



SURFACE CLEANLINESS STANDARDS FOR BLAST CLEANED SURFACE

DEGREES OF CLEANLINESS

Please note: There is no correlation between the degree of blast cleaning used and the surface profile produced and no specific correlation with removal of chemical contamination (or non-visible salts). For these issues, written standards and other measuring techniques must be used.

Please note: Images shown are for illustrative purposes only. For reference purposes please use relevant visual guides.

<p>Mill scale has started to flake with light rusting</p>						
	Rust Grade B	Sa 3	Sa 2 1/2	Sa 2	Sa 1	
	<p>All mill scale has flaked and complete rusting</p>					
		Rust Grade C	Sa 3	Sa 2 1/2	Sa 2	Sa 1
		<p>Pitting and complete rusting</p>				
Rust Grade D			Sa 3	Sa 2 1/2	Sa 2	Sa 1

<p>KEY / RUST GRADE</p>	<p>WHITE METAL</p> <p>Free of all visible oil, grease, dirt, dust, mill scale and rust</p> <p>SSPC-SP 5 NACE No. 1 SA-3</p>	<p>NEAR-WHITE METAL</p> <p>Evenly dispersed very light shadows, streaks and discolorations caused by stains of rust and mill scale may remain on 5% of the surface.</p> <p>SSPC-SP 10 NACE No. 2 SA-2 1/2</p>	<p>COMMERCIAL</p> <p>Evenly dispersed very light shadows, streaks and discolorations caused by stains of rust and mill scale may remain on no more than 33% of the surface.</p> <p>SSPC-SP 6 NACE No. 3 SA-2</p>	<p>BRUSH OFF</p> <p>Tightly adherent mill scale and rust may remain on the surface. Mill scale and rust are considered adherent if they cannot be removed with a dull putty knife.</p> <p>SSPC-SP 7 NACE No. 4 SA-1</p>
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