

Abrasive Blast Standards Cross-Over Chart

| | NACE | SSPC | Swedish (Sa) |
|---|------|-----------|--------------|
| <p>White Metal Blast**</p> <p>White metal blast cleaning is a method of preparing steel surfaces which, when viewed without magnification, shall be free of all visible oil, grease, dirt, dust mill scale, rust and paint.</p> | 1 | SSPC-SP5 | Sa3 |
| <p>Near White Metal Blast Cleaning**</p> <p>Near-white blast cleaning is method of preparing steel surfaces which, when viewed without magnification, must be free of all visible oil, grease, dirt, dust, mill scale, rust and paint. Generally, evenly dispersed, very light shadows, streaks and discolorations caused by stains of rust, stains of mill scale and stains of previously applied paint may remain on no more than 5% of the surface.</p> | 2 | SSPC-SP10 | Sa2 ½ |
| <p>Commercial Blast Cleaning**</p> <p>Commercial blast cleaning is a method of preparing steel surfaces which, when viewed without magnification, must be free of all visible oil, grease, dirt, dust, mill scale, rust and paint. Generally, evenly dispersed, very light shadows, streaks and discolorations caused by stains of rust, stains of mill scale, and stains of previously applied paint may remain on no more than 33% of the surface. Slight residues of rust and paint may also be left in the craters of pits if the original surface is pitted.</p> | 3 | SSPC-SP6 | Sa2 |
| <p>Brush Off Blast Cleaning</p> <p>Brush-off blast cleaning is a method of preparing steel surfaces which, when viewed without magnification, must be free of all visible oil, grease, dirt, loose mill scale, loose rust and loose paint. Tightly adhered mill scale, rust and paint may remain on the surface. The entire surface must be subject to the abrasive blast. The remaining mill scale, rust or paint must be tight and the surface sufficiently abraded to provide good adhesion and bonding of the specified paint system.</p> | 4 | SSPC-SP7 | Sa1 |

** The appearance of the surface may be affected by the particular blasting abrasive used. Uniformity of colour may be affected by the grade, original surface condition, and configuration of the materials being cleaned, as well as by discolorations from mill or fabrication marks and the shadowing from blast cleaning patterns. SSPC-Vis 1 or other visual standards of surface preparation agreed upon by the contracting parties may be used to further define the surface.