

QUALITY STANDARD FOR

HV ISOFUSION®

GLASS COATINGS

1. SCOPE

This Standard specifies the quality requirements for the HV ISOFUSION® process for glass coating by vitreous enameling of panels intended for use in the construction of tanks for uses such as the storage of potable water or municipal sludge.

This Standard applies to the enameling elements of the HV ISOFUSION® process, however, the quality criteria in Section 5.2 should apply to the tank as built. The HV ISOFUSION® glass coating has been developed with reference to International Standard specifications for glass coatings on bolted steel panels and conforms to ISO 28765⁽¹⁾.

2. DEFINITIONS

For the purposes of this Standard, the following definitions shall apply.

Glass coating: Any coating, commonly also referred to as vitreous enamel, based on silica Glass-Fused-to-Steel sheets by the HV ISOFUSION® process at temperatures sufficient to cause glass melting and chemical bonding to the substrate so as to form a composite glass/steel panel.

Supplier: Any company supplying Fusion Tanks and Silos with any materials for use in the HV ISOFUSION® process.

Defect: Any void, break, crack, thin spot, blister, foreign inclusion or contamination of the glass coating.

Discontinuity: Any defect which allows an electric current to pass through the glass coating when testing using the specified instrument operated in accordance with Section 5.2.2 of this Standard.

3. GENERAL

The inspection procedures specified in this Standard and the HV ISOFUSION® enameling process shall be carried out under quality management systems accredited to ISO 9001⁽²⁾.

4. RAW MATERIALS

4.1 The steel used shall have a specification as agreed between Fusion Tanks and Silos and the steel supplier having due regard to the requirements of the enameling process.

4.2 All other raw materials used in the production of the glass coated panels shall be inspected on receipt at Fusion Tanks and Silos' premises to ensure that they meet Fusion Tanks and Silos' specifications.

4.3 Where Fusion Tanks and Silos is not able to inspect raw material against any aspect of Fusion Tanks and Silos' specification or the specification according to Clause 5.1.1 (for example, chemical composition of steels, flow bead tests of glass etc.), Fusion Tanks and Silos shall require the supplier to carry out such inspections at the suppliers premises and provide Fusion Tanks and Silos with authorized copies of certificates for such inspections and record conformity of the raw materials in accordance with the Quality Specification, and make certified copies of those records available.

5. QUALITY**5.1 Glass Coating**

Glass coated test samples shall be regularly tested to ensure that the properties of the glass coating meet the requirements of this Standard and Fusion Tanks and Silos' specification.

5.1.1 Quality Specification

Tests shall be carried out to ensure that the glass coating on the contact enamel surface meets the chemical resistance and physical property specifications set out in Table 1.

TABLE 1 - CHEMICAL RESISTANCE AND PHYSICAL PROPERTIES

	TEST STANDARD	QUALITY SPECIFICATION	MINIMUM TEST FREQUENCY
CHEMICAL RESISTANCE (Inside Surface)			
Citric acid at room temperature	ISO 28706-1:2008 ⁽³⁾ Clause 9	Class A+	Monthly
Boiling citric acid	ISO 28706-2:2008 ⁽⁴⁾ Clause 10	Maximum weight loss 3g/m ² after 2½ hours	Annually
Boiling distilled or demineralized water Liquid phase	ISO 28706-2:2008 Clause 13	Maximum weight loss 4g/m ² after 48 hours	Annually
Hot sodium hydroxide	ISO 28706-4:2008 ⁽⁵⁾ Clause 9	Maximum weight loss 7g/m ² after 24 hours	Annually
PHYSICAL PROPERTIES (Inside Surface)			
Impact	ISO 4532 ⁽⁶⁾ , 30N force.	Maximum cracking 2mm after 24 hours	Monthly
Adherence level	EN 10209: Annex D ⁽⁷⁾	Class 2	Monthly
Scratch hardness	EN 15771 ⁽⁸⁾	Mohs 5	Monthly

5.2 Finished Panels

Finished panels shall be inspected following the enameling process, prior to packing and dispatch from Fusion Tanks and Silos' premises. Fusion Tanks and Silos shall carry out inspections on both the inside and the outside surfaces. In cases where both the inside and the outside surfaces of the panel are in contact with the stored liquid both surfaces shall be treated as inside surfaces for the purposes of this Standard.

5.2.1 Inspection of the Outside Surface

The outside surface of all panels shall be inspected visually under good daylight or equivalent lighting for defects in the glass coating. Any panel having visible

defects larger than 0.04" shall be rejected. Any panel having more than three visible defects per m² of the total panel area shall be rejected. All visible defects on the outside surface of accepted panels shall be repaired using a repair material approved by Fusion Tanks and Silos for this purpose and applied according to the repair material manufacturer's instructions.

5.2.2 Inspection of the Inside Surface

The inside panel surface shall be inspected using a high voltage tester approved by Fusion Tanks and Silos for this purpose and used in accordance with Test A of EN 14430⁽⁹⁾ and Clause 5.2.2.1. Inspection shall be carried out on every panel and any panel

5. ISO 28706-4:2008

Vitreous and porcelain enamels –
Determination of resistance to
chemical corrosion – Part 4:
Determination of resistance to
chemical corrosion by alkaline
liquids using a cylindrical vessel.

6. ISO 4532:1991

Determination of the resistance of
enameled articles to impact - Pistol
test.

7. EN 10209:1996

Annex D: Cold-rolled low carbon
steel flat products for vitreous
enameling.

8. EN 15771:2010

Vitreous and porcelain enamels –
Determination of surface scratch
hardness according to the Mohs
scale.

9. EN 14430:2004

Vitreous and porcelain enamels –
High voltage test.

10. EN ISO 2178:1995

Non-magnetic coatings on magnetic
substrates – Measurement of coating
thickness – Magnetic method.

11. ISO 2859:1999

Sampling procedure for inspection
by attributes - Part 1: sampling
schemes indexed by Acceptance
quality limit (AQL) for lot-by-lot
inspection.