



Standard Test Method for Compressive Stress of Porcelain Enamels by Loaded-Beam Method¹

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INTRODUCTION

Many methods and tests have been used in the industry to determine the relative compressive stress of porcelain enamel ground coats and cover coats. Three methods have been most commonly used. They are loaded-beam, warp, and split-ring methods. In the loaded-beam method the measure of stress is the load required to bring a specimen back to a plane after it has been bowed by controlled application of the enamel under test to one side of the specimen. The degree of the deflection of a specimen from a plane caused by controlled application of enamel to one side is the indicating measure of stress in the warp test. The indicating measurement in the split-ring test is the force required to just open a split ring after controlled application of test enamel to the outside surface of a ring.

1. Scope

1.1 This test method covers the measurement of the compressive stresses (Note 1) developed by fired porcelain enamels using the loaded-beam method.

NOTE 1—Although some may interpret the calculations that are used in this test method as indicating compressive load, it is commonly referred to as compressive stress within the porcelain enamel industry.

1.2 This test method is limited to the use of the loaded-beam method. However, this method includes charts (Fig. 1 and Fig. 2) that provide for conversion of loaded-beam test results to warp and ring stress values.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

A 424 Specification for Steel, Sheet, for Porcelain Enameling²

¹ This test method is under the jurisdiction of ASTM Committee B-8 on Metallic and Inorganic Coatings and is the direct responsibility of Subcommittee B08.12 on Materials for Porcelain Enamel and Ceramic-Metal Systems.

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² Annual Book of ASTM Standards, Vol 01.03.

3. Terminology

3.1 Description of Term Specific to This Standard

3.2 *compressive stress or stress*—a term used to designate the degree of compression that exists in a porcelain enamel on steel after processing.

4. Significance and Use

4.1 All porcelain enamel coatings or glass coatings are by necessity under some degree of compression at room temperature. The desired degree of compression or stress depends upon the type of ware and the end use of the item. Some method of determining relative compressive stress of enamels is necessary to establish the suitability of an enamel for a proposed application.

5. Apparatus

5.1 *Furnace*, suitable for simultaneous firing of at least six 1 by 12-in. (25 by 305-mm) specimens in vertical hanging position.

5.2 *Firing Rack*, suitable for furnace.

5.3 *Loaded-Beam Test Apparatus* (see Fig. 3 and Fig. 4).

5.4 *Metric Weights*, slotted, 1 to 500 g.

5.5 *Laboratory Balance*, accurate to 10 mg with necessary weights (1 to 100 g).

5.6 *Brushing Template*, $2\frac{1}{16}$ by $10\frac{15}{16}$ in. (52 by 278 mm) (see Fig. 5 for one example of achieving the desired end result).

5.7 *Stencil Brush*.

5.8 *Fluorescent Light Fixture* with diffusion panel and adjustable support.

