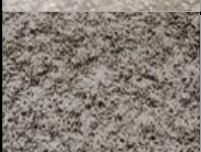
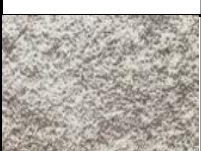


International Standard for Surface Preparation prior to Painting/Coating

Description	American Standard	International Standard	Sweden Standard	British Standard		Surface Profile
	SSPC	ISO 8501-1	SIS 05 5900	BS 4232	NACE	
Solvent Cleaning Removal of all visible oil, grease, dirt, soil, salts and contaminants by cleaning with solvent, vapor, cleaning compound, alkali, emulsion, or steam.	SSPC-SP-01					
Hand Tool Cleaning Removal all loose rust, loose mill scale, and loose paint to a degree specified, by hand chipping, scraping, sanding and wire brushing	SSPC-SP-02	St 2	St 2			
Power Tool Cleaning Removal of all loose rust, loose mill scale, and loose paint to degree specified, by power tool chipping, power tool descaling, power sanding, power wire brushing and power grinding.	SSPC-SP-03	St 3	St 3			
Flame Cleaning of New Steel	SSPC-SP-04					
White Metal Blast Cleaning Removal of all visible rust, mill scale, paint, and foreign matter by blast cleaning by wheel or nozzle (dry or wet) using sand, grit or shot. (For very corrosive atmospheres where high cost of cleaning is warranted.)	SSPC-SP-05	Sa 3	Sa 3	First Quality	#1	
Commercial Blast Cleaning Blast cleaning until at least two-thirds of the surface area is free of all visible residues. (For conditions where thoroughly cleaned surface is required.)	SSPC-SP-06	Sa 2	Sa 2	Third Quality	#3	
Brush-off Blast Cleaning Blast cleaning of all except tightly adhering residues of mill scale, rust and coatings, exposing numerous evenly distributed flecks of underlying metal	SSPC-SP-07	Sa 1	Sa 1		#4	
Pickling Complete removal of rust and mill scale by acid pickling, duplex pickling, or electrolytic pickling	SSPC-SP-08					
Weathering & Blast Cleaning	SSPC-SP-09					
Near White Blast Cleaning Blast cleaning nearly to white metal cleanliness, until at least 95% of the surface area is free of all visible residues. (for high humidity, chemical atmosphere, marine, or other corrosive environments.)	SSPC-SP-10	Sa 2½	Sa 2½	Second Quality	#2	
Power Tool Cleaning to Bare Metal Complete removal of all rust, scale and paint by power tools, with resultant surface profile	SSPC-SP-11					
Pressure Water Jetting Surface Preparation and Cleaning of Steel and Other Hard Materials by High and Ultrahigh Pressure Water Jetting prior to recoating	SSPC-SP-12				#5	
Surface Preparation of Concrete This standard gives requirements for surface preparation of concrete by mechanical, chemical, or thermal methods prior to the application of bonded protective coating or lining systems. The requirements of this standard are applicable to all types of cementitious surfaces including cast-in-place concrete floors and walls, pre-cast slabs, masonry walls and shotcrete surfaces. An acceptable prepared concrete surface should be free of contaminants, laitance, loosely adhering concrete, and dust, and should provide a dry, sound, uniform substrate suitable for the application of protective coating or lining systems.	SSPC-SP-13				#6	
Industrial Blast Cleaning Surfaces viewed without magnification, are free of all visible oil, grease, dust, and dirt. Traces of tightly adherent mill scale, rust and coating residue are permitted to remain on 10% of each unit area of the surface if they are evenly distributed.	SSPC-SP-14				#8	