

ICS 25.220.20

CCS A29



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

GB/T 11374-2012

Replacing GB/T 11374-1989

**Thermal spraying coating - Nondestructive methods for
measurement of thickness**

热喷涂涂层厚度的无损测量方法

Issued on: September 3, 2012

Implemented on: March 1, 2013

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China;
Standardization Administration of China**

Table of Contents

- 1 Scope
- 2 Normative references
- 3 Terms and Definitions

Foreword

This standard rule according to GB/T 1.1-2009 given draft. This standard replaces GB/T 11374-1989 "non-destructive method for measuring the thickness of the thermal spray coatings." Compared with the GB/T 11374-1989 The main changes are as follows:

- Adds a second chapter references;
- Modify the third chapter name and explain some of the terminology;
- Revised Chapter determining part of the reference surface;
- Modify part of Chapter VI of local thickness measurements. The standard proposed by China Machinery Industry Federation. This standard layer Standardization Technical Committee (SAC/TC57) administered by the National Metal and non-metal cover. This standard was drafted. Wuhan Institute of Material Protection, the front surface of Coal Mine Engineering Ltd., Jiangsu. The main drafters of this standard. Wang Hongsheng, Yansheng Gui, Zhang Ji Shu, Hong Wei. This standard replaces the standards previously issued as follows:
 - GB/T 11374-1989. Non-destructive measurements of the thickness of the thermal spray coatings

1 Scope

GB/T 11374-2012 is the Chinese national standard on thermal spraying coating - nondestructive methods for measurement of thickness, 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 3 September 2012 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 March 2013. Classification: ICS 25.220.20, 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 terms selection, measurement of thermal spray coating thickness measurement, the measurement reference surface and determine the thickness locally. This standard applies to all thermal spray process, a variety of magnetic metal substrates include flame spraying, arc spraying, plasma spraying and other prepared Non-magnetic and non-magnetic coatings on metal substrates thickness measurement and evaluation of a non-conductive coating on the body.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated edition applies to this article Member. For undated references, the latest edition (including any amendments) applies to this document.

GB/T 4956 magnetic substrates on the non-magnetic coatings - Measurement of coating thickness - Magnetic method The

GB/T 4957 non-magnetic metal layer covering non-conductive coating thickness measurement eddy current method

GB/T 6463 Reviews on metals and other inorganic coating layer thickness measurement

GB/T 12334 metals and other inorganic coatings - Definitions and general rules on thickness measurement

GB/T 18719 thermal spraying terminology, classification

3 Terms and Definitions

GB/T 12334 and GB/T 18719 defined and the following terms and definitions apply to this document.

3.1 The main surface significant surface Some of the coated surface has to be coated or covered with layers on the workpiece, the cover layer on its performance or appearance are critical on the surface.

3.2 Measuring surface measuring area As the main surface area of a single measurement. Non-destructive method for measuring surface area in contact with the probe readings or regional impact.

3.3 Reference surface reference area It requires a single measurement frequency region specified.

3.4 Local thickness local thickness Averaged over a reference surface of a predetermined number of times thickness were measured.

3.5 The minimum local thickness minimum local thickness The local minimum thickness

single major surface of the workpiece measured in.

3.6 Maximum local thickness maximumlocalthickness The maximum thickness of the main surface in the local single workpiece measured in.

chinastandards.org - PREVIEW