

Blasting Standards

BLAST CLEANING - PREPARATION GUIDES

grade - BS 7079 SS 05 59 00

description, when viewed with the naked eye

SA 2

Thorough blast cleaning: Commercial finish 65% clean

The surface shall be free from visible oil, dirt and grease, from poorly adhering mill scale, rust, paint coatings and foreign matter. Any residual contamination should be firmly adhering.

SA 2.5

Very thorough blast cleaning: Near white metal 85% clean

The surface shall be free from visible oil, dirt and grease, from poorly adhering mill scale, rust, paint coatings and foreign matter. The metal has a greyish colour. Any traces of contamination shall be visible only as slight stains in the form of spots or stripes.

SA 3

Blast cleaning to pure metal: White metal 100% clean

The surface shall be free from visible oil, dirt and grease, from poorly adhering mill scale, rust, paint coatings and foreign matter. The blasted surface must have a uniform metallic colour.

BLASTING GRADES

Following is a table giving a clear indication of the comparative blasting grades applicable to national and international standards:

BLASTING GRADE COMMON STANDARDS COMPARISON

SSPC steel structures painting council

BS 7079 British standards

SS 05 59 00 Swedish standards

BS 4232

NACE, National Association of Corrosion Engineers

white metal (SP5) SA 3

1st quality

grade 1

near white metal (SP10) SA 2.5

2nd quality

grade 2

commercial finish (SP6) SA 2

3rd quality

grade 3

RUST GRADES

A Surface mostly covered with adherent mill scale, with little or no rust

B Mill scale has begun to flake, rust has started to form

C Mill scale has rusted away or can be scraped off easily and slight pitting has taken place

D Mill scale has rusted away and general pitting can be seen with naked eye