

<b>STN</b>	<b>Žiarové striekanie. Meranie elektrickej vodivosti žiarovo striekaných neželezných kovových povlakov pomocou metódy vírivých prúdov.</b>	<b>STN EN 16813</b>  03 8733
------------	--	--

Thermal spraying - Measurement of the electrical conductivity of thermal sprayed non-iron metal coatings by means of eddy current method

Táto norma obsahuje anglickú verziu európskej normy.  
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 04/17

Obsahuje: EN 16813:2016

**124615**

---

Úrad pre normalizáciu, metrológiu a skúšobníctvo Slovenskej republiky, 2017  
Podľa zákona č. 264/1999 Z. z. o technických požiadavkách na výrobky a o posudzovaní zhody a o zmene a doplnení niektorých zákonov v znení neskorších predpisov sa slovenská technická norma a časti slovenskej technickej normy môžu rozmnožovať alebo rozširovať len so súhlasom slovenského národného normalizačného orgánu.



EUROPEAN STANDARD

**EN 16813**

NORME EUROPÉENNE

EUROPÄISCHE NORM

November 2016

ICS 25.220.20

English Version

## Thermal spraying - Measurement of the electrical conductivity of thermal sprayed non-iron metal coatings by means of eddy current method

Projection thermique - Mesurage de la conductivité électrique des revêtements métalliques non ferreux obtenus par projection thermique, à l'aide de la méthode par courants de Foucault

Thermisches Spritzen - Messung der elektrischen Leitfähigkeit thermisch gespritzter Nichteisenmetallschichten mittels Wirbelstromverfahren

This European Standard was approved by CEN on 24 September 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**

<b>Contents</b>		Page
<b>European foreword</b> .....		3
<b>Introduction</b> .....		4
<b>1</b>	<b>Scope</b> .....	5
<b>2</b>	<b>Normative references</b> .....	5
<b>3</b>	<b>Terms and definitions</b> .....	5
<b>4</b>	<b>Measuring process</b> .....	6
<b>4.1</b>	<b>Measuring method</b> .....	6
<b>4.2</b>	<b>Calibration standard</b> .....	7
<b>4.3</b>	<b>Measuring frequency and penetration depth</b> .....	8
<b>4.4</b>	<b>Measuring instruments</b> .....	8
<b>4.5</b>	<b>Factors, which have effects on the uncertainty of the measurement</b> .....	9
<b>4.6</b>	<b>Limit of application</b> .....	9
<b>5</b>	<b>Procedure of the measurement</b> .....	10
<b>5.1</b>	<b>Calibration of the measuring instruments</b> .....	10
<b>5.2</b>	<b>Measurement</b> .....	10
<b>6</b>	<b>Measuring results and their assessment</b> .....	10
<b>7</b>	<b>Test report and documentation</b> .....	11
<b>Annex A (informative) Record for the applied Electrical Conductivity Measurement</b> .....		12
<b>A.1</b>	<b>General</b> .....	12
<b>A.2</b>	<b>Component/part</b> .....	12
<b>A.3</b>	<b>Surface preparation for spraying</b> .....	12
<b>A.4</b>	<b>Spraying procedure for component/part</b> .....	12
<b>A.5</b>	<b>Preparation of measurement</b> .....	13
<b>A.6</b>	<b>Measuring instrument</b> .....	13
<b>A.7</b>	<b>Result of the measured electrical conductivity</b> .....	13
<b>Bibliography</b> .....		14

## **European foreword**

This document (EN 16813:2016) 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 May 2017, and conflicting national standards shall be withdrawn at the latest by May 2017.

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

According to the CEN-CENELEC Internal Regulations, the national standards organisations 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.

## Introduction

In many applications, the electrical conductivity is a relevant technical parameter. For testing of imperfections in components or technological material properties the eddy current method can be very well applied. It can be detected or determined, for example:

- defects in welds;
- imperfections or change in the structure of a component, for example, due to aging processes in structures made out of aluminium;
- change in structure caused by temperature effects;
- thickness;
- physical material properties such as the electrical conductivity.

Due to an interaction between high frequency magnetic fields, emitted from a measuring probe, and the eddy currents induced in the object to be measured the electrical conductivity can be determined, e.g. according to ASTM E 1004 or can be used for fast and contact less measurements of a coating thickness according to EN ISO 21968.

Due to the manufacturing process thermal sprayed coatings contain a layer orientated structure. Dependent on the material used, it can also contain oxides and/or inclusions as well as porosity created due to splat boundary effects during spraying.

Besides the structure with its grain boundaries, dislocations, internal stresses and impurities, e.g. oxide skins, the specific gravity of a material plays an important role for the level of the electrical conductivity. In order to produce the highest possible level of electrical conductivity in the coating, the influencing factors for the thermal spraying process should be minimized.

## 1 Scope

This European standard specifies the procedure of the measurement of the electrical conductivity of non-Ferro-magnetic thermal sprayed coatings. By this measurement the absolute value of the electrical conductivity in the coating sprayed on component can be determined as well as also deviations from the agreed rated value can be used to control a running production. With that, a remarkable contribution can be applied to process and quality assurance measures of a manufacture process.

## 2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN ISO 21968, *Non-magnetic metallic coatings on metallic and non-metallic basis materials - Measurement of coating thickness - Phase-sensitive eddy-current method (ISO 21968)*

**koniec náhľadu – text ďalej pokračuje v platenej verzii STN**