
**Vitreous and porcelain enamels —
Terminology —**

**Part 1:
Terms and definitions**

*Emaux vitrifiés — Terminologie —
Partie 1: Termes et définitions*





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Foreword

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Vitreous and porcelain enamels — Terminology —

Part 1: Terms and definitions

1 Scope

This document defines a number of terms relating to vitreous and porcelain enamels and their technology. This list is not complete and only comprises those terms for which the definition is considered necessary for correct and adequate understanding in order to clarify these processes.

The interpretations given are those corresponding to the practical usage in this field and they do not necessarily coincide with those used in other fields.

For purposes of clarification, the term “vitreous enamel”, used throughout this document, is synonymous with “porcelain enamel”, the term favoured in the United States and some other countries.

2 Normative references

There are no normative references in this document.

3 Terms and definitions

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

NOTE [Annex A](#) lists alternative terms and cross refers to primary terms used below.

3.1

abrasive blasting

process for *cleaning* ([3.44](#)) or finishing by means of an abrasive directed at high velocity against the work piece

3.2

abrasion resistance

degree of resistance of *vitreous enamel* ([3.255](#)) to be abraded by solid materials

3.3

acid resistance

degree of resistance of *vitreous enamel* ([3.255](#)) to attack by acidic corrosive chemicals

3.4

adherence

adhesion

<enamel-metallic substrate> degree of bonding between the fused *vitreous enamel* ([3.255](#)) and the metallic substrate

3.5

adherence of powder

ability of a vitreous enamel powder to remain attached by static attraction to a grounded *substrate* ([3.242](#)) before *firing* ([3.111](#))

3.6

ageing

change in properties of vitreous enamel slips, powders, reagents, or steel with the lapse of time

3.7

air seal

air curtain

flow of pressurized air across the entrance and exit of a *continuous furnace* (3.53) that prevents heat escaping from the furnace but allows ware to pass through

3.8

alkali degreasing

removal of oil, grease, lubricants, and loose debris from the surface of the metallic substrate by immersion or spraying with an aqueous alkali degreaser in preparation for *vitreous enamelling* (3.256)

3.9

alkali resistance

degree of resistance of *vitreous enamel* (3.255) to attack by alkaline corrosive mediums

3.10

aluminium enamel

vitreous enamel (3.255) specifically formulated for application on aluminium substrates

3.11

anneal

annealing

thermal treatment of metals generally made by controlled heating and subsequent cooling

Note 1 to entry: Raw castings are heated in the range from 650 °C to 950 °C to relieve stresses and strains, burn off grease and in some cases to change the structure of the iron and in so doing improve the castings condition prior to coating with vitreous enamel.

3.12

anti-scale compound

agent that is applied to furnace tooling and other items to protect them from *scaling* (3.210) during *firing* (3.111)

3.13

back emission

back ionization

<electrostatic powder> defect often with the appearance of localized, very heavy *orange peel* (3.160), due to excessive charge build-up in the powder film resulting in electrical breakdown of air (i.e. back emission)

Note 1 to entry: The effect of the self-limiting characteristics of the electrostatic powder during application.

3.14

ball mill

ceramic or ceramic-lined rotating cylinder in which vitreous enamel materials are either wet or dry ground, generally using alumina, porcelain or steatite balls as grinding media

3.15

batch smelter

discontinuous smelter

smelter which is charged, fired, and discharged according to a predetermined periodic cycle

3.16

bead

defect resulting from accumulation of *vitreous enamel* (3.255) usually at the point where the enamel drains off the ware in *dipping* (3.78) (3.79)

3.17**beading****rim enamelling**

application of ridge of *vitreous enamel* (3.255) along the edge or rim of ware

3.18**beading enamel****rim enamel**

vitreous enamel (3.255) specifically formulated for *beading* (3.17)

3.19**biocide**

anti-bacterial agent used to inhibit fermentation of organic *mill additions* (3.150) such as gums

3.20**bisque**

dry unfired vitreous enamel coating

3.21**black specks**

defect that appears as black particles at the surface of vitreous enamel coating

Note 1 to entry: See *boiling* (3.26) and *carbon boil* (3.34).

Note 2 to entry: This can be the result of reaction with the substrate or with contamination on the substrate surface.

3.22**blank**

sized piece of untreated metal sheet that will be used in forming the finished article

3.23**blasting**

process whereby solid metallic, mineral, synthetic resin, vegetable particles or water are projected at high velocity against a work piece for the purpose of *cleaning* (3.44), abrading or shot peening the surface

3.24**blister**

defect that appears as a localized bubble under the surface of the fired *vitreous enamel* (3.255)

3.25**bloom**

visual exudation or efflorescence on the vitreous enamel surface

Note 1 to entry: See *scumming* (3.212).

3.26**boiling**

defect resembling areas of *ground-coat* (3.135) pull-through, *blisters* (3.24) and *pinholes* (3.169), visible after first cover-coat fire

Note 1 to entry: See *carbon boil* (3.34) and *black specks* (3.21).

Note 2 to entry: This can be the result of excessive ground-coat activity during cover-coat fire, as the ground-coat boils up through the cover-coat it may be accompanied by a release of gases.

3.27**bolt-hole brush**

specially-designed round brush used to remove vitreous enamel bisque from in and around small openings in the ware

3.28

box furnace

furnace in which ware is fired according to a predetermined periodic cycle

3.29

break out

defect characterized by areas of *blisters* ([3.24](#)) having well-defined boundaries

3.30

bubble structure

size and spatial distribution of voids within the fired vitreous enamel layer

3.31

burn-off

defect that appears as a localized area of rough oxides erupting through the enamel coating

Note 1 to entry: This can be caused by too thin an application of enamel, allowing excessive oxidation of the metal substrate during firing, leading to super saturation of the enamel coating with metal oxides.

3.32

burning bar

burning point

burning tool

tool used to suspend or support ware during firing operations

3.33

button test

fusion button test

control test to determine the relative fusibility of vitreous enamel frit or powder

Note 1 to entry: See *fusion flow test* ([3.126](#)).

Note 2 to entry: The completed test specimen resembles a button.

3.34

carbon boil

defect resembling areas of *blisters* ([3.24](#)), *pinholes* ([3.169](#)), or *black specks* ([3.21](#)), visible in fired *vitreous enamel* ([3.255](#))

Note 1 to entry: See *boiling* ([3.26](#)) and *black specks* ([3.21](#)).

Note 2 to entry: Result of the oxidation of carbides and free carbon at or near the surface of the steel substrate during firing, resulting in evolution of gasses.

3.35

cascading

<electrostatic powder> defect that starts with a few particles of powder detaching themselves after application and as they cascade down the ware they gather more and more powder leaving a trail of thinner and thinner coating

Note 1 to entry: Excess powder, inadequate powder adhesion and vibration contribute to this defect.

3.36

cast iron enamel

vitreous enamel ([3.255](#)) specifically formulated for application on cast iron substrate

3.37

cermet

ceramic-metal coating

mixture of one or more ceramic materials in combination with a metallic phase applied to a metallic substrate

3.38**chalkboard enamel**
blackboard enamel

special type of matt vitreous enamel used to provide a writing surface for chalk

3.39**chalky surface**

surface defect where the vitreous enamel surface has lost its *gloss* ([3.131](#)) and taken on a powdery appearance

Note 1 to entry: See *scumming* ([3.212](#)).

3.40**chemical resistance**

degree of resistance of *vitreous enamel* ([3.255](#)) to attack by corrosive chemicals

3.41**chipping**

defect characterized by fracturing and detachment of irregular enamel particles from the vitreous enamel surface

3.42**cleanability**

relative ease with which soils or stains can be removed from a fused vitreous enamel surface

3.43**cleaner**

pre-treatment solution, usually alkaline, used to remove oil, grease, lubricants, and loose debris from the surface of metal substrate in preparation for *vitreous enamelling* ([3.256](#))

3.44**cleaning****degreasing**

removal of foreign materials, such as abraded metallic particles from pressing or *blasting* ([3.23](#)), grease, oil, oxides, *scale* ([3.209](#)), rust, swarf, etc., from the surface

Note 1 to entry: See *vapour degreasing* ([3.252](#)).

3.45**clear frit****transparent frit**

vitreous enamelling ([3.256](#)) frit that remains essentially transparent or non-opaque when fused

3.46**coefficient of expansion**

rate at which a material will expand under the influence of increasing temperature

3.47**cold-rolled steel**

low-carbon, cold-reduced and annealed sheet steel, not necessarily enamelling quality

3.48**colour matching**

comparison of two or more samples of products that are notionally the same colour

3.49**colouring oxide**

calcined mixture of inorganic material used as a *mill addition* ([3.150](#)) to impart colour to a *vitreous enamel* ([3.255](#))

3.50

coloured frit

vitreous enamel frit containing a colorant in order to produce a strong colour in the fired *vitreous enamel* (3.255)

3.51

consistency

rheological properties of a vitreous enamel slip that control its *draining* (3.87), flowing, and spraying behaviour

3.52

continuity of coating

degree to which a *vitreous enamel* (3.255) is free from defects such as bare spots, *boiling* (3.26), *blisters* (3.24), or *copperheads* (3.58), etc., that could reduce its protective and/or its aesthetic properties

Note 1 to entry: See *discontinuity* (3.82).

3.53

continuous furnace

furnace through which ware is fed continuously and from which the fired product is discharged continuously

3.54

continuous smelter

smelter from which the molten product is discharged continuously

3.55

conventional enamelling

application of vitreous enamel ground coat(s) and cover coat(s), each one followed by a firing operation

3.56

cooling zone

exit part of a *continuous furnace* (3.53) in which the ware is allowed to cool after *firing* (3.111)

3.57

copper enamels

vitreous enamels (3.255) specifically formulated for application on copper substrate

3.58

copperheads

defect resembling small freckle or pimple-like reddish brown spots occurring in *ground-coats* (3.135), or direct-on *enamels* (3.255) on iron substrates, in principle in an isolated round *burn-off* (3.31)

3.59

cover coat enamel

vitreous enamel (3.255) with specific chemical, physical and/or aesthetic properties applied as either intermediate or final coat

3.60

covering power

degree to which a vitreous enamel coating obscures the underlying surface

3.61

crack

cracking

defect caused by laminar interruptions in the fused coating running vertical to the surface

Note 1 to entry: Cracking can also occur at different angles.

Note 2 to entry: The causes are mainly the result of mechanical or thermal tensile stresses within the enamel coating.

3.62**crawling
curling**

incomplete formation of the enamel layer on the *substrate* (3.242) with the appearance of agglomerates or irregularly spaced islands in the *vitreous enamel* (3.255) during *firing* (3.111)

3.63**crazing**

defect resembling a network of fine *cracks* (3.61) in the vitreous enamel coating

3.64**cross-bend test**

determination of the resistance of *bisque* (3.20) or fused vitreous enamel coating to *cracking* (3.61) by progressively distorting the coated panels by bending

3.65**cup spray gun****cup-gun**

spray gun (3.235) with a fluid container as an integral part

3.66**cupping**

pouring of vitreous enamel slip over areas of a component during *draining* (3.87) to improve coverage in certain areas

3.67**curtains**

defect with the appearance of a draped pattern of darkened areas that sometimes *blisters* (3.24)

Note 1 to entry: Curtains occur mainly in ground-coats and direct-on enamels but may also be seen in cover coats.

3.68**decal
transfer**

design or wording printed on paper with *ceramic ink* (3.211) and transferred to a fired enamel surface and then refired to form an integral part of the vitreous enamel coating

3.69**decarburized steel****zero carbon steel**

special type of steel sheet of extremely low carbon content

Note 1 to entry: This type of steel is suitable for direct-on white cover-coat application after acid pickle and nickel flash.

Note 2 to entry: Decarburized steel does not undergo a permanent phase change during firing hence it is sag resistant and is therefore suitable for large panels, etc.

3.70**de-beading**

removal of excess vitreous enamel slip from the edge of dipped ware

3.71**decking**

multiple layer loading of ware for drying and/or *firing* (3.111)

3.72**de-enamelling**

removal of fired *vitreous enamel* (3.255) from the metallic substrate

3.73

de-setting agent

electrolytes that reduce the *viscosity* ([3.254](#)) of the vitreous enamel slip

3.74

delayed fish-scale

small half-moon shaped defects occurring in the vitreous enamelled surface which are not immediately apparent on cooling

Note 1 to entry: See *fish-scale* ([3.116](#)).

3.75

de-vitrification

change from the vitrified state to the crystalline state

Note 1 to entry: Some vitreous enamels will de-vitrify to produce dull lustre and opacity.

3.76

dimple

defect resembling a shallow depression in the vitreous enamel surface

3.77

dip weight

pick-up

plate weight

amount of *vitreous enamel* ([3.255](#)) retained on a test plate after *dipping* ([3.78](#)) ([3.79](#)), *flow coating* ([3.119](#)) or by *slushing* ([3.226](#))

Note 1 to entry: This is specified as either dry weight or wet weight retained per unit area on a test plate.

3.78

dipping

swilling

<wet process> application of *vitreous enamel* ([3.255](#)) by immersing the component in a bath of vitreous enamel slip and subsequent removal of excess enamel by *draining* ([3.87](#))

3.79

dipping

<dry process> application of *vitreous enamel* ([3.255](#)) in *dry process enamelling* ([3.90](#)) by briefly immersing the red hot component in powdered frit

3.80

direct fired furnace

open flame furnace

Note 1 to entry: The products of combustion come into contact with the ware during firing.

3.81

direct-on-enamelling

vitreous enamel coating, applied directly onto the metallic substrate and functioning as either a ground coat or as a finish coat

3.82

discontinuity

weakness within the vitreous enamel coating that is detected by spark testing

3.83

double draining

evidence of further flow having occurred after the apparent end of *draining* ([3.87](#))

3.84**double-face ware**

ware that has a finish coating on both surfaces

3.85**drain line**

defect resembling a streak of thicker or thinner *enamel* ([3.255](#))

Note 1 to entry: Drain lines result from the flow of excess enamel after dipping.

3.86**drain time**

time required for vitreous enamel slip applied by *dipping* ([3.78](#)) ([3.79](#)), *slushing* ([3.226](#)), or *flow coating* ([3.119](#)) to complete its movement across the surfaces of a coated part

3.87**draining**

removal of excess vitreous enamel slip from the ware after *dipping* ([3.78](#)) ([3.79](#)), *slushing* ([3.226](#)) or *flow coating* ([3.119](#))

3.88**dredge**

sieve used to apply powdered vitreous enamel frit to hot ware in *dry process enamelling* ([3.90](#))

3.89**dry milling****dry grinding**

milling/grinding of vitreous enamel materials in the absence of liquid

3.90**dry process enamelling**

process whereby cast iron components are heated to a temperature above the maturing temperature of the *vitreous enamel* ([3.255](#)), then coated with vitreous enamel powder by *hot dusting* ([3.139](#))/*dredging* ([3.139](#)) or *dipping* ([3.78](#)) ([3.79](#)) and subsequently fired

3.91**dry spray**

appearance of a rough sandy texture on spray coated ware

Note 1 to entry: Dry spray is the result of not wetting out the wet sprayed surface.

3.92**dry weight**

weight of the vitreous enamel bisque per unit area

Note 1 to entry: See *dip weight* ([3.77](#)).

3.93**drying crack**

defect characterized as a fissure in the *bisque* ([3.20](#)), visible after *firing* ([3.111](#))

3.94**dulling**

lustreless finish to the vitreous enamelled surface

3.95**dust coat**

relatively thin, sprayed coating of vitreous enamel slip

3.96

easy-to-clean enamel

ETC enamel

vitreous enamel ([3.255](#)) specifically formulated to allow the easy removal of food soil deposits from its surface

Note 1 to entry: ETC enamel needs to be neither pyrolytic nor catalytic.

3.97

edging

process of removing vitreous enamel bisque from the edge of a piece of ware to expose the underlying *vitreous enamel* ([3.255](#))

Note 1 to entry: Edging is also used to describe the spraying of special slip onto the edge of the ware.

3.98

edging brush

stiff bristled brush with a metal guide, used for removal of vitreous enamel bisque from edges of ware before the firing operation

3.99

eggshell

fused vitreous enamel surface exhibiting a smooth, matt texture, reminiscent of an egg shell

Note 1 to entry: In sanitary ware, it is a defect.

3.100

electrophoretic deposition

deposition of vitreous enamel particles onto a work-piece from an enamel slip under the influence of an applied direct current voltage

3.101

electrostatic dry powder application

process in which the component is coated by electrostatically charged vitreous enamel powder

3.102

electrostatic wet application

process in which the component is coated by electrostatically charged vitreous enamel slip

3.103

enamelling aluminium

aluminium suitable for use as a metallic substrate for *vitreous enamelling* ([3.256](#))

3.104

enamelling cast iron

cast iron suitable for use as a metallic substrate for *vitreous enamelling* ([3.256](#))

3.105

enamelling iron

cold reduced low carbon steel, specifically produced as a metallic substrate for *vitreous enamelling* ([3.256](#))

3.106

etched

loss of *gloss* ([3.131](#)) and/or roughening of the surface as a result of chemical attack

3.107

Faraday cage effect

<electrostatic application> defect resulting from poor penetration by charged enamel particles into concave areas leading to thin spray and potentially to *burn-off* ([3.31](#))

3.108**film strength**

relative resistance of the vitreous enamel bisque to mechanical damage

Note 1 to entry: See *cross-bend test* ([3.64](#)).

3.109**fineness test**

control test used to measure the degree to which a vitreous enamel frit has been milled in either the wet or dry form, usually expressed in grams residue retained on a particular mesh sieve from a given sample size

3.110**fire tool marks****burning tool marks****fire marks****pin marks****point marks**

defect characterized by very small indentations similar in appearance to shallow *pinholes* ([3.169](#))

Note 1 to entry: Fire tool marks may also appear on the surface opposite to the point of contact with the supporting tool.

3.111**firing**

controlled heat treatment of vitreous enamelled ware in a furnace, in order to fuse and develop the coating's desired properties

3.112**firing range**

time-temperature interval in which a *vitreous enamel* ([3.255](#)) or ceramic coating is satisfactorily fused

3.113**firing temperature****maturing temperature**

temperature at which *vitreous enamel* ([3.255](#)) must be held for a selected time to achieve the desired properties

3.114**firing time**

period of time during which the ware remains in the firing zone of the furnace to mature the vitreous enamel coating

3.115**firing zone**

portion of the furnace, usually a *continuous furnace* ([3.53](#)), through which the ware passes during the *firing time* ([3.114](#))

3.116**fish-scale**

small half-moon shaped defects occurring in the vitreous enamelled surface

Note 1 to entry: See *delayed fish-scale* ([3.74](#)), *shiner-scale* ([3.219](#)), *whale-scale* ([3.257](#)) and *process fish-scale* (*poppers*) ([3.184](#)).

Note 2 to entry: Fish-scaling can occur immediately on cooling or after some time has elapsed following firing. This defect originates from super saturation of the substrate with hydrogen (acquired during firing), which explosively fractures the enamel coating in order to relieve the pressure that has accumulated with time at the enamel-steel interface.

3.117

flaw

defect in ware causing rejection

3.118

flow button

pellet of compressed powdered frit used in the *fusion flow test* ([3.126](#))

3.119

flow coating

process of coating a metal shape by causing the *slip* ([3.223](#)) to flow over its surface and allowing it to drain

3.120

fluidity

ability of a powder to develop a fluid-like *consistency* ([3.51](#)) and flow properties when aerated

3.121

flux

substance that interacts with infusible (or partially infusible) materials, thus increasing fluidity of the melted mix

3.122

ford cup

device for measuring the flow out time for a defined volume through a specified area (hole)

3.123

fork

tool used to load and remove ware from the furnace during the firing operation

3.124

frit

flake

result of fusing a mixture of different inorganic raw materials, which constitute the vitrifiable base of the enamel, and then quenching the molten glassy mass from temperatures between 1 150 °C and 1 350 °C

Note 1 to entry: Granulated frit is produced by quenching the discharging melt into water and flake is produced by discharging the melt between water cooled rollers.

3.125

fritting

process of quenching and shattering molten *glass* ([3.129](#)) into small friable frit particles

3.126

fusion flow test

control test to compare the relative fluidity behaviour of molten samples of *frit* ([3.124](#)) compared with an accepted standard

3.127

galvanic nickel dip

deposition of a nickel coating produced by a displacement reaction in which one metal displaces another from solution

EXAMPLE $\text{Fe} + \text{Ni}^{++} \rightarrow \text{Ni} + \text{Fe}^{++}$

3.128**gasatura****gassing****grizzle****spongy enamel**

defect in which the vitreous enamel surface is disfigured by a myriad of minute bubbles or *blisters* ([3.24](#)), some broken and accompanied by a loss of *gloss* ([3.131](#))

Note 1 to entry: The condition is associated with the evolution of hydrogen, principally originating from moisture.

3.129**glass**

term synonymous with *vitreous enamel* ([3.255](#)) or *frit* ([3.124](#)), in particular by chemical vessel manufacturers

3.130**glass eye**

defect consisting of large unbroken *blister* ([3.24](#)) in the surface of the fused *vitreous enamel* ([3.255](#))

3.131**gloss**

shine or *lustre* ([3.145](#)) of vitreous enamel surface

3.132**graining**

application of a vitreous enamel finish resembling wood grain

3.133**graining roller**

specialized type of roller used for transferring a grain pattern to the *vitreous enamel* ([3.255](#))

3.134**grit blasting**

process for *cleaning* ([3.44](#)) and abrading the surface by means of small irregular pieces of steel or malleable cast iron directed at high velocity against the work piece

Note 1 to entry: In the United Kingdom, this term can also apply to the use of non-metallic particles of similar shape, e.g. silicon carbide or aluminium oxide.

3.135**ground-coat**

vitreous enamel ([3.255](#)) applied directly to the *substrate* ([3.242](#)) to function as an intermediate bonding layer between the substrate and the cover coat

3.136**hairlines****strain-lines****tension-lines**

defect resembling one or a series of near parallel lines in the fused vitreous enamel surface and giving the appearance of *cracks* ([3.61](#)) healed by fusion

Note 1 to entry: Hairlines can be caused, for example, by the release of mechanical stresses within the steel during firing.

3.137**hardness**

relative refractoriness of a *vitreous enamel* ([3.255](#)) or *frit* ([3.124](#))

3.138

**hollowware
cookware
ovenware**

kitchen utensils such as pots, pans, and kettles

Note 1 to entry: Hollowware is subdivided in categories based on volume.

Note 2 to entry: Foodware is intended to be heated in the course of preparation of food and drinks by conventional thermal methods and by microwaves.

3.139

**hot dusting
dredging**

application of dry powdered frit to red hot ware by sifting

3.140

impact test

test to determine the resistance of a *vitreous enamel* ([3.255](#)) to fracture from a sudden blow

3.141

**jar mill
pot mill**

small porcelain *ball mill* ([3.14](#))

3.142

jewellers' enamel

vitreous enamel ([3.255](#)) specifically formulated for use in the manufacture of jewellery, insignia, and art objects

3.143

lamination

<steel> defect characterized by a linear row of *blisters* ([3.24](#)) in the vitreous enamel surface along the direction of rolling, in severe cases a *metal blisters* ([3.149](#)) will form

3.144

lump

defect characterized by rounded projection on an enamelled surface

Note 1 to entry: A lump is commonly the result of spray-gun spit.

3.145

lustre

decorative surface finish with an iridescent appearance

Note 1 to entry: Lustre is also used to describe a pearly or silky sheen of a vitreous enamel surface.

3.146

marble effect

decorative surface finish produced by colouring and *graining* ([3.132](#)) that resembles variegated marble, however, in the case of white enamels often noted as a defect due to a lack of opacity

3.147

matt enamel

vitreous enamel ([3.255](#)) specifically formulated to provide a surface with low specular *gloss* ([3.131](#))

Note 1 to entry: Matt enamel is also used to express a lack of gloss.

3.148

**medium
squeegee oil**

oil or mixture of oils used to suspend *pigments* ([3.167](#)) and *fluxes* ([3.121](#)) in *screening inks* ([3.211](#))

3.149**metal blister**

defect with the appearance of a bulge in the enamelled surface due to entrapped gasses in a steel lamination resulting in localized swelling in the metal substrate during *firing* ([3.111](#))

Note 1 to entry: Historically, metal blisters originated from pipe lamination in ingot route steel.

3.150**mill additions**

materials used to prepare enamel slip, such as bisque strengtheners, electrolytes, *pigments* ([3.167](#)), refractories and suspension agents, etc., and which together with the *frit* ([3.124](#)) comprise the mill charge

3.151**millscale**

thick oxide layer formed during hot rolling or heat treatment of certain metals

3.152**mottled ware****graniteware**

decorative finish with particles of one colour appearing in a uniform background of another colour or shade

Note 1 to entry: See *self-mottled ware* ([3.214](#)).

3.153**muffle furnace**

refractory chamber heated from the outside

Note 1 to entry: The heat is transferred through the walls of the firing chamber in order to fire the ware inside and hence the ware has no contact with the products of combustion.

3.154**neutralizer**

agent used to remove excess acid or alkali remaining on the surface of the work piece after pre-treatment

3.155**nickel dip**

chemical deposition of a discontinuous layer of metallic nickel on to the surface of the steel in order to enhance the steel/enamel bond

Note 1 to entry: See *galvanic nickel dip* ([3.127](#)) and *reduction nickel dip* ([3.192](#)).

3.156**one-coat enamelling**

vitreous enamelling ([3.256](#)) of ware is completed in a single coat application

3.157**one-fire enamelling**

coat or coats of *vitreous enamel* ([3.255](#)) fused in a single fire

3.158**opacifier**

material that imparts or increases the opacity of *vitreous enamel* ([3.255](#))

3.159**opaque vitreous enamel**

vitreous enamel frit which exhibit opaque properties after *firing* ([3.111](#)) through which neither the underlying coating or *substrate* ([3.242](#)) is visible

3.160

orange peel

defect in the fused enamel coat showing a dimpled or wavy surface characteristic of orange peel

3.161

over-spray

slip from the *spray gun* ([3.235](#)) not deposited on to the target area of the ware

Note 1 to entry: Over-spray is also used to describe a spray application of a light coat of slip to an unfired vitreous enamel.

3.162

pearl lines

bubble lines

defect characterized by a number of bubbles or *blisters* ([3.24](#)) in a single line or a series of parallel lines

Note 1 to entry: This is a severe case of strain-lines and is a result of the release of mechanical stresses within the steel during firing.

Note 2 to entry: Pearl lines should not be confused with the out-gassing from steel lamination which occurs as a single line along the direction of rolling; see [3.143](#).

3.163

peeling

defect characterized by spontaneous detachment of large pieces of *vitreous enamel* ([3.255](#)) from the metallic surface after *firing* ([3.111](#))

Note 1 to entry: Peeling is a manifestation of poor adhesion.

3.164

perritts

comb-rack

comb shaped rack used for supporting ware during *pickling* ([3.166](#)), drying or firing operations

3.165

pickle basket

container fabricated from corrosion-resistant material, used to hold ware during the *pickling* ([3.166](#)) process

3.166

pickling

chemical process used to remove oxides and other compounds from the metal surface and to acid etching the metal surface in preparation for *enamelling* ([3.256](#)) in order to enhance the steel-enamel bond

3.167

pigments

insoluble inorganic colouring agents

3.168

pig skin

leather

surface defect with the appearance characterized by similarity to the texture of pig skin

3.169

pinhole

pinholing

holiday

defect characterized by a small hole in the fired *enamel* ([3.255](#))

Note 1 to entry: See *pore* ([3.173](#)).

3.170**pit**

defect resembling a small surface depression

3.171**plugging compound
filler**

putty-like mixture of inorganic materials used to fill holes in iron castings to ensure an even surface for *vitreous enamelling* ([3.256](#))

3.172**pop-off**

defect in which small conical pieces of *vitreous enamel* ([3.255](#)) partially or fully detached themselves from enamelled ware

3.173**pore**

defect characterized by a hole in the fired *vitreous enamel* ([3.255](#)) connecting the surface with the metallic substrate

Note 1 to entry: See *pinhole* ([3.169](#)).

3.174**porosity**

degree to which voids are present in the fired *vitreous enamel* ([3.255](#))

3.175**porosity**

<catalytic enamels> capacity of *catalytic enamels* ([3.213](#)) to absorb oil or fatty substances

3.176**pot furnace**

heating apparatus used to smelt raw materials contained in crucibles

3.177**powder enamel**

<electrostatic> vitreous enamel powder coated with an encapsulant which allows it to carry an electrostatic charge and a particle size to enable it to be transported by the electrostatic charge

3.178**powder enamelling**

electrostatic application of a vitreous enamel coating in dry powder form to a cold substrate

3.179**powdered enamel**

frit ([3.124](#)), in powder form, applied to red hot cast iron by sieving or *dipping* ([3.78](#)) ([3.79](#))

Note 1 to entry: Powdered enamel should not be confused with powder enamel.

3.180**powder-powder enamelling**

application of a powder coat over an unfired powder ground coat and followed by *firing* ([3.111](#))

3.181**preheat zone**

portion of a *continuous furnace* ([3.53](#)) through which the ware passes before entering the firing zone

3.182**pressure pot****pressure tank**

pressurized container from which slip is supplied under pressure to the spray-gun

3.183

primary boiling

evolution of gas during the initial *firing* ([3.111](#)) of *vitreous enamel* ([3.255](#))

Note 1 to entry: Primary boiling can sometimes cause rejection.

3.184

process fish-scale

poppers

defect arising from fish-scaling of ground coat during drying or *firing* ([3.111](#)) of the cover coat resulting in small discoloured or black oxide patches in the fired cover coat

Note 1 to entry: See *fish-scale* ([3.116](#)) and *delayed fish-scale* ([3.74](#)).

3.185

pyro

hydrated or anhydrous form of tetra sodium pyro-phosphate ($\text{Na}_4\text{P}_2\text{O}_7$)

3.186

pyrolytic enamel

vitreous enamel ([3.255](#)) specifically formulated with heat-resistant properties

Note 1 to entry: Pyrolytic enamel is used to coat ovens to allow food soils to be burnt-off when subjected to a cleaning cycle at a temperature of or above 500 °C.

3.187

ready-to-use enamel

RTU enamel

pre-milled vitreous enamel mixture for wet processing, requiring to be blended with water and sieved before application or delivered ready-to-apply

3.188

reboiling

defect arising from the sudden appearance of bubbles on the surface of sheet steel ground coats during second and subsequent *firings* ([3.111](#))

3.189

re-circulating dip tank

container provided with the means of keeping the contents in constant circulation

3.190

reclaim enamel

vitreous enamel over-spray that is recovered from spray booths and reconstituted for re-use

3.191

recovery time

comeback

time required for a furnace to return to temperature after the introduction of a load of ware

3.192

reduction nickel dip

auto-catalytic nickel dip

electroless nickel dip

deposition of a nickel coating by a controlled chemical reduction that is catalysed initially by the metallic component and continued by the deposited nickel

3.193

reflectance

fraction of incident light that is diffusely reflected, measured relative to magnesium oxide, and using standard conditions

3.194**reflectivity**

reflectance (3.193) of a coating whose thickness is such that no further increase in reflectance occurs by increasing coating thickness

3.195**refractory composite coating**

combination of heat-resistant ceramic materials applied to a metallic substrate that may or may not require heat treatment prior to service

Note 1 to entry: Refractory composite coating is also used to describe a coating applied to non-metallic substrates such as graphite or concrete.

3.196**resistivity**

electrical resistance offered to the passage of a steady current

3.197**rheology**

characterization of the flow properties of an enamel slip or powder

3.198**ripple**

defect having the appearance of a uniform, wide-ranging waviness in the surface of fused dry *powdered enamel* (3.179)

3.199**rotary smelter**

smelter that turns gradually on its horizontal axis in order to agitate continually the molten charge

3.200**rubbing stone****rubbing down stone**

abrasive tool used to remove undesirable portions of fused *vitreous enamel* (3.255)

Note 1 to entry: See *stoning* (3.240).

3.201**rust inhibitor**

coating compound comprising particular salts applied to prevent atmospheric oxidation

Note 1 to entry: Rust inhibitor is also used to describe an electrolyte that inhibits rusting at the interface between application and firing of the enamel.

3.202**sag test**

evaluation of the capacity of the *substrate* (3.242) to undergo firing cycle(s) without excessive deviation from its original shape

3.203**sagging****distortion****warping**

<steel> defect in which the shape of the work piece is permanently deformed during *firing* (3.111) as a result of yielding under its own weight and/or as a result of phase changes occurring within the steel

3.204**sagging**

<enamel> defect in which wavy lines of increased *vitreous enamel* (3.255) thickness are evident due to flow or slippage of the coating occurring on those surfaces that are vertical during *firing* (3.111)

3.205

sand blasting

abrasive blasting ([3.1](#)) with a sand substitute, e.g. aluminium oxide

Note 1 to entry: Blasting with sand is forbidden in most countries for reasons of health and safety.

3.206

sanitary ware

vitreous enamelled ware such as bathtubs, shower trays and sinks

3.207

satin finish

lustrous (but not mirror-like) surface finish having no directional texture

3.208

scab

defect having the appearance of a flap or tongue of loose metal rolled into the steel surface

3.209

scale

oxide formed on the surface of a metal during heating at elevated temperatures

3.210

scaling

process of forming *scale* ([3.209](#))

3.211

screening ink

screening paste

ceramic ink

blend of *fluxes* ([3.121](#)) and *pigments* ([3.167](#)) suspended in a *medium* ([3.148](#)) and used as the ink in screen printing

3.212

scumming

defect exhibiting a loss of *gloss* ([3.131](#)) on fired vitreous enamel surface, sometimes accompanied by an iridescent *bloom* ([3.25](#)) or *chalky surface* ([3.39](#)) depending on cause and severity, not always immediately apparent

Note 1 to entry: See *bloom* ([3.25](#)).

3.213

self-clean enamel

continuous clean enamel

catalytic enamel

types of *vitreous enamel* ([3.255](#)) designed to provide the continuous removal, at normal cooking temperatures, of food soils accumulated on the interior surfaces of ovens

Note 1 to entry: The first type depends on porosity increasing the surface area to aid decomposition of the food soils, the second type incorporates transition metal oxides that catalyses the decomposition of the food soils.

3.214

self-mottled ware

decorative finish with particles of one colour appearing in a uniform background of another colour produced from slip containing two or more contrasting *coloured frits* ([3.50](#))

3.215

semi-muffle

any furnace in which products of combustion are not completely excluded from contact with the ware

3.216**semi-opaque enamel**

vitreous enamel frit which exhibits only partial opacity after *firing* (3.111), through which the underlying coating or *substrate* (3.242) is partially visible

3.217**set**

rheological property of enamel slip affecting the rate of *draining* (3.87), residual thickness, and uniformity of coating

3.218**setting-up agent****set-up salt**

electrolyte that is used to increase the measured *pick-up* (3.77) of slip

3.219**shiner scale****shiner**

defect appearing as a minute form of *fish-scale* (3.116) encountered in over-fired *ground-coat* (3.135)

Note 1 to entry: See *fish-scale* (3.116).

3.220**shorelines**

defect appearing as a series of roughly concentric wavy lines in the fired enamel surface

3.221**silver steel****silver metal**

defect characterized by a shiny metallic spot visible after spontaneous *chipping* (3.41) or *spalling* (3.232) of the *vitreous enamel* (3.255)

Note 1 to entry: The shiny silver spot is often of a more noble nature than the surrounding steel, the result of a chemical reaction between Co, Ni and Cr, etc., with the steel substrate.

3.222**sliding**

defect caused by poor *draining* (3.87) of the slip leading to patches of the coating sliding under its own weight and resulting in an uneven coat

3.223**slip****slurry**

suspension of finely divided vitreous enamel material in a liquid, generally water

3.224**slip gauge**

tool used to measure the *consistency* (3.51) of the slip

3.225**slump test**

test to determine *consistency* (3.51) of slip whereby measurement is made by the spreading of a specified volume of slip over a flat surface

3.226**slushing**

coating of ware with liquid *vitreous enamel* (3.255) by pouring, *dipping* (3.78) (3.79) or throwing the slip onto the ware and removing the excess material by shaking to obtain a uniform coating

3.227

smelt

specific batch or lot of *frit* ([3.124](#))

3.228

smelting

melting of vitreous enamel raw materials together in a smelter to form the *vitreous enamel* ([3.255](#))

Note 1 to entry: The raw materials are thoroughly mixed before charging the smelter. They are then allowed to remain in the smelter for several hours until thoroughly and uniformly melted. The smelt is then tapped out as a white-hot stream either over water-cooled rollers or into a quenching tank of water, the former producing flake and the latter frit.

3.229

softening temperature

temperature at which, under specified conditions, *vitreous enamel* ([3.255](#)) or *frit* ([3.124](#)) begins to flow

3.230

soilability

relative ease with which extraneous matter attaches to or builds up on the surface of fused *vitreous enamel* ([3.255](#))

3.231

solubility

tendency of a vitreous enamel frit to dissolve, as a function of time and temperature, in the medium in which it is present, such that the *rheology* ([3.197](#)) of the enamel slip is affected

3.232

spall

spalling

defect resulting from the spontaneous fracturing and detachment of *enamel* ([3.255](#)) mostly characterized by conchoidal fracture (i.e. the substrate may sometimes be visible)

Note 1 to entry: Spalling often occurs on corners, sharp radii or panel edges and can be the result of too low enamel coefficient of expansion for the substrate, the external radii and the enamel thickness concerned. Mechanical and thermal stresses can aggravate the spalling.

3.233

spark test

high voltage electrical test in which a spark is used to detect *discontinuity* ([3.82](#)) in coating

3.234

spray booth

open fronted booth that allows components to be spray coated within it

Note 1 to entry: The spray booth should be fitted with extraction to contain the over-spray within the booth, together with the means of collecting waste enamel.

3.235

spray gun

device that applies a coating of atomized vitreous enamel slip or powder to components with means of adjusting application rate, degree of atomization and spray pattern

3.236

spray-rate

amount of *vitreous enamel* ([3.255](#)) discharged by the spray-gun in unit time

3.237

stainability

relative ease with which *vitreous enamel* ([3.255](#)) is penetrated and discoloured by a foreign material

3.238**star mark
spider**

defect caused by bisque damage leaving a spider or star shape fracture in the fused *vitreous enamel* ([3.255](#))

Note 1 to entry: See *fire tool marks* ([3.110](#)).

Note 2 to entry: A star mark is often the result of impact damage on the underside while in bisque.

3.239**stippled finish**

pebbly textured decorative vitreous enamel finish, often multicoloured

3.240**stoning**

removal by abrading of undesirable portions of fused *vitreous enamel* ([3.255](#)) with an abrasive stone

3.241**suspending agents**

colloidal material that suspends the frit particles in enamel slip

3.242**substrate**

material upon which a coating is directly deposited

Note 1 to entry: In the case of a single or first coating, the substrate is identical with the metallic substrate.

3.243**swab test****sponge test**

<coating continuity> low voltage electrical test used to evaluate the continuity of *vitreous enamel* ([3.255](#))

3.244**swab test**

<surface cleanliness> test used to validate the cleanliness of the vitreous enamel surface

3.245**tearing**

defect characterized by short *cracks* ([3.61](#)) or fissures in the enamel bisque, on *firing* ([3.111](#)) the cracks usually heal, but leave a visible trace of the cracks in the enamel surface

Note 1 to entry: Depending on the degree of cracking, tearing can form a network of cracks.

3.246**thixotropy**

property of suspensions which shows a reduction in *viscosity* ([3.254](#)) when shaken or stirred

3.247**thread test**

test performed by pulling or drawing a thread from the vitreous enamel melt during *smelting* ([3.228](#)) to ascertain its degree of melting and to examine for undissolved or unmelted particles

3.248**triangle bars**

three-sided *burning bars* ([3.32](#))

3.249**tube furnace**

furnace in which gas is burned inside radiant tubes, avoiding contact between the ware and the products of combustion

3.250

two coat-one fire enamelling

single *firing* ([3.111](#)) of vitreous enamelled ware having received both ground and cover coats

3.251

U-type furnace

continuous furnace ([3.53](#)) in which the ware travels into the firing zone, U-turns, and travels out along a parallel path

3.252

vapour degreasing

removal of oil and grease by solvent vapours condensing on the work pieces being cleaned

3.253

vignette

shading

application of a further layer of *vitreous enamel* ([3.255](#)), usually of a contrasting colour, to the area bordering the edge or rim of enamelled articles

3.254

viscosity

resistance offered by a fluid to flow

3.255

vitreous enamel

porcelain enamel

enamel

substantially vitreous, or glassy inorganic silica coating bonded to metallic substrate by fusion at a minimum temperature of 480 °C

Note 1 to entry: This coating is applied for protective functional and/or aesthetic purposes.

Note 2 to entry: This coating is produced by the proprietary formulation of silica glass, minerals and clays to produce a sprayable medium, dry or suspended in water on to the surface of the metallic substrate, and its subsequent fusion bonding.

Note 3 to entry: Porcelain enamel is the favoured term in the US and Canada.

3.256

vitreous enamelling

porcelain enamelling

enamelling

process of covering a metal surface with one or more coatings of fusion bonded vitrified, inorganic material

3.257

whale-scale

defect characterized by an enlarged form of *fish-scale* ([3.116](#)) encountered in under-fired *ground-coat* ([3.135](#))

Note 1 to entry: See *delayed fish-scale* ([3.74](#)) and *fish-scale* ([3.116](#)).

3.258

water-break test

test used to validate the cleanliness of pickled or degreased *substrate* ([3.242](#))

Note 1 to entry: A water-break is a discontinuous film of water on a surface signifying non-uniform wetting and usually associated with surface contamination.

3.259

water mark

water spot

water stain

defect characterized by a depression and/or a discolouration around the edges

3.260

water streak

water line

defect occurring in the *bisque* ([3.20](#)) characterized by a washed out pattern in the form of a streak

Annex A (normative)

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Alternative terms	Terms	Term number
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