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Corrosion tests in artificial atmospheres —Salt spray tests

*Essais de corrosion en atmosphères artificielles—Essais aux
brouillards salins*



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ISO copyright office
Case postale 56 · CH-1211 Geneva 20
Tel. +41 22 749 0111
Fax +41 22 749 0947
E-mail copyright@iso.org
Web www.iso.org

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 9227 was prepared by Technical Committee ISO/TC 156, Corrosion of metals and alloys.

This third edition cancels and replaces the second edition (ISO 9227:2006), of which it constitutes a minor revision.

Introduction

There is seldom a direct relation between resistance to the action of salt spray and resistance to corrosion in other media, because several factors influencing the progress of corrosion, such as the formation of protective films, vary greatly with the conditions encountered. Therefore, the test results should not be regarded as a direct guide to the corrosion resistance of the tested metallic materials in all environments where these materials might be used. Also, the performance of different materials during the test should not be taken as a direct guide to the corrosion resistance of these materials in service.

Nevertheless, the method described gives a means of checking that the comparative quality of a metallic material, with or without corrosion protection, is maintained.

Salt spray tests are generally suitable as corrosion protection tests for rapid analysis for discontinuities, pores and damage in organic and inorganic coatings. In addition, for quality control purposes, comparison can be made between specimens coated with the same coating. As comparative tests, however, salt spray tests are only suitable if the coatings are sufficiently similar in nature.

It is often not possible to use results gained from salt spray testing as a comparative guide to the long-term behaviour of different coating systems, since the corrosion stress during these tests differs significantly from the corrosion stresses encountered in practice.

Corrosion tests in artificial atmospheres —Salt spray tests

1 Scope

This International Standard specifies the apparatus, the reagents and the procedure to be used in conducting the neutral salt spray (NSS), acetic acid salt spray (AASS) and copper-accelerated acetic acid salt spray (CASS) tests for assessment of the corrosion resistance of metallic materials, with or without permanent or temporary corrosion protection.

It also describes the method employed to evaluate the corrosivity of the test-cabinet environment

It does not specify the dimensions of test specimens, the exposure period to be used for a particular product, or the interpretation of results. Such details are provided in the appropriate product specifications.

The salt spray tests are particularly useful for detecting discontinuities, such as pores and other defects in certain metallic, organic, anodic oxide and conversion coatings.

The neutral salt spray test is the test method in which a 5% sodium chloride solution in the pH range from 6,5 to 7,2 is atomized under a controlled environment. It particularly applies to:

- metals and their alloys,
- metallic coatings (anodic and cathodic),
- conversion coatings,
- anodic oxide coatings, and
- organic coatings on metallic materials.

The acetic acid salt spray test is the test method in which a 5% sodium chloride solution with the addition of glacial acetic acid in the pH range from 3,1 to 3,3 is atomized under a controlled environment. It is especially useful for testing decorative coatings of copper+nickel+chromium, or nickel+chromium. It has also been found suitable for testing anodic coatings on aluminum.

The copper-accelerated acetic acid salt spray test is the test method in which a 5% sodium chloride solution with the addition of copper chloride and glacial acetic acid in the pH range from 3,1 to 3,3 is atomized under a controlled environment. It is useful for testing decorative coatings of copper +nickel +chromium, or nickel+chromium. It has also been found suitable for testing anodic coatings on aluminum.

The salt spray methods are all suitable for checking that the comparative quality of a metallic material, with or without corrosion protection, is maintained. They are not intended to be used for comparative testing as a means of ranking different materials relative to each other with respect to corrosion resistance.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1514, Paints and varnishes —Standard panels for testing

ISO 2808, Paints and varnishes—Determination of film thickness

ISO 3574, Cold-reduced carbon steel sheet of commercial and drawing qualities

ISO 8407, Corrosion of metals and alloys —Removal of corrosion products from corrosion test specimens

ISO 17872, Paints and varnishes—Guidelines for the introduction of scribe marks through coatings on metallic panels for corrosion testing

3 Test solutions

3.1 Preparation of the sodium chloride solution

Dissolve a sufficient mass of sodium chloride in distilled or deionized water with a conductivity not higher than 20 $\mu\text{S}/\text{cm}$ at $25^\circ\text{C}\pm 2^\circ\text{C}$ to produce a concentration of 50 $\text{g}/\pm 5 \text{ g}/\text{l}$. The sodium chloride concentration of the sprayed solution collected shall be 50 $\text{g}/\pm 5 \text{ g}/\text{l}$. The specific gravity range for a 50 $\text{g}/\pm 5 \text{ g}/\text{l}$ solution is 1,029 to 1,036 at 25°C .

The sodium chloride shall contain less than 0,001 % mass fraction of copper and less than 0,001 % mass fraction of nickel, as determined by atomic absorption spectrophotometry or another analytical method of similar sensitivity. It shall not contain more than 0,1 % of a mass fraction of sodium iodide, or more than 0,5% of a mass fraction of total impurities calculated for dry salt.

NOTE If the pH of the prepared solution at $25^\circ\text{C}\pm 2^\circ\text{C}$ is outside the range 6,0 to 7,0, investigate the presence of undesirable impurities in the salt and/or the water

3.2 pH adjustment

3.2.1 pH of the salt solution

Adjust the pH of the salt solution to the desired value on the basis of the pH of the sprayed solution collected.

3.2.2 NSS test

Adjust the pH of the salt solution (3.1) so that the pH of the sprayed solution collected within the test cabinet (4.2) is 6,5 to 7,2 at $25^\circ\text{C}\pm 2^\circ\text{C}$. Check the pH using electrometric measurement or in routine checks, with a short-range pH paper, which can be read in increments of 0,3 pH units or less. Make any necessary corrections by adding hydrochloric acid, sodium hydroxide or sodium bicarbonate solution of analytical grade.

Possible changes in pH may result from loss of carbon dioxide from the solution when it is sprayed. Such changes can be avoided by reducing the carbon dioxide content of the solution by, for example, heating it to a temperature above 35°C before it is placed in the apparatus, or by making the solution using freshly boiled water.

3.2.3 AASS test

Add a sufficient amount of glacial acetic acid to the salt solution (3.1) to ensure that the pH of samples of sprayed solution collected in the test cabinet (4.2) is between 3,1 and 3,3. If the pH of the solution initially prepared is 3,0 to 3,1, the pH of the sprayed solution is likely to be within the specified limits. Check the pH using electrometric measurement at $25^\circ\text{C}\pm 2^\circ\text{C}$, or in routine checks, with a short-range pH paper which can be read in increments of 0,1 pH units or less. Make any necessary corrections by adding glacial acetic acid or sodium hydroxide of analytical grade.

3.2.4 CASS test

Dissolve a sufficient mass of copper(II) chloride dihydrate ($\text{CuCl}_2\cdot 2\text{H}_2\text{O}$) in the salt solution (3.1) to produce a concentration of 0,26 $\text{g}/\pm 0,02 \text{ g}/\text{l}$ [equivalent to (0,205 \pm 0,015)g of CuCl_2 per litre].

Adjust the pH using the procedures described in 3.2.3.

3.3 Filtration

If necessary, filter the solution before placing it in the reservoir of the apparatus, to remove any solid matter which might block the apertures of the spraying device.

4 Apparatus

4.1 Component protection

All components in contact with the spray or the test solutions shall be made of, or lined with, materials resistant to corrosion by the sprayed solution and which do not influence the corrosivity of the sprayed test solutions.

4.2 Spray cabinet

The cabinet shall be such that the conditions of homogeneity and distribution of the spray are met. The upper parts of the cabinet shall be designed so that drops of sprayed solution formed on its surface do not fall on the specimens being tested.

The size and shape of the cabinet shall be such that the collection rate of solution in the cabinet is within the limits specified in Table 2, measured as specified in 8.3.

Preference shall be given to apparatus that has a means for properly dealing with fog after the test, prior to releasing it from the building for environmental conservation, and for drawing water prior to discharging it to the drainage system.

NOTE A schematic diagram of one possible design of spray cabinet is shown in Annex A.

4.3 Heater and temperature control

An appropriate system maintains the cabinet and its contents at the specified temperature (see Table 2). The temperature shall be measured at least 100 mm from the walls.

4.4 Spraying device

The device for spraying the salt solution comprises a supply of clean air, of controlled pressure and humidity, a reservoir to contain the solution to be sprayed, and one or more atomizers.

The compressed air supplied to the atomizers shall be passed through a filter to remove all traces of oil or solid matter, and the atomizing pressure shall be at an overpressure of 70 kPa¹⁾ to 170 kPa. The pressure should be $98 \text{ kPa} \pm 10 \text{ kPa}$.

NOTE Atomizing nozzles can have a "critical pressure" at which an abnormal increase in the corrosiveness of the salt spray occurs. If the "critical pressure" of a nozzle has not been established with certainty, control of fluctuations in the air pressure within $\pm 0,7 \text{ kPa}$, by installation of a suitable pressure regulator valve, minimizes the possibility that the nozzle will be operated at its "critical pressure".

In order to prevent the evaporation of water from the sprayed droplets, the air shall be humidified before entering the atomizer by passing through a saturation tower containing hot distilled water or deionized water at a temperature 10°C above that of the cabinet. The appropriate temperature depends on the pressure used and on the type of atomizer nozzle and shall be adjusted so that the rate of collection of spray in the cabinet and the concentration of the collected spray are kept within the specified limits (see 8.3). In Table 1, guiding values are given for the hot-water temperature in the saturation tower at different pressures. The level of the water shall be maintained automatically to ensure adequate humidification.

1) $1 \text{ kPa} = 1 \text{ kN/m}^2 = 0,01 \text{ atm} = 0,01 \text{ bar} = 0,145 \text{ psi}$.

Table 1—Guiding values for the temperature of the hot water in the saturation tower

Atomizing overpressure kPa	Guiding values for the temperature, in °C, of the hot water in the saturation tower when performing the different salt spray tests Neutral salt spray (NSS) and acetic acid salt spray (AASS)	Copper-accelerated acetic acid salt spray (CASS)
70	45	61
84	46	63
98	48	64
112	49	66
126	50	67
140	52	69

The atomizers shall be made of inert material. Baffles may be used to prevent direct impact of the spray on the test specimens, and the use of adjustable baffles is helpful in obtaining uniform distribution of the spray within the cabinet. For this purpose, a dispersion tower equipped with an atomizer may also be helpful. The level of the salt solution in the salt reservoir shall be maintained automatically to ensure uniform spray delivery throughout the test.

4.5 Collecting devices

At least two suitable collecting devices shall be available, consisting of funnels made of chemically inert material, with the stems inserted into graduated cylinders or other similar containers. Suitable funnels have a diameter of 100 mm, which corresponds to a collecting area of approximately 80 cm². The collecting devices shall be placed in the zone of the cabinet where the test specimens are placed, one close to an inlet of spray and one remote from an inlet. They shall be placed so that only mist, and not liquid falling from specimens or from parts of the cabinet, is collected.

4.6 Re-use

If the cabinet has been used once for an AASS or CASS test, or has been used for any other purpose with a solution differing from that specified for the NSS test, it shall not be used for the NSS test.

It is nearly impossible to clean a cabinet that was once used for AASS or CASS testing so that it can be used for an NSS test. However, in such circumstances, the equipment shall be thoroughly cleaned and checked using the method described in Clause 5, ensuring in particular that the pH of the collected solution is correct throughout the entire spraying period. After this procedure, the specimens to be tested are placed in the cabinet.

5 Method for evaluating cabinet corrosivity

5.1 General

To check the reproducibility and repeatability of the test results for one piece of apparatus, or for similar items of apparatus in different laboratories, it is necessary to verify the apparatus at regular intervals as described in 5.2 to 5.4.

NOTE During permanent operation, a reasonable time period between two checks of the corrosivity of the apparatus is generally considered to be 3 months.

To determine the corrosivity of the tests, reference-metal specimens made of steel shall be used.

As a complement to the reference-metal specimens made of steel, high-purity zinc reference-metal specimens may also be exposed in the tests in order to determine the corrosivity against this metal as described in Annex B.

5.2 NSS test

5.2.1 Reference specimens

To verify the apparatus, use four or six reference specimens of $1\text{ mm} \pm 0,2\text{ mm}$ thickness and $150\text{ mm} \times 70\text{ mm}$, of CR4-grade steel in accordance with ISO 3574 with an essentially faultless surface²⁾ and a matt finish (arithmetic mean deviation of the profile $R_a = 0,8\text{ }\mu\text{m} \pm 0,3\text{ }\mu\text{m}$). Cut these reference specimens from cold-rolled plates or strips.

Clean the reference specimens carefully, immediately prior to testing. Besides the specifications given in 6.2 and 6.3, cleaning shall eliminate all those traces (dirt, oil or other foreign matter) that could influence the test results.

Thoroughly clean the reference specimens with an appropriate organic solvent (such as a hydrocarbon with a boiling point between 60°C and 120°C) using a clean soft brush or an ultrasonic cleaning device. Carry out the cleaning in a vessel full of solvent. After cleaning, rinse the reference specimens with fresh solvent and then dry them.

Determine the mass of the reference specimens to $\pm 1\text{ mg}$. Protect one face of the reference specimens with a removable coating, for example an adhesive plastic film. The edges of the reference test specimens may be protected by the adhesive tape as well.

5.2.2 Arrangement of the reference specimens

Position four steel reference specimens in four quadrants (if six specimens are available, place them in six different positions including four quadrants) in the zone of the cabinet where the test specimens are placed, with the unprotected face upwards, and at an angle of $20^\circ \pm 5^\circ$ from the vertical.

The support for the reference specimens shall be made of, or coated with, inert materials such as plastics. The lower edge of the reference specimens shall be level with the top of the salt spray collector. The test duration shall be 48 h.

The test cabinet shall be filled with dummy specimens of inert materials, such as plastic or glass, during the verification procedure.

5.2.3 Determination of mass loss (mass per area)

At the end of the test, immediately take the reference specimens out of the test cabinet and remove the protective coating. Remove the corrosion products by mechanical and chemical cleaning, as described in ISO 8407. For chemical cleaning, use a solution with a mass fraction of 20 % of diammonium citrate $[(\text{NH}_4)_2\text{HC}_6\text{H}_5\text{O}_7]$ (recognized analytical grade) in water for 10 min at 23°C .

After each stripping, thoroughly clean the reference specimens at ambient temperature with water, then with ethanol, followed by drying.

Weigh the reference specimens to the nearest 1 mg. Divide the determined mass loss by the area of the exposed surface area of the reference specimen in order to assess the metal mass loss per square metre of the reference specimen.

It is recommended that freshly prepared solution be used during each procedure for the removal of corrosion products.

NOTE The corrosion products can also be removed by chemical cleaning as described in ISO 8407, and by using a solution with a volume fraction of 50% hydrochloric acid ($p_{20} = 1,18\text{ g/ml}$), of recognized analytical grade, in water, the latter also containing 3,5 g/l of hexamethylene tetramine as a corrosion inhibitor.

2) "Essentially faultless" means free from pores, marks, scratches and any light colouration

5.2.4 Checking of NSS apparatus operation

The operation of the test apparatus is satisfactory if the mass loss of each reference specimen is 70 ± 20 g/m² for 48 h of operation using steel reference specimens³⁾

5.3 AASS test

5.3.1 Reference specimens

To verify the apparatus, use four or six reference specimens of $1 \text{ mm} \pm 0,2 \text{ mm}$ thickness and $150 \text{ mm} \times 70 \text{ mm}$, of CR4-grade steel in accordance with ISO 3574, with an essentially faultless surface⁴⁾ and a matt finish (arithmetical mean deviation of the profile $R_a = 0,8 \mu\text{m} \pm 0,3 \mu\text{m}$). Cut these reference specimens from cold-rolled plates or strips.

Clean the reference specimens carefully, immediately before testing. Besides the specifications given in 6.2 and 6.3, cleaning shall eliminate all those traces (dirt, oil or other foreign matter) that might influence the test results.

Thoroughly clean the reference specimens with an appropriate organic solvent (such as a hydrocarbon with a boiling point between 60°C and 120°C) using a clean soft brush or an ultrasonic cleaning device. Carry out the cleaning in a vessel full of solvent. After cleaning, rinse the reference specimens with fresh solvent, and then dry them.

Determine the mass of the reference specimens to ± 1 mg. Protect one face of the reference specimens with a removable coating, for example an adhesive plastic film. The edges of the reference test specimens may be protected by the adhesive tape as well

5.3.2 Arrangement of the reference specimens

Position four steel reference specimens in four quadrants (if six specimens are available, place them in six different positions including the four quadrants) in the zone of the cabinet where the test specimens are placed, with the unprotected face upwards and at an angle of $20^\circ \pm 5^\circ$ from the vertical.

The support for the reference specimens shall be made of, or coated with, inert materials such as plastics. The lower edge of the reference specimens shall be level with the top of the salt spray collector. The test duration shall be 24 h.

The test cabinet shall be filled with dummy specimens of inert materials such as plastic or glass during the verification procedure.

5.3.3 Determination of mass loss (mass per area)

At the end of the test, immediately take the reference specimens out of the test cabinet and remove the protective coating. Remove the corrosion products by mechanical and chemical cleaning as described in ISO 8407. For chemical cleaning, use a solution with a mass fraction of 20 % diammonium citrate $[(\text{NH}_4)_2\text{HC}_6\text{H}_5\text{O}_7]$ (recognized analytical grade) in water for 10 min at 23°C .

After each stripping, thoroughly clean the reference specimens at ambient temperature with water, then with ethanol, followed by drying.

Weigh the reference specimens to the nearest 1 mg. Divide the determined mass loss by the area of the exposed surface area of the reference specimen in order to assess the metal mass loss per square metre of the reference specimen.

3) See Bibliography, Reference [21].

4) "Essentially faultless" means free from pores, marks, scratches and any light colouration.

It is recommended to use freshly prepared solution during every procedure for removal of corrosion products.

NOTE The corrosion products can also be removed by chemical cleaning as described in ISO 8407 and by using a solution with a volume fraction of 50% hydrochloric acid ($\rho_{20}=1,18 \text{ g/ml}$), of recognized analytical grade, in water, the latter also containing 3,5 g/l of hexamethylene tetramine as a corrosion inhibitor.

5.3.4 Checking of AASS apparatus operation

The operation of the test apparatus is satisfactory if the mass loss of each reference specimen is $40 \text{ g/m}^2 \pm 10 \text{ g/m}^2$ for 24 h of operation using steel reference specimens⁵⁾.

5.4 CASS test

5.4.1 Reference specimens

To verify the apparatus, use four or six reference specimens of $1 \text{ mm} \pm 0,2 \text{ mm}$ thickness and $150 \text{ mm} \times 70 \text{ mm}$, of CR4-grade steel in accordance with ISO 3574, with an essentially faultless surface⁶⁾ and a matt finish (arithmetical mean deviation of the profile $R_a = 0,8 \mu\text{m} \pm 0,3 \mu\text{m}$). Cut these reference specimens from cold-rolled plates or strips.

Clean the reference specimens carefully, immediately prior to testing. Besides the specifications given in 6.2 and 6.3, cleaning shall eliminate all those traces (dirt, oil or other foreign matter) that might influence the test results.

Thoroughly clean the reference specimens with an appropriate organic solvent (such as a hydrocarbon with a boiling point between 60°C and 120°C) using a clean soft brush or an ultrasonic cleaning device. Carry out the cleaning in a vessel full of solvent. After cleaning, rinse the reference specimens with fresh solvent, then dry them.

Determine the mass of the reference specimens to $\pm 1 \text{ mg}$. Protect one face of the reference specimens with a removable coating, for example an adhesive plastic film. The edges of the reference test specimens may be protected by the adhesive tape as well.

5.4.2 Arrangement of the reference specimens

Position four steel reference specimens in four quadrants (if six specimens are available, place them in six different positions including the four quadrants) in the zone of the cabinet where the test specimens are placed, with the unprotected face upwards and at an angle of $20^\circ \pm 5^\circ$ from the vertical.

The support for the reference specimens shall be made of, or coated with, inert materials such as plastics. The lower edge of the reference specimens shall be level with the top of the salt spray collector. The test duration is 24 h.

The test cabinet shall be filled with dummy specimens of inert materials such as plastic or glass during the verification procedure.

5.4.3 Determination of mass loss (mass per area)

At the end of the test, immediately take the reference specimens out of the test cabinet and remove the protective coating. Remove the corrosion products by mechanical and chemical cleaning as described in ISO 8407. For chemical cleaning, use a solution with a mass fraction of 20 % of diammonium citrate $[(\text{NH}_4)_2\text{HC}_6\text{H}_5\text{O}_7]$ (recognized analytical grade) in water for 10 min at 23°C .

After each stripping, thoroughly clean the reference specimens at ambient temperature with water, then with ethanol, followed by drying.

Weigh the reference specimens to the nearest 1 mg. Divide the determined mass loss by the area of the exposed surface area of the reference specimen in order to assess the metal mass loss per square metre of the reference specimen.

5) See Bibliography, Reference [21].

6) "Essentially faultless" means free from pores, marks, scratches and any light colouration.

It is recommended to use freshly prepared solution during every procedure for removal of corrosion products.

NOTE The corrosion products can also be removed by chemical cleaning as described in ISO 8407, and by using a solution with a volume fraction of 50% hydrochloric acid ($\rho = 1,18 \text{ g/ml}$), of recognized analytical grade, in water, the latter also containing 3,5 g/l of hexamethylene tetramine as a corrosion inhibitor.

5.4.4 Checking of CASS apparatus operation

The operation of the test apparatus is satisfactory if the mass loss of each reference specimen is $55 \text{ g/m}^2 \pm 15 \text{ g/m}^2$ for 24 h of operation using steel reference specimens⁷⁾.

6 Test specimens

6.1 The number and type of test specimens, their shape and their dimensions, shall be selected in accordance with the specification for the material or product being tested. When not specified, these parameters shall be mutually agreed between the interested parties. Unless otherwise specified or agreed, test panels with an organic coating to be tested shall be made from burnished steel complying with ISO 1514, and of approximate dimensions $150 \text{ mm} \times 100 \text{ mm} \times 1 \text{ mm}$. Annex C describes how test panels with organic coatings are to be prepared for testing. Annex D gives supplementary information needed for testing test panels with organic coatings.

6.2 The test specimens shall be thoroughly cleaned before testing, if not otherwise specified. The cleaning method employed shall depend on the nature of the material, its surface and the contaminants and shall not include the use of any abrasives or solvents which may attack the surface of the specimens.

Care shall be taken that specimens are not recontaminated after cleaning by careless handling.

6.3 If the test specimens are cut from a larger coated article, cutting shall be carried out in such a way that the coating is not damaged in the area adjacent to the cut. Unless otherwise specified, the cut edges shall be adequately protected by coating them with a suitable material, which remains stable under the conditions of the test, such as paint, wax or adhesive tape.

7 Arrangement of the test specimens

7.1 The test specimens shall be placed in the cabinet so that they are not in the direct line of travel of the spray from the atomizer.

7.2 The angle at which the surface of the test specimen is exposed in the cabinet is very important. The specimens shall in principle be flat and placed in the cabinet facing upwards at an angle as close as possible to 20° to the vertical. This angle shall, in all cases, be within the limits of 15° to 25° . In the case of irregular surfaces, for example entire components, these limits shall be adhered to as closely as possible.

7.3 The test specimens shall be arranged so that they do not come into contact with the cabinet and so that surfaces to be tested are exposed to free circulation of spray. The specimens may be placed at different levels within the cabinet as long as the solution does not drip from specimens or their supports at one level onto other specimens placed below. However, for a new examination or for tests with a total duration exceeding 96 h, location permutation of specimens is permitted⁸⁾.

7.4 The supports for the test specimens shall be made of inert non-metallic material. If it is necessary to suspend specimens, the material used shall not be metallic but shall be synthetic fibre, cotton thread or other inert insulating material.

7) See Bibliography, Reference [21].

8) In this case, the number and frequency of the permutations are left up to the operator and shall be indicated in the test report.

8 Operating conditions

8.1 Operating conditions are summarized in Table 2.

Table 2—Operating conditions

Test method Item	Neutral salt spray (NSS)	Acetic acid salt spray (AASS)	Copper-accelerated acetic acid salt spray (CASS)
Temperature	35°C ± 2°C	35°C ± 2°C	50°C ± 2°C
Average collection rate for a horizontal collecting area of 80 cm ²		1,5 ml/h ± 0,5 ml/h	
Concentration of sodium chloride (collected solution)	50 g/±5 g/l		
pH (collected solution)	6,5 to 7,2	3,1 to 3,3	3,1 to 3,3

8.2 Prior to a test, first check the collection rate and other test conditions in the test chamber when it is empty or completely filled with dummy specimens. After it has been confirmed that the test conditions are within a specified range, stop spraying the salt solution, fill the test chamber with test specimens and start the test.

8.3 The solution collected in each of the collecting devices (4.5) shall have a sodium chloride concentration and a pH value within the ranges given in Table 2.

The average rate of collection of solution in each device shall be measured over a minimum period of 24 h of continuous spraying.

8.4 The test solution which has been sprayed shall not be re-used.

During operation, the solution should be free from dust and should be isolated from ambient air to prevent the concentration of sodium chloride and the pH from fluctuating.

9 Duration of tests

9.1 The period of test shall be as designated by the specification covering the material or product being tested. When not specified, this period shall be agreed upon by the interested parties.

Recommended periods of exposure are 2 h, 6 h, 24 h, 48 h, 96 h, 168 h, 240 h, 480 h, 720 h and 1000 h.

9.2 Spraying shall not be interrupted during the prescribed test period. The cabinet shall be opened only for brief visual inspections of the test specimens in position and for replenishing the salt solution in the reservoir, if such replenishment cannot be carried out from outside the cabinet.

9.3 If the end-point of the test depends on the appearance of the first sign of corrosion, the test specimens shall be inspected frequently. For this reason, this type of specimen should not be tested with other specimens requiring tests of predetermined durations.

9.4 A periodic visual examination of specimens under test for a predetermined period may be carried out, but the surfaces under test shall not be disturbed, and the period for which the cabinet is open shall be the minimum necessary to observe and record any visible changes.

10 Treatment of specimens after test

At the end of the test period, remove the test specimens from the cabinet and allow them to dry for 0,5 h to 1h before rinsing, in order to reduce the risk of removing corrosion products. Before they are examined, carefully remove the residues of spray solution from their surfaces. A suitable method is to rinse or dip the test specimens gently in clean running water, at a temperature not exceeding 40 °C, and then to dry them immediately in a stream of air, at an overpressure not exceeding 200 kPa and at a distance of approximately 300 mm.

NOTE ISO 8407 can be used for treatment of the specimen after the test.

How to treat specimens after testing should, in line with good engineering practice, be included in the test specification.

11 Evaluation of results

Many different criteria for the evaluation of the test results may be applied to meet particular requirements, for example:

- a) appearance after the test;
- b) appearance after removing superficial corrosion products;
- c) number and distribution of corrosion defects, i.e. pits, cracks, blisters, rusting or creep from scratches in the case of organic coatings, etc.; these may be assessed by methods described in ISO 8993 or ISO 10289 and, for organic coatings, in ISO 4628, Parts 1, 2, 3, 4, 5 and 8 (see Annex D);
- d) time elapsed before the appearance of the first signs of corrosion;
- e) change in mass;
- f) alteration revealed by micrographic examination;
- g) change in mechanical properties.

NOTE It is good engineering practice to define the appropriate criteria in the specification for a coating or a product to be tested.

12 Test report

12.1 The test report shall indicate the outcome of the test according to the criteria for evaluation of results prescribed for the test. Report the result obtained for each specimen tested and, when appropriate, the average result for a group of replicate test specimens. Photographic records of the tested specimens may, if required, accompany the report.

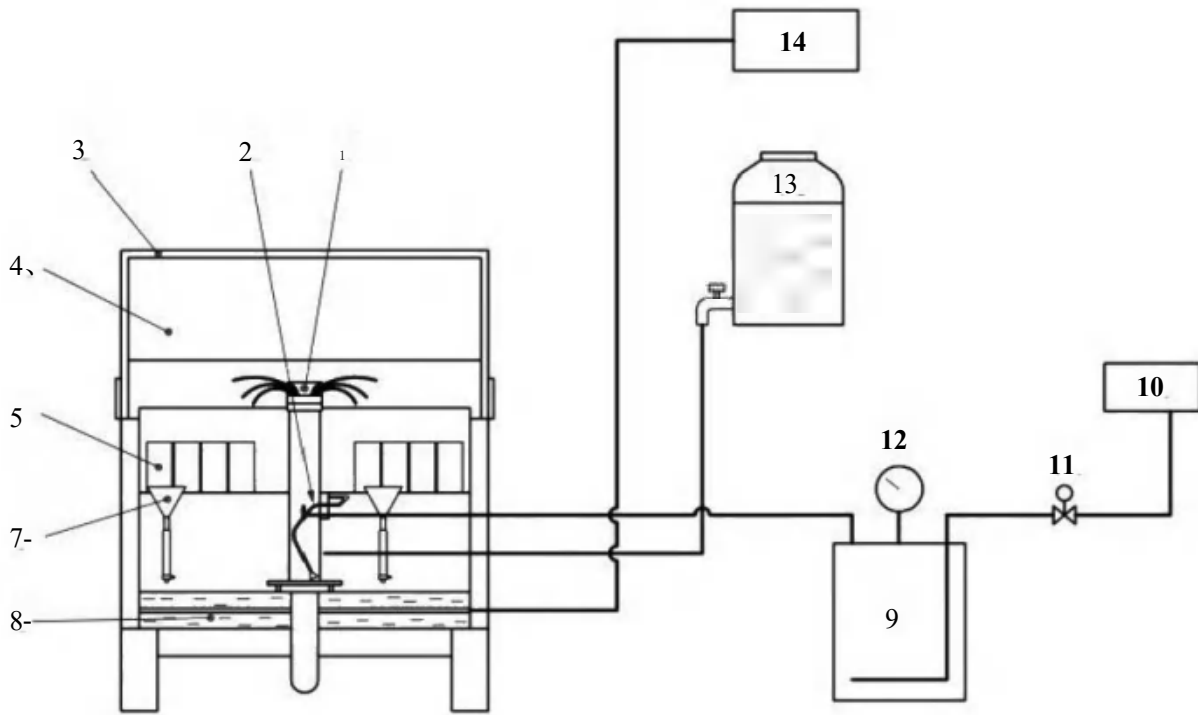
12.2 The test report shall contain information about the test procedure. This information may vary according to the purpose of the test and the guidelines prescribed, but a general list of the details likely to be required is as follows:

- a) a reference to this International Standard;
- b) type and purity of salt and water used;
- c) description of the material or product tested;
- d) dimensions and shape of the test specimen, and nature and area of the surface tested;
- e) preparation of the test specimen, including any cleaning treatment applied and any protection given to edges or other special areas;
- f) known characteristics of any coating, with an indication of the surface area;
- g) number of test specimens subjected to the test representing each material or product;

- h) method used to clean test specimens after the test with, where appropriate, an indication of the loss in mass resulting from the cleaning operation;
- i) angle at which the tested surfaces were inclined;
- j) frequency and number of specimen location permutations, if any;
- k) duration of the test and results of any intermediate inspections;
- l) properties of any reference specimens placed in the cabinet to check the stability of the operating conditions;
- m) test temperature;
- n) volume of the collected solution;
- o) pH of the test solution and the collected solution;
- p) salt concentration or density of the collected solution;
- q) result of corrosion rate of reference specimens made of steel, or for both steel and zinc (mass loss, g/m^2);
- r) any abnormality or incident occurring during the entire test procedure;
- s) intervals of inspection.

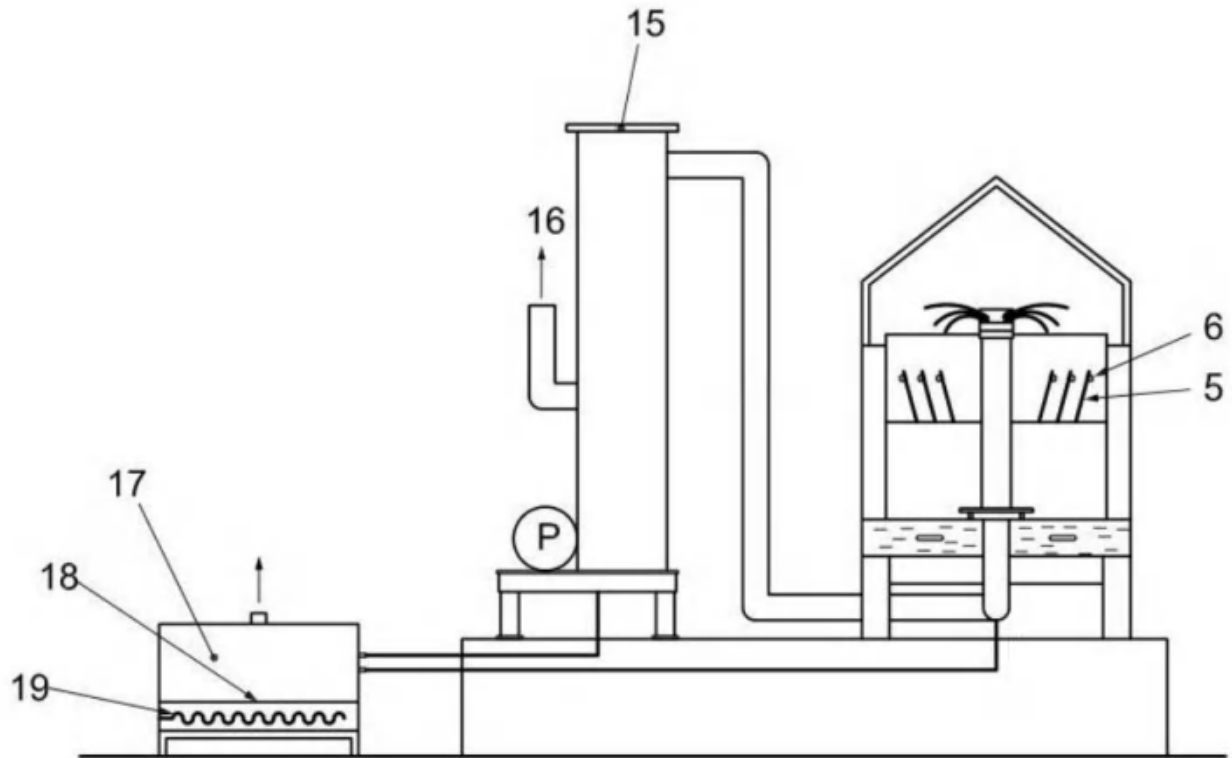
Annex A
 (informative)

Schematic diagram of one possible design of spray cabinet with means for treating fog exhaust and drain



a) Front view

Figure A.1 (continued)



b)Side view

Key

- 1 mist dispersion tower
- 2 atomizer
- 3 cover
- 4 test chamber
- 5 test specimen
- 6 test-specimen support
- 7 fog collector
- 8 chamber
- 9 air saturator
- 10 air compressor
- 11 solenoid valve
- 12 pressure gauge
- 13 solution tank
- 14 temperature controls
- 15 exhaust-treatment disposal
- 16 air-outlet port
- 17 drain-treatment disposal
- 18 salt tray
- 19 heating elements

Figure A.1—Schematic diagram of one possible design of spray cabinet

Preference shall be given to apparatus that has a means for properly dealing with fog after the test, prior to releasing it from the building for environmental conservation, and for draining water prior to discharging it to the drainage system.

Annex B (informative)

Complementary method for evaluating cabinet corrosivity using zinc reference specimens

B.1 Reference test specimens

As a complementary method for measuring cabinet corrosivity in accordance with this International Standard, four or six reference specimens of zinc with an impurity level of less than 0,1%, in mass fraction, may be used.

The reference specimens shall have dimensions of 50 mm×100 mm×1 mm.

Before testing, the reference specimens shall be cleaned carefully with a hydrocarbon solvent in order to remove all evidence of dirt, oil, or other foreign matter liable to influence the result of the corrosion rate determination. After drying, the reference specimens shall be weighed to the nearest 1 mg.

Protect one face of the reference specimens with a removable coating, for example an adhesive plastic film.

B.2 Arrangement of the reference specimens

Position four reference specimens in four different quadrants (if six specimens are used, place them in six different positions including the four quadrants) in the test cabinet, with the unprotected face upward and at an angle of $20^{\circ} \pm 5^{\circ}$ from the vertical.

The support for the reference specimens shall be made of, or coated with, inert materials such as plastic, and shall be placed at the same level as the test specimens.

The recommended test duration for the NSS test is 48 h, for the AASS test 24 h and for the CASS test 24 h.

B.3 Determination of mass loss

Immediately after the end of the test, firstly remove the protective coating, then remove the corrosion products by repetitive cleaning as described in ISO 8407. For chemical cleaning of the zinc reference specimens, use a solution of saturated glycine, 250g±5g of glycine, $C_2H_5NO_2$ (p.a.), per litre of deionized water.

The chemical cleaning procedure is preferably performed in repetitive immersions of 5 min. After each immersion step, thoroughly clean the reference specimen at ambient temperature by rinsing with water and by light brushing, then by rinsing with acetone or ethanol, followed by drying. Weigh the reference specimen to the nearest 1 mg and plot the mass versus the actual cleaning cycle as described in ISO 8407.

NOTE For efficient dissolution of the corrosion products during the immersion step, it is important that the solution be stirred continually. An ultrasonic bath might be preferred in order to increase the rate of dissolution.

From the plot of mass versus number of cleaning cycles, determine the true mass of the specimen after removal of the corrosion products as described in ISO 8407. Subtract this number from the initial mass of the reference specimen prior to testing, and divide the resulting number by the area of the exposed surface of the reference specimen to assess the metal mass loss per square metre of the reference specimen.

B.4 Satisfactory performance of cabinet

The cabinet has performed satisfactorily if the loss in mass of each steel and zinc reference specimen is within the allowed ranges given in Table B.1.

Table B.1—Allowed range of mass loss of the zinc and steel reference specimens during verification of the corrosivity of the cabinet

Test method	Test duration	Allowed range of mass loss of the zinc reference specimens	Allowed range of mass loss of the steel reference specimens
	h	g/m ²	g/m ²
NSs	48	50±25	70±20 (see 5.2.4)
AASS	24	30±15	40±10 (see 5.3.4)
CASS	24	50±20	55±15 (see 5.4.4)

Annex C (normative)

Preparation of panels with organic coatings for testing

C.1 Preparation and coating of panels

Unless otherwise specified, each test panel with organic coating shall be prepared in accordance with ISO 1514 and coated by the specified method with the product or system under test.

Unless otherwise specified, the back and edges of the panel shall be coated with the coating system under test. If the coating on the back or edges of the panel differs from that of the coating product under test, it shall have a corrosion resistance greater than that of the coating product under test.

C.2 Drying and conditioning

Dry (or stove) and age (if applicable) each coated test panel for the specified time under specified conditions and, unless otherwise specified, condition them at a temperature of $23\text{ }^{\circ}\text{C}\pm 2^{\circ}\text{C}$ and a relative humidity of $50\%\pm 5\%$ for at least 16 h, with free circulation of air and without exposing them to direct sunlight. The test procedure shall then be carried out as soon as possible.

C.3 Thickness of coating

Determine the thickness, in micrometres, of the dried coating by one of the non-destructive procedures described in ISO 2808.

C.4 Preparation of scratches

All scribe marks shall be made in accordance with ISO 17872 and shall be at least 25 mm from each other and from any edge of the test panel.

If specified, make a straight scratch or scribe mark through the coating to the substrate.

To apply the scratch, use a scratch instrument with a hard tip. Unless otherwise agreed, the scratch shall have either parallel sides or an upwards-broadening cross-section that shows a width of 0,2 mm to 1,0 mm of the metallic substrate.

One or two scribe marks may be applied. The scribe mark(s) shall be parallel to the longer edge of the test panel, unless otherwise agreed.

The tool used to introduce scribe marks should give a uniform shape. Penknives should not be used.

For aluminium panels, two scribe marks shall be made which are perpendicular to, but do not intersect, each other. One scratch shall be parallel to the rolling direction and the other at right angles.

Annex D

(normative)

Required supplementary information for testing test panels with organic coatings

The items of supplementary information listed in this annex shall be supplied, as appropriate.

The information required should preferably be agreed between the interested parties and may be derived, in part or totally, from an international or national standard or other documents related to the system under test.

- a) Substrate material and surface preparation used (see C.1).
- b) Method of application of the test coating system to the substrate (see C.1).
- c) Duration and conditions of drying (or stoving) and ageing (if applicable) of the test panel before testing (see C.2).
- d) Thickness(es), in micrometres, of the dry coating(s), and method of measurement in accordance with ISO 2808, and whether it is a single coating or multicoat system (see C.3).
- e) Number and location of scribe marks made prior to exposure (see C.4).
- f) Duration of the test.
- g) Characteristics considered in evaluating the resistance of the test coating and method(s) of inspection used.

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