

<b>STN</b>	<b>Žiarové striekanie Prášky Časť 1: Charakterizácia a technické dodacie podmienky (ISO 14232-1: 2017)</b>	<b>STN EN ISO 14232-1</b>  03 8713
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Thermal spraying - Powders - Part 1: Characterization and technical supply conditions (ISO 14232-1:2017)

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. 10/17

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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 ISO 14232-1**

NORME EUROPÉENNE

EUROPÄISCHE NORM

April 2017

ICS 25.220.20

Supersedes EN 1274:2004

English Version

## Thermal spraying - Powders - Part 1: Characterization and technical supply conditions (ISO 14232-1:2017)

Projection thermique - Poudres - Partie 1:  
Caractérisation et conditions techniques de livraison  
(ISO 14232-1:2017)

Thermisches Spritzen - Pulver - Teil 1:  
Zusammensetzung und technische Lieferbedingungen  
(ISO 14232-1:2017)

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EUROPÄISCHES KOMITEE FÜR NORMUNG

**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

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## European foreword

This document (EN ISO 14232-1:2017) has been prepared by Technical Committee ISO/TC 107 “Metallic and other inorganic coatings” in collaboration with 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of an identical text or by endorsement, at the latest by October 2017, and conflicting national standards shall be withdrawn at the latest by October 2017.

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.

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### Endorsement notice

The text of ISO 14232-1:2017 has been approved by CEN as EN ISO 14232-1:2017 without any modification.

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**Thermal spraying — Powders —  
Part 1:  
Characterization and technical supply  
conditions**

*Projection thermique — Poudres —*

*Partie 1: Caractérisation et conditions techniques de livraison*





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## 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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 107, *Metallic and other inorganic coatings*.

This first edition of ISO 14232-1, together with ISO/TR 14232-2, cancels and replaces ISO 14232:2000.

A list of all parts in the ISO 14232 series can be found on the ISO website.

## Introduction

For thermal spray processes that use material in a powder form, the powder can be considered as one of the main elements requiring control to produce an acceptable coating. The chemical and physical properties of powder play a fundamental role in the creation of desired coating properties. The size, shape and morphology of the powder particles determine the melting behaviour and therefore the processing of powders in general.

To keep the coating properties and the spray process as consistent as possible, it is very important to maintain all the characteristics of powder particles within limited tolerances.

An exception is granted to details on the properties of sprayed coatings. Such properties, which result from spraying conditions not covered by this document, e.g. gas composition, deposition efficiency, material flow rate, stand-off distance, etc., can differ greatly from the properties of the original powder.

The ISO 14232 series consists of two parts. This document examines the characterization of spray powders. ISO/TR 14232-2 is a technical report that examines how technical literature describes the application of powders.



# Thermal spraying — Powders —

## Part 1:

# Characterization and technical supply conditions

## 1 Scope

This document specifies measuring methods for the characterization of powders and their technical supply conditions. It is applicable to powders that are used in thermal spraying on the basis of their physical and chemical properties.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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.

ISO 3923-2, *Metallic powders — Determination of apparent density — Part 2: Scott volumeter method*

ISO 3954, *Powders for powder metallurgical purposes — Sampling*

ISO 4490, *Metallic powders — Determination of flow rate by means of a calibrated funnel (Hall flowmeter)*

ISO 10474, *Steel and steel products — Inspection documents*

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