

SURFACE PREPARATION

FOR CORROSION PROTECTION

Extensive, professional preparation of the material to be protected is necessary for a high-quality and durable anti-corrosion coating since surfaces are contaminated with substances that reduce adhesion and aid corrosion. The method and intensity of the surface preparation must be adapted to the initial condition and the expected load. The rust grades A and C, as well as various preparation grades, are listed below:

PICTURE EXAMPLES BASED ON ISO 12944, PART 4

Rust Grade A

Steel surface largely covered with adhering mill scale but little, if any, rust.



Standard Preparation Grade Sa 1

Based on rust grade A

Only loose mill scale, rust and coatings are removed.

Preparation grade A Sa 1 is not listed in Part 4 of ISO 12944. It is shown here only as an example of an insufficient grade.



Standard Preparation Grade Sa 2½

Based on rust grade A

Mill scale, rust and coatings are removed to the extent that traces remaining on the steel surface merely appear as slight staining due to the tingeing of the pores.



Standard Preparation Grade Sa 3

Based on rust grade A, B or C

Mill scale, rust and coatings are removed completely (assessment without magnification).



FROM SPEC TO PROTECT

protectiveeu.sherwin-williams.com

SHERWIN
WILLIAMS®

SURFACE PREPARATION

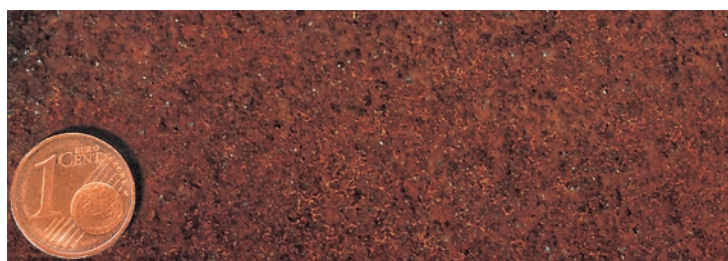
FOR CORROSION PROTECTION

Note: these illustrations are not identical to similar reference samples of well-known standards (SIS 0559000, ISO 8501-1). Like them, they are intended to visualise the verbal descriptions of the standards as examples. It must be considered that there is no generally valid appearance or picture for the appearance of a standard preparation grade since changing factors such as initial condition, type and colour of the shot, etc. can lead to different appearances. Sa 3 is illustrated only once – at the end of A-series. It also applies similarly to the C-series since, as the TOP preparation grade, it is independent of the initial condition. Blasting material used: melted coal slag.

PICTURE EXAMPLES BASED ON ISO 12944, PART 4

Rust Grade C

Steel surface on which the mill scale has rusted away or from which it can be scraped, but with slight pitting visible under normal vision.



Hand cleaning/manually derusting

Based on rust grade C

Poorly adhering mill scale and rust are removed by hand tool cleaning (e.g. scraper or wire brush etc.) or power tools. This surface state is suitable for surface tolerant primers.



Standard Preparation Grade Sa 2

Based on rust grade C

Mill scale, rust and coatings are removed almost completely, i.e. firmly adhering mill scale, rust and coatings remaining do not form a continuous layer.



Standard Preparation Grade Sa 2½

Based on rust grade C

Mill scale, rust and coatings are removed to the extent that traces remaining on the steel surface merely appear as slight staining due to the tingeing of the pores.



SHERWIN-WILLIAMS®

protectiveeu.sherwin-williams.com

United Kingdom: +44 1204 556420
sales.uk@sherwin.com

Romania: +40 256 420 320
sales.balkan@sherwin.com

Sweden: +46 381 26104
cspm.sweden@sherwin.com

Switzerland: +41 44 936 77 77
cspmbubikon@sherwin.com

Italy: +39 051 770 612
cspm.italy@sherwin.com

Germany: +49 7042 109 4000
pm.kundenservice@sherwin.com

Spain: +34 96 121 89 80
pedidos.valencia@sherwin.com

Hungary: +48 882 817 420
cs.pm@sherwin.com

Poland: +48 886 342 873
cs.pm@sherwin.com

Other countries (English): +49 7042 109 4400
pm.customerservice@sherwin.com