

# SVENSK STANDARD

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### **Termisk sprutning – Metalliska och andra oorganiska beläggningar – Zink, aluminium och dess legeringar – Del 2: Villkor för utförande av korrosionsskydd genom termisk sprutning (ISO 2063-2:2017)**

### **Thermal spraying – Zinc, aluminium and their alloys – Part 2: Execution of corrosion protection systems (ISO 2063-2:2017)**

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Denna standard ersätter SS-EN ISO 2063:2005, utgåva 1.

The European Standard EN ISO 2063-2:2017 has the status of a Swedish Standard. This document contains the official version of EN ISO 2063-2:2017.

This standard supersedes the Swedish Standard SS-EN ISO 2063:2005, edition 1.

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EUROPEAN STANDARD

**EN ISO 2063-2**

NORME EUROPÉENNE

EUROPÄISCHE NORM

October 2017

ICS 25.220.20; 25.220.40

Supersedes EN ISO 2063:2005

English Version

## Thermal spraying - Zinc, aluminium and their alloys - Part 2: Execution of corrosion protection systems (ISO 2063- 2:2017)

Projection thermique - Zinc, aluminium et alliages de  
ces métaux - Partie 2: Exécution des système de  
protection contre la corrosion (ISO 2063-2:2017)

Thermisches Spritzen - Zink, Aluminium und ihre  
Legierungen - Teil 2: Ausführung von  
Korrosionsschutzsystemen (ISO 2063-2:2017)

This European Standard was approved by CEN on 31 August 2017.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**



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## **European foreword**

This document (EN ISO 2063-2:2017) has been prepared by Technical Committee ISO/TC 107 “Metallic and other inorganic coatings” in collaboration with 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 April 2018, and conflicting national standards shall be withdrawn at the latest by April 2018.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 2063:2005.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

### **Endorsement notice**

The text of ISO 2063-2:2017 has been approved by CEN as EN ISO 2063-2:2017 without any modification.



# Thermal spraying — Zinc, aluminium and their alloys —

## Part 2: Execution of corrosion protection systems

### 1 Scope

This document specifies requirements for corrosion protection of steel structures, components or parts, which are coated by thermal spraying of zinc, aluminium or their alloys.

This document specifies requirements for coating manufacturers of surface preparation, thermal spraying, testing and post treatments, e.g. sealing of the coating. This document applies to metallic corrosion protection coatings in the case of new fabrication in the workshop, as well as on-site and for repair on-site after assembly.

Requirements for coating thickness, minimum adhesive strength and surface conditions, specified in a coating specification, are given.

Recommendations are given for suitable process steps and quality assurance measures for new production and maintenance and for supervising of corrosion protection works.

This document covers the application of thermal-sprayed zinc, aluminium and their alloys for protection against corrosion in the temperature range between  $-50\text{ °C}$  to  $+200\text{ °C}$ . Heat-resistant protective coatings of aluminium are covered by ISO 17834 and are not in the scope of this document.

This document specifies requirements for the equipment, the working place and the qualification of the spray and testing personnel.

NOTE ISO 2063-1:2017 is addressed to the designer and to the planning engineer of corrosion protection system.

### 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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.

ISO 1463, *Metallic and oxide coatings — Measurement of coating thickness — Microscopical method*

ISO 2063-1, *Thermal spraying — Zinc, aluminium and their alloys — Part 1: Design considerations and quality requirements for corrosion protection systems*

ISO 2178, *Non-magnetic coatings on magnetic substrates — Measurement of coating thickness — Magnetic method*

ISO 4624, *Paints and varnishes — Pull-off test for adhesion*

ISO 8044, *Corrosion of metals and alloys — Basic terms and definitions*

ISO 8501-1:2007, *Preparation of steel substrates before application of paints and related products — Visual assessment of surface cleanliness — Part 1: Rust grades and preparation grades of uncoated steel substrates and of steel substrates after overall removal of previous coatings*