

# DIN EN 13507:2010-06 (E)

## Thermal spraying - Pre-treatment of surfaces of metallic parts and components for thermal spraying

---

<b>Contents</b>		<b>Page</b>
Foreword .....		3
1	Scope .....	4
2	Normative references .....	4
3	Principles .....	4
4	Methods of surface preparation .....	5
4.1	General .....	5
4.2	Degreasing .....	5
4.3	Grit blasting .....	5
4.4	Threading/grooving .....	7
4.5	Cleaning by reversed transferred arc .....	7
4.6	Bond coatings .....	7
4.7	Precautions for health, safety and environmental protection .....	7
5	Preheating .....	7
6	Masking of areas not to be coated .....	8
7	Effect of pre-treatment on the fatigue strength .....	8
Bibliography .....		9