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Indian Standard

METHODS OF SAMPLING AND PHYSICAL TESTS FOR REFRACTORY MATERIALS

PART 23  METHODS OF TEST FOR DENSE SHAPED REFRACTORY PRODUCTS —
DETERMINATION OF RESISTANCE TO ABRASION AT AMBIENT TEMPERATURE

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

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Price Group 5
NATIONAL FOREWORD

This Indian Standard (Part 23) which is identical to ISO 16282 : 2007 'Methods of test for dense shaped refractory products — Determination of resistance to abrasion at ambient temperature' issued by the International Organization for Standardization (ISO) was adopted by the Bureau of Indian Standards on the recommendation of the Refractories Sectional Committee and approval of the Metallurgical Engineering Division Council.

The text of ISO Standard has been approved as suitable for publication as an Indian Standard without deviations. Certain conventions are, however, not identical to those used in Indian Standards. Attention is particularly drawn to the following:

a) Wherever the words 'International Standard' appear referring to this standard, they should be read as 'Indian Standard'.

b) Comma (,) has been used as a decimal marker in the International Standard while in Indian Standards, the current practice is to use a point (.) as the decimal marker.

In this adopted standard, reference appear to certain International Standards for which Indian Standards also exist. The corresponding Indian Standards which are to be substituted in their respective places are listed below along with their degree of equivalence for the editions indicated:

<table>
<thead>
<tr>
<th>International Standard</th>
<th>Corresponding Indian Standard</th>
<th>Degree of Equivalence</th>
</tr>
</thead>
<tbody>
<tr>
<td>ISO 5017 : 1998 Dense shaped refractory products — Determination of bulk density, apparent porosity and true porosity</td>
<td>IS 1528 (Part 15) : 2007 Methods of sampling and physical tests for refractory materials: Part 15 Method for determination of bulk density, apparent porosity and true porosity of dense shaped refractory products (first revision)</td>
<td>Identical</td>
</tr>
</tbody>
</table>

For the purpose of deciding whether a particular requirement of this standard is complied with the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (revised)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.
1 Scope

This International Standard specifies a method intended primarily for the determination of the abrasion resistance of shaped refractory materials at ambient temperature. It can also be used for unshaped refractory materials. It provides an indication of the suitability of the material for service in abrasive or erosive conditions.

NOTE This International Standard is based on and technically identical to EN 993-20, published by the European Committee for Standardization.

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 565, Test sieves — Metal wire cloth, perforated metal plate and electroformed sheet — Nominal sizes of openings

ISO 5017, Dense shaped refractory products — Determination of bulk density, apparent porosity and true porosity\(^1\)

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1 resistance to abrasion
resistance of refractory test pieces to the surface wear caused by the mechanical action of moving solids

3.2 resistance to erosion
resistance of refractory test pieces to the surface wear caused by the mechanical action of a fluid, which may or may not contain solid material

4 Principle

The method determines the volume of material abraded from a flat surface of a test piece placed at right angles to a nozzle through which 1 000 g of size-graded silicon carbide is blasted by compressed air at 450 kPa.

\(^1\) EN 993-1, which is referred to in the text of EN 993-20, is closely based on ISO 5017.
5 Apparatus

5.1 Abrasion tester, consisting of the equipment specified in 5.1.1 and 5.1.2.

5.1.1 Venturi blast assembly (see Figure 1) or blast gun (see Figure 2), consisting of a suitable housing with an air nozzle delivering air into the barrel of the assembly which acts as a venturi tube, the abrasive entering the barrel from the side. The air-delivery nozzle shall have an inlet inside diameter between 2,84 mm and 2,92 mm and an outlet inside diameter between 2,36 mm and 2,44 mm. The air nozzle may be protected from abrasion by covering it with a nominally 9,4 mm long piece of vinyl tubing of inside diameter 4,7 mm and wall thickness 1,5 mm. The inside diameter of the barrel of the assembly shall not exceed 10 mm and the barrel shall be checked periodically for wear.

5.1.2 Nozzle (see Figures 1 and 2), for directing the abrading medium onto the test piece, consisting of a piece of glass tubing 115 mm long, 7 mm in outside diameter, with a nominally 1,1 mm thick wall. This glass tube is attached to the blast assembly and held perpendicular to the test piece using a 70 mm long piece of stainless steel tubing, 7,15 mm inside diameter. The steel tube is glued inside a 9,53 mm tubing nut which is screwed onto the end of the blast assembly barrel. The glass tube is inserted through this steel tube and an air pressure seal made using a suitable rubber grommet compressed when the tubing nut is attached to the assembly barrel. The end of the glass tube within the blast assembly barrel shall be positioned at a distance of 2 mm from the air-delivery nozzle. This is achieved by placing the glass tube on a brass rod 4,5 mm in diameter, with a 7,9 mm shoulder 117 mm from the tip. This allows the glass tube to be inserted through the steel tube and into the barrel of the assembly until the end of the brass rod touches the air-delivery nozzle, thus ensuring a 2 mm gap between the end of the glass tube and the air-delivery nozzle.

A new piece of glass tubing shall be used for each determination.

5.2 Feed mechanism, capable of supplying 1 000 g of abrasive to the blast assembly in (450 ± 15) s. Secondary air shall be allowed to enter the system with the abrasive. A suitable feed mechanism is shown in Figures 3 and 4. It consists of three funnels:

a) an upper (charging) funnel;

b) a middle (feed control) funnel with a metal, glass or plastic orifice which provides the required feed rate;

c) a lower (delivery) funnel.

5.3 Test chamber (see Figure 3), consisting of a tightly sealed enclosure with a door to permit ready access for mounting and removing the test pieces. The blast assembly is mounted vertically in the top of the test chamber so that the downward stream of abrasive travels (203 ± 1) mm from the tip of the glass nozzle to the surface of the test piece.

The chamber shall be fitted with an exhaust vent and a butterfly valve to regulate the pressure in the chamber during the test. A cloth dust-collecting bag of adequate capacity may fitted over the end of the exhaust vent.

The upper part of the chamber shall be fitted with a tube and stopcock to allow the connection of a manometer.
Key
1 venturi housing
2 air supply
3 supply of abrasive
4 air-delivery nozzle: inside diameter at inlet 2.84 mm to 2.92 mm
inside diameter at outlet 2.36 mm to 2.44 mm
5 tubing nut
6 steel stabilizing sleeve
7 brass rod for positioning glass tube
8 glass tube with grommet
9 top of test chamber

Figure 1 — Example of venturi blast assembly
Figure 2 — Example of blast gun (dismantled)

Key
1 brass rod for positioning glass tube
2 glass tube with grommet
3 tubing nut
4 steel stabilizing sleeve
5 sand blast gun
6 air-delivery nozzle

Dimensions in millimetres
5.4 **Manometer**, capable of measuring up to 400 Pa (41 mm of water), to measure the pressure inside the chamber during the test.

5.5 **Vacuum gauge**, capable of measuring up to 750 mm of mercury (gauge pressure), to check the pressure at the entry port for the abrasive on the blast assembly.

5.6 **Balance**, capable of weighing to the nearest ±0,1 g.

5.7 **Callipers**, capable of measuring to the nearest ±0,5 mm.

5.8 **Test sieves**, conforming to the requirements of ISO 565.

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**Figure 3 — Schematic diagram of abrasion tester**

Key

1. air supply line
2. pressure regulator
3. pressure gauge
4. feed system
5. stopcock
6. venturi
7. butterfly valve
8. manometer
9. steel tube
10. exhaust vent
11. test chamber
12. glass tube
13. test piece
Key
1  blast assembly
2  air pressure regulator
3  glass tube and steel stabilizing sleeve
4  test piece
5  adjustable platform

Figure 4 — Abrasion tester — Introduction of test piece
5.9 Abrasive, consisting of silicon carbide with a particle-size distribution as given in Table 1. Before use, remove the material retained on the 850 \( \mu \text{m} \) ISO sieve and that passing the 300 \( \mu \text{m} \) ISO sieve.

![Table 1 — Sieve analysis of abrasive](image)

<table>
<thead>
<tr>
<th>Size of opening (ISO 565 — R 40/3)</th>
<th>Amount retained</th>
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</thead>
<tbody>
<tr>
<td>( 850 \mu \text{m} )</td>
<td>Trace</td>
</tr>
<tr>
<td>( 600 \mu \text{m} )</td>
<td>( 20 \pm 2 )</td>
</tr>
<tr>
<td>( 300 \mu \text{m} )</td>
<td>( 80 \pm 3 )</td>
</tr>
<tr>
<td>( 212 \mu \text{m} )</td>
<td>( 2 \text{ max.} )</td>
</tr>
<tr>
<td>&lt; 212 ( \mu \text{m} )</td>
<td>Trace</td>
</tr>
</tbody>
</table>

NOTE This silicon carbide corresponds to FEPA grit size grade P36.

5.10 Compressed-air supply: Clean, dry, compressed air supplied to the blast assembly at the required pressure by means of a regulator and an air-pressure gauge capable of being read in 7 kPa increments, mounted as close to the blast assembly as possible.

6 Test pieces

6.1 General

The number of items to be tested and the number of test pieces per item shall be agreed between the parties and stated in the test report.

6.2 Shaped refractories

For all materials except the most abrasion-resistant, test pieces measuring 114 mm \( \times \) 114 mm \( \times \) 64 mm shall be cut from refractory bricks or shapes so that one of the square faces of each test piece is a flat original surface not bearing a brand mark (see, however, Note 1 to Clause 7). Test pieces measuring 100 mm \( \times \) 100 mm \( \times \) 25 mm may be used for the most abrasion-resistant materials. The test piece dimensions shall be stated in the test report.

6.3 Unshaped refractories

Test pieces of the above-mentioned dimensions shall be prepared directly from the material under test. The preparation procedure, including treatment and firing and the temperature of firing, shall be agreed between the interested parties. One of the square faces of each test piece shall be the face which was in contact with the bottom of the mould (see, however, Note 1 to Clause 7). The test piece preparation conditions and the test piece dimensions shall be stated in full in the test report.

7 Procedure

Dry the test pieces at \((110 \pm 5) \degree \text{C}\) to constant mass.

Weigh the test pieces to \(\pm 0.1\) g. Determine their volume by measuring their length, width and thickness to the nearest 0.5 mm using callipers (5.7).
Place one of the test pieces in the test chamber with a square face perpendicular to the glass nozzle (see, however, Note 2), at a distance of \((203 \pm 1)\) mm from the nozzle tip. For test pieces from shaped refractories, the flat original surface not bearing a brand mark shall be used for the test (see, however, Note 1). For test pieces from unshaped refractories, the test surface shall be the face which was in contact with the bottom of the mould (see, however, Note 1).

NOTE 1 If required, and agreed between the interested parties, other faces, including cut surfaces, may be used in the test.

NOTE 2 If agreed between the parties, an impact angle other than 90° may be used in the test.

Turn on the compressed-air supply and regulate the pressure to \((450 \pm 7)\) kPa. Check the air pressure before and after the abrasive has run through the system.

Measure the pressure in the test chamber using the water manometer and maintain the pressure in the chamber at 310 Pa (32 mm of water) by means of the butterfly valve in the exhaust vent.

After the pressure of the compressed air supplied to the blast assembly and the test chamber pressure have been adjusted, disconnect the abrasive feed line and connect the 750 mmHg vacuum gauge to the abrasive entry port on the blast assembly (see Note 3). If the vacuum gauge does not show a minimum pressure of 375 mmHg, check the position of the glass tube or the condition of the air-delivery nozzle. After obtaining the correct vacuum, reconnect the abrasive feed line and recheck the test chamber pressure before placing \((1 000 \pm 5)\) g of dry abrasive in the upper (charging) funnel. The lower (delivery) funnel shall not be completely filled or flooded with abrasive. Connect the feed mechanism to the blast assembly. It shall deliver the abrasive in the specified time of \((450 \pm 15)\) s.

NOTE 3 As an alternative, a suitable vacuum gauge may be built into the apparatus (see Figure 4).

Remove the test piece from the test chamber, blow off the dust, and immediately weigh to the nearest 0.1 g.

NOTE 4 The time between abrading and weighing the abraded test piece should not exceed 10 min, to prevent the test piece absorbing moisture from the air.

Repeat the procedure with the next test piece, using fresh silicon carbide abrasive and a new piece of glass tubing.

8 Calculation

Calculate the bulk density of each test piece, in grams per cubic centimetre, from the mass and the volume determined in Clause 7, or by the method given in ISO 5017.

Calculate the volume of material lost by abrasion from each test piece, \(A\), in cubic centimetres, as follows:

\[
A = \left(\frac{m_1 - m_2}{\rho}\right) = \frac{m}{\rho}
\]

where

\[
\rho \quad \text{is the bulk density, in grams per cubic centimetre;}
\]

\[
m_1 \quad \text{is the mass of the test piece before testing, in grams;}
\]

\[
m_2 \quad \text{is the mass of the test piece after testing, in grams;}
\]

\[
m \quad \text{is the loss in mass of the test piece, in grams.}
\]

9 Precision

No precision data were available at the time of the preparation of this International Standard, but precision data may be added later if and when they become available.
10 Test report

The test report shall include the following information:

a) all information necessary for identification of the sample tested, including manufacturer, type and batch number;

b) a reference to this International Standard, i.e. ISO 16282:2007;

c) the name of the test establishment;

d) the dimensions of the test pieces;

e) the number of items tested and the number of test pieces per item;

f) for unshaped refractories, the conditions of preparation, including treatment and firing, of the test pieces;

g) all details necessary to identify the surface abraded, if different from that specified in Clause 7;

h) the impact angle of the abrasive on the test piece, if different from that specified in Clause 7;

i) the results of the test, including the results of the individual determinations and their mean, calculated as specified in Clause 8;

j) any deviations from the procedure specified;

k) any unusual features (anomalies) observed during the test;

l) the date of the test.
IS 1528 (Part 23) : 2011
ISO 16282 : 2007

Bibliography

[1] EN 993-1, Methods of test for dense shaped refractory products — Part 1: Determination of bulk density, apparent porosity and true porosity

[2] EN 993-20, Methods of test for dense shaped refractory products — Part 20: Determination of resistance to abrasion at ambient temperature
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Amendments Issued Since Publication

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BUREAU OF INDIAN STANDARDS

Headquarters:
Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002
Telephones: 2323 0131, 2323 3375, 2323 9402 Website: www.bis.org.in

Regional Offices: Telephones

Central : Manak Bhavan, 9 Bahadur Shah Zafar Marg NEW DELHI 110002 2323 7617, 2323 3841

Eastern : 1/14 C.I.T. Scheme VII M, V.I.P. Road, Kankurgachi KOLKATA 700054 2337 8499, 2337 8561 2337 8626, 2337 9120

Northern : SCO 335-336, Sector 34-A, CHANDIGARH 160022 260 3843, 260 9285

Southern : C.I.T. Campus, IV Cross Road, CHENNAI 600113 2254 1216, 2254 1442 2254 2519, 2254 2315

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