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Welding - Test for shop primers in relation to welding and allied processes - Part 1: General requirements (ISO 17652-1:2003)

Soudage - Essai sur peintures primaires en relation avec le soudage et les techniques connexes - Partie 1: Exigences générales (ISO 17652-1:2003)

Schweißen - Prüfung von Fertigungsbeschichtungen für das Schweißen und für verwandte Prozesse - Teil 1: Allgemeine Anforderungen (ISO 17652-1:2003)

This European Standard was approved by CEN on 2 January 2003.

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EN ISO 17652-1:2003 (E)

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Foreword

This document (EN ISO 17652-1:2003) has been prepared by Technical Committee CEN/TC 121 "Welding", the secretariat of which is held by DS, in collaboration with Technical Committee ISO/TC 44 "Welding and allied processes".

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of an identical text or by endorsement, at the latest by November 2003, and conflicting national standards shall be withdrawn at the latest by November 2003.

EN ISO 17652 consists of the following parts, under the general title: *Welding – Test for shop primers in relation to welding and allied processes*:

- *Part 1: General requirements*
- *Part 2: Welding properties of shop primers*
- *Part 3: Thermal cutting*
- *Part 4: Emission of fumes and gases*

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Luxembourg, Malta, Netherlands, Norway, Portugal, Slovakia, Spain, Sweden, Switzerland and the United Kingdom.

EN ISO 17652-1:2003 (E)

1 Scope

This part of this European Standard specifies standardised conditions for an assessment of shop primers on the weldability of steel materials. The standard is intended to be used for assessment of shop primers by:

- testing by the suppliers during development of new shop primers;
- testing by the suppliers during production as part of a quality control scheme;
- declaration of the properties of shop primers by suppliers;
- use as a reference in contracts between suppliers and customers for deliveries of shop primers;
- acceptance testing of shop primers by customers.

The standard can also be used for comparisons between different shop primers using the welding procedure appropriate for the task, or between the different welding procedures using a specific shop primer. For guidance on application see clause 4.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text, and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

EN ISO 17652-2:2003, *Welding - Test for shop primers in relation to welding and allied processes - Part 2: Welding properties of shop primers (ISO 17652-2:2003)*.

EN ISO 17652-3, *Welding - Test for shop primers in relation to welding and allied processes - Part 3: Thermal cutting (ISO 17652-3:2003)*.

EN ISO 17652-4, *Welding - Test for shop primers in relation to welding and allied processes - Part 4: Emission of fumes and gases (ISO 17652-4:2003)*.

3 Terms and definitions

For the purposes of this European Standard, the following terms and definitions apply.

3.1 emission test
this test describes a method for evaluating the influence of shop primers on the emission of fumes and gasses during welding

3.2 rating test
this screening test provides a method of assessing the relative weldability of shop primers of a specified thickness by making a standard weld over a range of shop primers and subsequently evaluating of the severity of the resulting porosity

3.3 shop primer
primer made for corrosion protection of steel in the production period. The shop primer is applied uniformly in a controlled thickness to abrasive blasted steel plates. It should be possible to weld and cut shop primed materials. The demand on corrosion protection may vary from one application to another. The term prefabrication primer is equivalent to shop primer

3.4 supplier
manufacturer of shop-primer