

# DIN EN 14866:2006-05 (E)

## Vitreous and porcelain enamels - Regenerative, enamelled and packed panels for air-gas and gas-gas heat exchangers - Specifications

---

<b>Contents</b>		<b>Page</b>
Foreword .....		3
1	Scope .....	4
2	Normative references .....	4
3	Terms and definitions .....	4
4	Steel substrates .....	6
4.1	Delivery .....	6
4.2	Analysis .....	6
4.3	Hydrogen permeability .....	6
4.4	Fish scale test .....	6
4.5	Pickling speed .....	6
5	Enamel frit(s) .....	7
5.1	Delivery .....	7
5.2	Coefficient of expansion .....	7
5.3	Fusion flow .....	7
5.4	Boiling water vapour resistance .....	7
5.5	Acid resistance .....	7
5.6	Thermal shock resistance .....	7
5.7	Adherence .....	8
6	Characteristics of the enamel coating .....	8
6.1	Adherence .....	8
6.2	Thickness .....	8
6.3	Thermal shock resistance .....	9
6.4	Fundamental defects .....	9
6.5	Open defects .....	9
6.6	Edge covering of gas-gas heaters .....	10
6.7	Boiling sulphuric acid resistance .....	10
6.8	Rework .....	10
7	Characteristics after packing .....	10
7.1	Packing pressure .....	10
7.2	Visual examination .....	10
7.3	Edge covering of gas-gas heaters .....	11
8	Documentation .....	11
Annex A (normative)	Method for determining thermal shock resistance of vitreous or porcelain enamel coatings .....	12