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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 11373-2017

Replacing GB 11373-1989

**Thermal spraying - Pre-treatment of surfaces of metallic parts
and components**

热喷涂 金属零部件表面的预处理

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009. This standard replaces GB/T 11373-1989 "Thermal Sprayed Metal Parts Surface Pretreatment General," compared with GB/T 11373-1989 main Technical differences are as follows:

--- Complement the surface pretreatment method;

--- Supplementary preheating requirements;

--- Complement the non-painted area of the shelter requirements;

--- Supplementary pretreatment on the impact of fatigue strength analysis. This standard is proposed by the China Machinery Industry Federation. This standard by the National Metal and Nonmetallic Coating Standardization Technical Committee (SAC/TC57) centralized. This standard was drafted. Wuhan Institute of Materials Protection, Jiangsu Zhongzheng Dazheng Surface Engineering Co., Ltd., Ma On Shan Dingtai Rare Earth New Materials Co., Ltd., Foshan Advanced Surface Technology Co., Ltd., Tongxiang Tiansheng Line Equipment Co., Ltd., Wuhan University of Technology, Shengli Oil Tianxin large tube technology development limited liability company, Dongying Yellow River Delta standard technical service center, Shenzhen Kechuang standard service center. The main drafters of this standard. Wu Jianhua, Ni Ya, Li Yue, Li Zhigang, Liu Ji Lu, Shi Zhimin, Shen Hongwei, Dingzhang Xiong, Wu Guohua, Guo Jisong, Wu Yongtai, Geng Jianchao, Wang Ke. This standard replaces the standards previously issued as.

--- GB/T 11373-1989. Thermal spraying of metal parts surface pretreatment

1 Scope

GB/T 11373-2017 is the Chinese national standard on thermal spraying - pre-treatment of surfaces of metallic parts and components, in the field of manufacturing engineering. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes

binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 29 September 2017 by the General Administration of Quality Supervision, Inspection and Quarantine of the People's Republic of China; Standardization Administration of China, and has been in force since 1 April 2018. Classification: ICS 25.220.10, CCS A29. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This standard specifies the thermal spraying of metal parts surface pretreatment process, a clear surface thermal spraying metal parts should be pre-treatment Important principles to consider. This standard applies to the production of new parts, but also for the repair of old parts. For corrosion-resistant thermal spraying zinc, aluminum and its alloy coating see GB/T 9793.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version applies to this article Pieces. For undated references, the latest edition (including all amendments) applies to this document. Visual inspection of surface cleanliness of steel surfaces before application of coatings - Part 1. Uncoated steel Surface and the full removal of the original coating steel surface corrosion level and treatment level

GB/T 9793 thermal spraying metal and other inorganic coatings zinc, aluminum and their alloys

GB/T 13288.1 Steel substrates before application of paints and varnishes - Surface roughness characteristics of blast-cleaned steel substrates - Part 1. Technical requirements and definitions for comparison of ISO surface roughness for steel surface roughness after blasting

GB/T 13288.2 steel coating before coating surface treatment after blasting steel surface roughness characteristics Part 2. Abrasive Determination of surface roughness of steel after blasting - Method of comparative sample block method

GB/T 13288.3 steel surface coating before application of spray-cleaned steel surface roughness characteristics Part 3. ISO Surface roughness comparison sample block calibration and surface roughness measurement method microscope focusing method

GB/T 13288.4 Steel substrates before application of paints and varnishes - Surface roughness characteristics of spray - cleaned steel parts - Part 4. ISO Surface Roughness - Comparison of Blocks for the Calibration and Determination of Surface Roughness - Stylus Method

GB/T 13288.5 steel before coating the surface treatment after blasting steel surface roughness characteristics - Part 5. Surface Roughness determination method Copy tape method

GB/T 17850.1 before coating the steel surface treatment spray cleaning non-metallic abrasive technical requirements guidelines and classification

GB/T 18719 thermal spraying terminology, classification

GB/T 18838.1 before coating the steel surface treatment jet cleaning metal abrasive technical requirements guidelines and classification ISO 11124-

2 Steel sheets for painting - Surface preparation - Technical requirements for metal abrasives for blast cleaning - Part 2. Chilled cast iron Sand

(Preparation of steel substrates before application of paints and related products - Specifications for metallic blast-cleaning abrasives - Part