ISO 14920:2015-01 (E)

Thermal spraying - Spraying and fusing of self-fluxing alloys

Contents

Page

Foreword iv

Introduction v

1 Scope 1

2 Normative references 1

3 Influence on the substrate and design 1
3.1 Substrate metal 1
3.2 Design 1

4 Spray material of the self-fluxing alloy 2
4.1 Selection 2
4.2 Composition 2

5 Preparation of the component 2
5.1 General 2
5.2 Methods of surface preparation 3
5.3 Cleanliness 3

6 Spray and fusion process 3
6.1 Spraying with simultaneous fusion 3
6.1.1 Procedure 3
6.1.2 Particle size and particle size range of the powder particles 3
6.1.3 Coating thickness 3
6.2 Spraying with subsequent fusion 4
6.2.1 Procedure 4
6.2.2 Particle size and particle size range of the powder particles 4
6.2.3 Coating thickness 4
6.3 Spraying technique -- Procedure 4
6.3.1 General 4
6.3.2 Preheating 4
6.3.3 Spraying 4
6.3.4 Fusing the deposit 5
6.3.5 Cooling 5

7 Final machining 5

8 Hardness testing 5
8.1 General 5
8.2 Standard hardness test 6

Annex A (informative) Reference values for the expected hardness of the fused coating 7

Bibliography 8