

<b>STN</b>	<b>Žiarové striekanie Striekanie a pretavovanie samotroskotvorných zliatin (ISO 14920: 2023)</b>	<b>STN EN ISO 14920</b>  03 8712
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Thermal spraying - Spraying and fusing of self-fluxing alloys (ISO 14920:2023)

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. 11/23

Obsahuje: EN ISO 14920:2023, ISO 14920:2023

Oznámením tejto normy sa ruší  
STN EN ISO 14920 (03 8712) z augusta 2015

**137661**

EUROPEAN STANDARD

**EN ISO 14920**

NORME EUROPÉENNE

EUROPÄISCHE NORM

September 2023

ICS 25.220.20

Supersedes EN ISO 14920:2015

English Version

**Thermal spraying - Spraying and fusing of self-fluxing alloys (ISO 14920:2023)**Projection thermique - Projection et fusion d'alliages  
autofondants (ISO 14920:2023)Thermisches Spritzen - Spritzen und Einschmelzen von  
selbstfließenden Legierungen (ISO 14920:2023)

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**EN ISO 14920:2023 (E)**

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## **European foreword**

This document (EN ISO 14920:2023) 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of an identical text or by endorsement, at the latest by March 2024, and conflicting national standards shall be withdrawn at the latest by March 2024.

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## **Endorsement notice**

The text of ISO 14920:2023 has been approved by CEN as EN ISO 14920:2023 without any modification.

INTERNATIONAL  
STANDARD

ISO  
14920

Third edition  
2023-08

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**Thermal spraying — Spraying and  
fusing of self-fluxing alloys**

*Projection thermique — Projection et fusion d'alliages autofondants*



Reference number  
ISO 14920:2023(E)

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Published in Switzerland

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## ISO 14920:2023(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.

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 document 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)).

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This document was prepared by Technical Committee ISO/TC 107, *Metallic and other inorganic coatings*, in collaboration with the European Committee for Standardization (CEN) Technical Committee CEN/TC 240, *Thermal spraying and thermally sprayed coatings*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This third edition cancels and replaces the second edition (ISO 14920:2015), which has been technically revised.

The main changes are as follows:

- materials which can and can't be used for fusing have been clarified;
- grit blasting material has been defined;
- spray methods and their influence coating quality have been specified.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).



# Thermal spraying — Spraying and fusing of self-fluxing alloys

## 1 Scope

This document specifies the procedure for thermal spraying of self-fluxing alloys that are simultaneously or subsequently fused to create a homogeneous, diffusion-bonded coating.

## 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.

EN 13507, *Thermal spraying — Pre-treatment of surfaces of metallic parts and components for thermal spraying*

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