ISO 14647:2000(E)

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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this International Standard may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 14647 was prepared by Technical Committee ISO/TC 107, *Metallic and other inorganic coatings*, Subcommittee SC 7, *Corrosion tests*.

Annexes A and B of this International Standard are for information only.

Introduction

Gold coatings are often specified for the contacts of separable electrical connectors and other devices. Electrodeposits are the form of gold that is most used on contacts, although it is also employed as clad metal and as weldments on the contact surface. The intrinsic nobility of gold enables it to resist the formation of insulating oxide films that could interfere with reliable contact operation.

In order that the nobility of gold be assured, porosity, cracks, and other defects in the coating that expose base metal substrates and underplates should be minimal or absent, except in those cases where it is feasible to use the contacts in structures that shield the surface from the environment or where corrosion inhibiting surface treatments for the deposit are employed. The level of porosity in the coating that may be tolerable depends on the severity of the environment to the underplate or substrate, design factors for the contact device like the force with which it is mated, circuit parameters, and the reliability of contact operation that it is necessary to maintain. Also, when present, the location of pores on the surface is important. If the pores are few in number and are outside the zone of contact of the mating surfaces, their presence can often be tolerated.

Methods for determining pores on a contact surface are most suitable if they enable their precise location and numbers to be determined. Contact surfaces are often curved or irregular in shape, and test methods should be suitable for them. In addition, the severity of porosity-determining tests may vary. The test method described in this International Standard is regarded as severe.

The relationship of porosity levels revealed by particular tests to contact behavior should be made by the user of these tests through practical experience or by judgement. Thus, absence of porosity in the coating may be a requirement for some applications, while a few pores on the critical surfaces may be acceptable for another. Such acceptance (or pass-fail) criteria should be part of the product specification for the particular product or part requiring the porosity test.

The test method described is highly sensitive and is capable of detecting virtually all porosity or other defects in gold coatings that could participate in substrate corrosion reactions. It is rapid, simple and inexpensive. In addition, it can be used on contacts having complex geometry such as pin-socket contacts. However, it is preferred that deeply recessed sockets are opened to expose their critical surfaces prior to testing.

The test method described is considered destructive in that it reveals the presence of porosity by contaminating the surface with corrosion products and by undercutting the coating at pore sites or at the boundaries of unplated areas. Any parts exposed to these tests should not be placed in service.

The test described involves corrosion reactions in which the products delineate defect sites in coatings. Since the chemistry, and properties of these products may not resemble those found in natural or service environments, these tests are not recommended for prediction of the electrical performance of contacts unless correlation is first established with service experience.

The test method described employs nitric acid (HNO_3) vapour at low relative humidity. Reaction of the gas mixture with a corrodible base metal at pore sites produces reaction products that appear as discrete spots on the gold surface. Individual spots are counted with the aid of a lens or low-power stereomicroscope.

The test method described is intended to be used for quantitative descriptions of porosity (such as number of pores per unit area or per contact) only on coatings that have a pore density sufficiently low that the corrosion sites are well separated and can be readily resolved. As a general guideline this can be achieved for pore densities up to about 100 per square centimetre or per 100 contacts. Above this value the tests are useful for the qualitative detection and comparison of porosity.

Metallic coatings — Determination of porosity in gold coatings on metal substrates — Nitric acid vapour test

WARNING: This International Standard does not purport to address all of the safety problems, if any, associated with its use. It is the responsibility of the user of this International Standard to establish appropriate safety and health practices and to determine the applicability of regulatory limitations prior to use. Specific precautionary measures are given in clause 6 and in 7.4, note 2.

1 Scope

This International Standard specifies equipment and a method for using nitric acid vapour to determine porosity in gold coatings, particularly electrodeposits and clad metals used on electrical contacts.

This method is designed to show whether the porosity level is less than or greater than some value that, by experience, is considered by the user to be acceptable for the intended application.

It is suitable for inlays or claddings containing 75 % or more of gold, for electrodeposits containing 95 % or more of gold or for substrates of copper, nickel and their alloys that are commonly used in electrical contacts.

The nitric acid vapour test is too severe to be used for gold coatings less than 0,6 µm thick. It is also not suitable for coatings that are less noble than gold or platinum, such as palladium and its alloys, or gold-flashed palladium and its alloys.

Several other porosity testing methods are described in ISO 10308 and in the literature (see e.g. Bibliography, [1] and [2]).

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this International Standard. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 2064, *Metallic and other inorganic coatings — Definitions and conventions concerning the measurement of thickness*.

ISO 2079, *Surface treatment and metallic coatings — General classification of terms*.

ISO 2080, *Electroplating and related processes — Vocabulary*.

ISO 10308, *Metallic coatings — Review of porosity tests*.

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
-