



wade hannon
Wade_Hannon
@graco.com

"SSPC
and
NACE
Joint
Technical
Report
Wet
Blasting"

221.1 KB



SSPC-TR 2/NACE 6G198
May 1, 1998
Editorial Revisions November 1, 2004

SSPC-TR 2/NACE 6G198
JOINT TECHNICAL REPORT
Wet Abrasive Blast Cleaning

SSPC: The Society for Protective Coatings (SSPC) and NACE International (NACE) issue this report in conformance with the best current technology regarding the specific subject. This report represents a consensus of those individual members who have reviewed this document. It is intended to aid the supplier, the user and the general public. Its acceptance does not in any respect preclude any person or organization, whether they have adopted the report or not, from manufacturing, marketing, purchasing, or using products, processes, or procedures not in conformance with this report. Nothing contained in this report is to be construed as granting any right, by implication or otherwise, to manufacture, sell, or use in connection with any method, apparatus, or product covered by Letters Patent, or as indemnifying or protecting anyone against liability for infringement of Letters Patent. This report represents minimum requirements and should in no way be interpreted as a restriction on the use of better procedures or materials. Neither is this report intended to apply in all related cases. Unpredictable circumstances may negate the usefulness of this report in specific instances. SSPC and NACE assume no responsibility for the interpretation or use of this report by other parties and accept responsibility for only those official interpretations issued by SSPC or NACE in accordance with their respective governing procedures and policies, which preclude the issuance of interpretations by individual volunteers.

Users of this report are responsible for reviewing appropriate health, safety, and regulatory documents and for determining their applicability in relation to this report prior to its use. This SSPC/NACE report may not necessarily address all safety problems and hazards associated with the use of materials, operations, and/or equipment detailed or referred to within this document.

CAUTIONARY NOTICE: SSPC/NACE reports are subject to periodic review and may be revised or withdrawn at any time without prior notice. SSPC and NACE require that action be taken to reaffirm, revise, or withdraw this report no later than five years from the date of initial publication. The user is cautioned to obtain the latest edition. For information on this and other joint SSPC/NACE publications, contact either organization. The SSPC Publications Dept. may be reached at 40 24th Street, Pittsburgh, PA 15222-4656 (telephone +1 412-281-2331). The NACE International Membership Services Dept. may be reached at 1440 South Creek, Houston, Texas 77064-4906 (telephone +1 281-226-6200).

Foreword

This joint report was prepared by the SSPC/NACE Joint Task Group C on Wet Abrasive Blast Cleaning, which is comprised of members of both the SSPC Surface Preparation Committee and the NACE Unit Committee T6G on Surface Preparation (now STG 04). It is intended to be used primarily by specifiers, owners, painting contractors, inspectors, and others involved in surface preparation of industrial structures.

1. Scope

This document covers procedures, equipment, and materials involved in a variety of air/water/abrasive, water/abrasive, and water-pressurized abrasive blast cleaning systems. Equipment usage and safety are also discussed.

2. Description and Use

2.1 Air/water/abrasive blasting is a cleaning method in which water is injected into the air/abrasive stream generated by conventional air-pressurized abrasive blasting equipment.

2.1.1 Water helps to remove contaminants from the substrate, to wet the abrasive, and to substantially reduce dispersion of fine particulates (dust). Particulates are often caused by the breakup of the abrasives, surface corrosion products, and paint if the surface has been previously painted. Dust suppression is achieved by thoroughly wetting the abrasive and other particles to encapsulate them with a thin film of moisture. The objective is to remove contaminants and suppress the dusting effect caused by the impact of the abrasive on the substrate, while retaining the blasting characteristics of dry abrasive, including creation of anchor profile.

2.1.2 Air/water/abrasive blasting is an alternative to waterjetting, dry blasting, and water blasting with abrasive injection.

2.1.3 Air/water/abrasive blasting is referred to hereafter as "wet blasting."

2.2 Water/abrasive blasting is a cleaning method in which abrasive is injected into the water stream generated by conventional fluid pumps.