

Title (en)

Process and apparatus for applying a phosphate coating on workpieces

Title (de)

Verfahren und Vorrichtung zum Aufbringen eines Phosphatüberzuges auf Werkstücke

Title (fr)

Procédé et dispositif pour appliquer sur des pièces une couche de phosphate

Publication

**EP 0987350 B1 20060628 (DE)**

Application

**EP 99890263 A 19990805**

Priority

AT 136398 A 19980806

Abstract (en)

[origin: EP0987350A2] A long ferrous metal workpiece is phosphate coated by passing the heated moving workpiece through a phosphating bath while supplying an electric (preferably cathodic) current. A phosphate coating is applied onto a long ferrous metal workpiece by heating the moving workpiece and then passing it through a phosphating bath with a dwell time of 1.5-19 (preferably 4-9) sec. in the presence of an electric (preferably cathodic) current. An Independent claim is also included for a phosphate coating apparatus for carrying out the above process, in which the phosphating unit (5) is preceded by a workpiece preheater (3) and is in the form of an electrolytic unit with a tubular electrode surrounding the workpiece (11).

IPC 8 full level

**C25D 11/36** (2006.01)

CPC (source: EP)

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Cited by

DE102015121349A1; CN110863229A; CN112226755A; CN103741195A

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