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THERMAL SPRAYING - ACCEPTANCE INSPECTION OF THERMAL SPRAYING EQUIPMENT - PART 3: ARC SPRAYING

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EUROPEAN STANDARD

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English Version

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Projection thermique - Contrôle d'acceptation du matériel de projection thermique - Partie 3: Projection à l'arc

Thermisches Spritzen - Abnahmeprüfungen für Anlagen zum thermischen Spritzen - Teil 3: Lichtbogenspritzen

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Contents

Page

Foreword 3
1 Scope 4
2 Normative references 4
3 Terms and definitions 4
4 Principles of acceptance inspection 4
5 Procedure of acceptance inspection 5
6 Designation 5
7 Inspection report 5
Annex A (informative) Inspection report for arc spraying equipment (initial test/retest) 6
Bibliography 8

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Foreword

This document (EN 1395-3:2007) has been prepared by 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of an identical text or by endorsement, at the latest by July 2007, and conflicting national standards shall be withdrawn at the latest by July 2007.

This document together with EN 1395-1, 1395-2, 1395-4, 1395-5, 1395-6 and 1395-7 supersedes EN 1395:1996.

EN 1395 consists of the following Parts, under the general title *Thermal spraying — Acceptance inspection of thermal spraying equipment*:

— *Part 1: General requirements;*

— *Part 2: Flame spraying including HVOF;*

— *Part 3: Arc spraying;*

— *Part 4: Plasma spraying;*

— *Part 5: Plasma spraying in chambers;*

— *Part 6: Manipulator systems;*

— *Part 7: Powder feed systems.*

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1 Scope

This European Standard specifies requirements for the acceptance inspection of thermal spraying equipment, in this case arc spraying, used to produce thermally sprayed coatings of reproducible quality.

This part should be used in conjunction with EN 1395-1, which includes general requirements and explanations of procedures.

2 Normative references

The following referenced documents are indispensable for the application 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 657:2005, *Thermal spraying — Terminology, classification*

EN ISO 14919:2001, *Thermal spraying — Wires, rods and cords for flame and arc spraying — Classification — Technical supply conditions (ISO 14919:2001)*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 657:2005 apply.

4 Principles of acceptance inspection

4.1 General

The following clauses reveal state of the art technology in thermal spraying equipment and the minimum requirements concerning a stable parameter setting and maintenance as given in Annex A.

4.2 Atomising gas

The atomising gas hoses and the control device shall be designed in such a manner that an undisturbed operation is ensured.

4.3 Arc spraying nozzle

The nozzle system (contact tubes and air nozzle) shall permit a constant arc to be maintained and provide atomisation without causing deposits that might disturb the operation.

4.4 Spraying wire feed unit

A continuously controllable and reproducible feed of the wires shall be provided. A precondition for this is an adequate constant air pressure and supply of electrical power.

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