

## **The Cast Iron Enamel Frits and The Coatings**

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The enamel frits which is used for sheet steel, can not be used over cast iron raw parts because of the coefficient of expansion value needs to have much more higher values than the coefficient of expansion values of steel enamels. So the cast iron enamels are fired 750 – 790 °C during 12 – 20 minutes. The application fields of enamelled cast iron enamels are kitchenwares, stoves, grids, burner caps and bathtubs... The most usable enamels are mat black, gloss black, white, transparent and majolicas on cast iron. The raw parts of the cast iron composition is very important in order to be enamelled. The sintered ground coat enamel is applied for ground coat which is the under of white, cream and the colored enamels. Mat black and gloss black enamels are applied direct on the cast iron raw parts. The majolica enamels are applied over the second coat of intermediate layer for third coat. Usually, the spraying method is used for the cast iron enamels, but sometimes the dipping method is also used.

**Keywords:** cast iron, majolica enamel, coating, grid, spraying method.