

Steel wire and wire products — Non-ferrous metallic coatings on steel wire —

Part 5: Nickel coatings

The European Standard EN 10244-5:2001 has the status of a British Standard

ICS 25.220.40; 77.140.65

National foreword

This British Standard is the official English language version of EN 10244-5:2001.

The UK participation in its preparation was entrusted to Technical Committee ISE/26, Steel wire, which has the responsibility to:

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- present to the responsible European committee any enquiries on the interpretation, or proposals for change, and keep the UK interests informed;
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Summary of pages

This document comprises a front cover, an inside front cover, the EN title page, pages 2 to 6, an inside back cover and a back cover.

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Steel wire and wire products - Non-ferrous metallic coatings on steel wire - Part 5: Nickel coatings

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Stahldraht und Drahterzeugnisse - Überzüge aus Nichteisenmetall auf Stahldraht - Teil 5: Überzüge aus Nickel

This European Standard was approved by CEN on 21 January 2001.

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Contents

	Page
Foreword	3
1 Scope.....	4
2 Normative reference.....	4
3 Term and definition	4
4 Requirements relating to coating	4
4.1 Material.....	4
4.2 Mass of coating	4
4.3 General requirements	5
5 Test conditions.....	5
5.1 Samples.....	5
5.1.1 General	5
5.1.2 Length of samples.....	5
5.2 Determination of mass of coating	5
5.2.1 General	5
5.2.2 Gravimetric method	5
5.2.3 Use of atomic absorption spectrometer	6
5.3 Adherence test	6

Foreword

This European Standard has been prepared by Technical Committee ECISS/TC 30 "Steel wires", the secretariat of which is held by BSI.

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of an identical text or by endorsement, at the latest by September 2001, and conflicting national standards shall be withdrawn at the latest by September 2001.

This European Standard for non-ferrous metallic coating on steel wire is made up of the following parts:

- Part 1 : General principles
- Part 2 : Zinc and zinc alloy coatings
- Part 3 : Aluminium coatings
- Part 4 : Tin coatings
- Part 5 : Nickel coatings
- Part 6 : Copper, bronze and brass coatings

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom.

1 Scope

This part of this European Standard specifies the requirements for the mass; other properties and testing of nickel coatings on steel wire and steel wire products of round or other cross-section.

2 Normative reference

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

EN 10244-1, *Steel wire and wire products — Non-ferrous metallic coatings on steel wire — Part 1 : General principles*

EN 10244-4, *Steel wire and wire products — Non-ferrous metallic coatings on steel wire — Part 4: Tin coatings*

3 Term and definition

For the purposes of this European standard the following term and definition apply.

3.1

wire with nickel coating

wire to which a nickel coating has been applied by electrolytic deposition, either before drawing or when the final dimension has been obtained

4 Requirements relating to coating

4.1 Material

The nickel coating shall be made of pure non-alloy nickel; the tolerated quantity of impurities shall be maximum 2 %

4.2 Mass of coating

The coating mass, when required, shall be agreed at the time of enquiry and order or according to the product standard.

4.3 General requirements

See the requirements in EN 10244-1.

5 Test conditions

5.1 Samples

5.1.1 General

See the general requirements in EN 10244-1.

5.1.2 Length of samples

The length of the samples shall be sufficient to allow all the necessary tests to be carried out.

5.2 Determination of mass of coating

5.2.1 General

The mass of the coating shall be determined using the gravimetric method or using an atomic absorption spectrometer. For the gravimetric method, the sample length shall in accordance with Table 1 in EN 10244-4.

5.2.2 Gravimetric method

5.2.2.1 Procedure

If necessary, degrease the sample with a suitable solvent. Weigh the sample to an accuracy of 0,1 mg.(mass m_1).

Strip the samples in concentrated nitric acid (HNO_3) with a density of 1,4 at 20 °C.

After stripping, rinse the samples, dry them and once again weigh them to the same accuracy (mass m_2). If the mass difference is less than 10 mg, repeat the test with a suitably longer sample.

Determine the diameter of the wire.

5.2.2.2 Calculation of mass of coating

The calculation shall be carried out in accordance with EN 10244-1 using the following formula:

$$Ni(g/m^2): \frac{(m_1 - m_2) \times d \times 1962}{m_2}$$

5.2.3 Use of atomic absorption spectrometer

Given the aggressive nature of the stripping solution, the gravimetric method does not give completely accurate figures. A more accurate method involves determining the quantity of nickel in a defined volume of pickling solution using an atomic absorption spectrometer.

NOTE The possible error in using the gravimetric method may be smaller with high carbon steels than with low carbon steels, which may be vigorously attacked.

5.3 Adherence test

The adherence test shall be carried out in accordance with EN 10244-1 using a mandrel with a diameter three times the diameter of the wire. Under these conditions, the nickel coating shall show no signs of flaking.

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