CONTENTS

	Preface	9
1	**Introduction**	11
2	**Physical principles of plasma spraying process**	15
2.1	Plasma beam	15
2.1.1	Characteristics of plasma beam	15
2.1.2	Temperature and output of plasma beam	19
2.1.3	Outlet velocity	22
2.2	Plasma gases	25
2.2.1	Dissociation, ionization and enthalpy of plasma-forming gases	26
2.2.1.1	Nitrogen	28
2.2.1.2	Hydrogen	28
2.2.1.3	Argon and helium	28
2.2.2	Thermal conductivity of plasma	29
2.2.3	Electric conductivity of plasma	30
2.3	Formation of plasma coatings	31
2.3.1	Powder transport, flight path and velocity of the sprayed particles	31
2.3.2	Interactions of molten material with the plasma beam and the surrounding atmosphere	34
2.3.3	Impingement of flying particles on the substrate	37
2.3.4	Thermal effects of the substrate and the sprayed layer	39
2.3.5	Physical and chemical transformation of material in spraying	42
2.4	Basic properties of plasma coatings	45
2.4.1	Structure	45
2.4.2	Density and porosity	47
2.4.3	Bonding, internal stresses, layer thickness	48
2.4.4	Strength, hardness, formability	49
2.4.5	Thermal and electrical conductivity	51
3	**Equipment and accessories for plasma spraying technology**	53
3.1	Principal scheme of plasma spraying equipment	53
3.2	Plasma torches	54
3.2.1	Plasma torches of foreign production	55
3.2.2	Plasma torches of domestic production — gas torch type 7-S and water-stabilized torch PAL-160-2	60

3.3 Powder feeder . . . 63
3.3.1 Simple powder feeder type P 30 . . . 63
3.3.2 Double feeder, type TWIN 10 . . . 65
3.4 Direct current sources . . . 67
3.5 Control box . . . 70
3.6 Cooling system . . . 74
3.7 Equipment for air exhaust and intake . . . 76
3.8 Gas system . . . 78
3.8.1 Pressure vessels with compressed gases . . . 78
3.8.2 Evaporation station of liquified gases . . . 80
3.9 Automatic plasma spraying equipment . . . 82
3.9.1 FRB-8-300 automatic machine . . . 82
3.9.2 WSP 500/1500 automatic equipment . . . 84
3.9.3 Automatic equipment for spraying gas turbine runner discs . . . 85
3.9.4 Industrial spraying robots . . . 86
3.9.5 ROB-LH-1 robotized spraying system . . . 89

4 Bonding and adherence of plasma coatings to the substrate . . . 91

4.1 Kinds of bonding forces . . . 91
4.2 Theoretical aspects of optimum adherence . . . 93
4.3 Main factors affecting the adherence of coating to substrate . . . 96
4.3.1 Coating thickness . . . 96
4.3.2 Preliminary preparation of substrate surface . . . 97
4.3.3 Spraying process parameters . . . 99
4.4 Experimental evaluation of adherence of plasma-sprayed coatings to substrate . . . 100
4.4.1 Test methods to determine adherence . . . 100
4.4.2 Adherence test according to DIN 50 160 Standard . . . 101
4.4.3 Adherence test according to DIN 50 161 . . . 103
4.4.4 Adherence test by the stud method . . . 104
4.4.5 Evaluation and comparison of the test methods . . . 107
4.5 Metallographic analysis of the bond . . . 110
4.5.1 Bond of metallic coating with substrate . . . 110
4.5.2 Bond of ceramic coating with NiAl interlayer on the substrate . . . 112
4.6 Adherence of metallic and ceramic plasma-sprayed coatings . . . 116
4.7 The effect of main parameters of plasma spraying on adherence of K 40, K 50 and K 55 powders to steel . . . 119
4.7.1 Method, materials and equipment used . . . 121
4.7.2 The effects of spraying distance and electric output on the adherence . . . 121
4.7.3 The effect of carrying gas flow rate on adherence . . . 122
4.7.4 The effect of fed powder volume on adherence . . . 123
4.7.5 The effect of powder granularity on adherence . . . 124

5 Selection of powders for plasma spraying in industrial applications . . . 126

5.1 Informative table for selection of suitable powders . . . 126
5.2 Most typical industrial applications of plasma-sprayed coatings . . . 140
5.2.1 Wear resistance (A) . . . 140
5.2.2 Resistance against oxidation, high temperature and red heat (B) . . . 144

5.2.3 Corrosion resistance (C) . . . 145
5.2.4 Electrical conductivity and electrical resistance (D) . . . 146
5.2.5 Renovation of worn parts (E) . . . 147

6 Technological procedure of plasma spraying . . . 149

6.1 Preliminary preparation of surfaces prior to spraying . . . 149
6.1.1 Mechanical machining . . . 149
6.1.2 Chemical degreasing . . . 151
6.1.3 Abrasive cleaning . . . 151
6.2 Application of interlayers improving adherence . . . 156
6.2.1 General properties of interlayers . . . 156
6.2.2 Molybdenum . . . 157
6.2.3 Nickel-aluminium . . . 158
6.2.4 Niobium, tantalum, nickel, nickel-chromium . . . 159
6.2.5 Cermet interlayers . . . 159
6.3 Spraying procedure . . . 160
6.3.1 Plasma gas selection . . . 160
6.3.2 Working parameters of the spraying process . . . 162
6.3.2.1 The effect of working parameters on the coating density . . . 163
6.3.2.2 The effect of electric input and gas flow rate . . . 163
6.3.2.3 The effect of distance . . . 164
6.3.2.4 The effect of volume of powder fed . . . 165
6.3.2.5 The effect of powder granularity . . . 165
6.3.3 Masking . . . 166
6.3.4 Preheat and cooling . . . 167
6.3.5 Spraying on convex rotary and planar surfaces . . . 169
6.3.6 Spraying of cylindrical surfaces and cavities from inside . . . 176
6.3.6.1 Plasma torches for internal spraying of cylindrical surfaces . . . 176
6.3.6.2 Technological procedure . . . 178
6.3.7 Spraying in shielding atmospheres . . . 180
6.3.7.1 Plasma spraying in local inert atmosphere . . . 182
6.3.7.2 Inert chamber . . . 185
6.3.7.3 Vacuum chamber . . . 186
6.4 Final treatment of the sprayed surface . . . 189
6.4.1 Sealing and remelting of coatings . . . 189
6.4.2 Chip machining . . . 190
6.4.3 Grinding . . . 191

7 Application of plasma-sprayed coatings in industry and research . . . 194

7.1 A survey of industrial applications of plasma-sprayed coatings . . . 194
7.1.1 Textile industry . . . 194
7.1.2 Paper and printing industries . . . 195
7.1.3 Automotive industry and the production of combustion engines . . . 197
7.1.4 Glass industry . . . 201
7.1.5 Electrotechnical industry . . . 204
7.1.6 Hydraulic machines and mechanisms . . . 206
7.1.7 Chemical industry . . . 209

7.1.8 Rolling mills, founding, metallurgy 212
7.1.9 Protection of stationary gas turbine blades against high-temperature corrosion 217
7.1.10 Plasma sprayed coatings in production of aircraft jet engines 220
7.1.11 Production of shaped parts of refractory materials 223
7.1.12 Nuclear technology and survey of other applications 226
7.2 Application of plasma spraying technology in research and development 228
7.2.1 Development of wear-resistant materials with improved friction properties . . . 228
7.2.2 Protective coatings on mining equipment structures, to prevent igniting sparks . . 230
7.2.3 Preparation of composite materials reinforced with fibres 233
7.2.4 Application of plasma-sprayed coatings in medicine 236

8 Testing of physical and mechanical properties of plasma sprayed coatings 240

8.1 Measurement of basic mechanical properties 241
8.2 Metallographical studies 242
8.3 Adherence tests 242
8.4 Hardness measurement 243
8.5 Measurement of coating porosity 244
8.6 Measurement of erosion resistance of coatings 246
8.7 Cavitation and abrasion tests 247
8.8 Thermal resistance of coatings 248
8.9 Corrosion tests 251
8.10 Testing of dielectric properties 253
8.11 Tests of wear resistance and friction properties 254
8.12 Tests of thermal conductivity 255
8.13 Other tests 256

9 Problems of work safety in the operation of plasma spraying equipment 259

9.1 Safety problems in surface preparation prior to plasma spraying 259
9.2 Dangers in plasma spraying 260
9.2.1 Electric installation 260
9.2.2 Radiation and heat 261
9.2.3 Noise 262
9.2.4 Working gases and pressure vessels 263
9.2.5 Effect of ozone and nitrous gases 264
9.3 Danger from metal dust and the vapours of spraying materials 264
9.3.1 Beryllium 267
9.3.2 Lead 268
9.3.3 Cadmium 269
9.3.4 Copper, zinc and tin 269
9.3.5 Aluminium and steel 270

Conclusions 272

References 274