

**Värvid ja lakid. Teraskonstruksioonide  
korrosioonitõrje värvkattesüsteemidega.  
Osa 4: Pinnatüübid ja pinna  
ettevalmistamine**

Paints and varnishes - Corrosion protection of steel  
structures by protective paint systems - Part 4:  
Types of surface and surface preparation

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN ISO 12944-4:1999 sisaldab Euroopa standardi EN ISO 12944-4:1998 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 12.12.1999 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN ISO 12944-4:1999 consists of the English text of the European standard EN ISO 12944-4:1998.</p> <p>This document is endorsed on 12.12.1999 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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<p><b>Käsitlusala:</b></p> <p>Standardi see osa käsitleb järgmisi süsinikterasest või madallegeerterasest koosnevate teraskonstruktsioonide pinnatööpe ja nende ettevalmistamist: - katmata pinnad; - pinnad, mis on kaetud termopihustatud tsingi, alumiiniumi või nende sulamitega; - kuumsukelgalvaanitud pinnad; - tsinkgalvaanitud pinnad; - kuivtsingitud pinnad; - krundiga eeltöödeldud pinnad; - muud värvitud pinnad.</p>	<p><b>Scope:</b></p>
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ICS 87.020, 91.080.10

**Võtmesõnad:** kaitsekatted, korrosioon, korrosioonitõrje, lakid, pinna seisund, pinnatöötlus, teraskonstruktsioon, värvid

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**English version**

Paints and varnishes

**Corrosion protection of steel structures by  
protective paint systems**

**Part 4: Types of surface and surface preparation  
(ISO 12944-4 : 1998)**

Peintures et vernis – Anticorrosion  
des structures en acier par systèmes  
de peinture – Partie 4: Types de  
surface et de préparation de surface  
(ISO 12944-4 : 1998)

Beschichtungsstoffe – Korrosions-  
schutz von Stahlbauten durch  
Beschichtungssysteme – Teil 4: Arten  
von Oberflächen und Oberflächenvor-  
bereitung (ISO 12944-4 : 1998)

This European Standard was approved by CEN on 1997-06-16.

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Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

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**CEN**

European Committee for Standardization  
Comité Européen de Normalisation  
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**Central Secretariat: rue de Stassart 36, B-1050 Brussels**

## Foreword

International Standard

ISO 12944-4 : 1998 Paints and varnishes – Corrosion protection of steel structures by protective paint systems – Part 4: Types of surface and surface preparation,

which was prepared by ISO/TC 35 'Paints and varnishes' of the International Organization for Standardization, has been adopted by Technical Committee CEN/TC 139 'Paints and varnishes', the Secretariat of which is held by DIN, as a European Standard.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, and conflicting national standards withdrawn, by November 1998 at the latest.

In accordance with the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard:

Austria, Belgium, the Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, the Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

## Endorsement notice

The text of the International Standard ISO 12944-4 : 1998 was approved by CEN as a European Standard without any modification.

NOTE: Normative references to international publications are listed in Annex ZA (normative).

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## Introduction

Unprotected steel in the atmosphere, in water and in soil is subject to corrosion that may lead to damage. Therefore, to avoid corrosion damage, steel structures are normally protected to withstand the corrosion stresses during the service life required of the structure.

There are different ways of protecting steel structures from corrosion. ISO 12944 deals with protection by paint systems and covers, in the various parts, all features that are important in achieving adequate corrosion protection. Additional or other measures are possible but require particular agreement between the interested parties.

In order to ensure effective corrosion protection of steel structures, it is necessary for owners of such structures, planners, consultants, companies carrying out corrosion protection work, inspectors of protective coatings and manufacturers of coating materials to have at their disposal state-of-the-art information in concise form on corrosion protection by paint systems. Such information has to be as complete as possible, unambiguous and easily understandable to avoid difficulties and misunderstandings between the parties concerned with the practical implementation of protection work.

This International Standard — ISO 12944 — is intended to give this information in the form of a series of instructions. It is written for those who have some technical knowledge. It is also assumed that the user of ISO 12944 is familiar with other relevant International Standards, in particular those dealing with surface preparation, as well as relevant national regulations.

Although ISO 12944 does not deal with financial and contractual questions, attention is drawn to the fact that, because of the considerable implications of inadequate corrosion protection, non-compliance with requirements and recommendations given in this standard may result in serious financial consequences.

ISO 12944-1 defines the overall scope of all parts of ISO 12944. It gives some basic terms and definitions and a general introduction to the other parts of ISO 12944. Furthermore, it includes a general statement on health, safety and environmental protection, and guidelines for using ISO 12944 for a given project.

This part of ISO 12944 describes different types of surface to be protected and gives information on surface preparation methods such as chemical, mechanical and flame cleaning. It deals with surface preparation grades, surface profile (roughness), assessment of prepared surfaces, temporary protection of prepared surfaces, preparation of temporarily protected surfaces for further coatings, preparation of existing metal coatings, and environmental aspects. As far as possible, reference is made to the basic International Standards on the surface preparation of steel substrates before application of paints and related products.

## 1 Scope

This part of ISO 12944 deals with the following types of surfaces of steel structures consisting of carbon or low-alloy steel, and their preparation:

- uncoated surfaces;
- surfaces thermally sprayed with zinc, aluminium or their alloys;
- hot-dip-galvanized surfaces;
- zinc-electroplated surfaces;
- sherardized surfaces;
- surfaces painted with prefabrication primer;
- other painted surfaces.

This part of ISO 12944 defines a number of surface preparation grades but does not specify any requirements for the condition of the substrate prior to surface preparation.

Highly polished surfaces and work-hardened surfaces are not covered by this part of ISO 12944.

## 2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 12944. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 12944 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 1461:—<sup>1)</sup>, *Hot dip galvanized coatings on fabricated ferrous products — Specifications.*

ISO 2063:1991, *Metallic and other inorganic coatings — Thermal spraying — Zinc, aluminium and their alloys.*

ISO 2409:1992, *Paints and varnishes — Cross-cut test.*

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1) To be published. (Revision of ISO 1459:1973 and ISO 1461:1973)



- ISO 4628-1:1982, *Paints and varnishes — Evaluation of degradation of paint coatings — Designation of intensity, quantity and size of common types of defect — Part 1: General principles and rating schemes.*
- ISO 4628-2:1982, *Paints and varnishes — Evaluation of degradation of paint coatings — Designation of intensity, quantity and size of common types of defect — Part 2: Designation of degree of blistering.*
- ISO 4628-3:1982, *Paints and varnishes — Evaluation of degradation of paint coatings — Designation of intensity, quantity and size of common types of defect — Part 3: Designation of degree of rusting.*
- ISO 4628-4:1982, *Paints and varnishes — Evaluation of degradation of paint coatings — Designation of intensity, quantity and size of common types of defect — Part 4: Designation of degree of cracking.*
- ISO 4628-5:1982, *Paints and varnishes — Evaluation of degradation of paint coatings — Designation of intensity, quantity and size of common types of defect — Part 5: Designation of degree of flaking.*
- ISO 4628-6:1990, *Paint and varnishes — Evaluation of degradation of paint coatings — Designation of intensity, quantity and size of common types of defect — Part 6: Rating of degree of chalking by tape method.*
- ISO 8501-1:1988, *Preparation of steel substrates before application of paints and related products — Visual assessment of surface cleanliness — Part 1: Rust grades and preparation grades of uncoated steel substrates and steel substrates after overall removal of previous coatings.*
- Informative Supplement to ISO 8501-1:1988, *Representative photographic examples of the change of appearance imparted to steel when blast-cleaned with different abrasives.*
- ISO 8501-2:1994, *Preparation of steel substrates before application of paints and related products — Visual assessment of surface cleanliness — Part 2: Preparation grades of previously coated steel substrates after localized removal of previous coatings.*
- ISO/TR 8502-1:1991, *Preparation of steel substrates before application of paints and related products — Tests for the assessment of surface cleanliness — Part 1: Field test for soluble iron corrosion products.*
- ISO 8502-2:1992, *Preparation of steel substrates before application of paints and related products — Tests for the assessment of surface cleanliness — Part 2: Laboratory determination of chloride on cleaned surfaces.*
- ISO 8502-3:1992, *Preparation of steel substrates before application of paints and related products — Tests for the assessment of surface cleanliness — Part 3: Assessment of dust on steel surfaces prepared for painting (pressure-sensitive tape method).*
- ISO 8502-4:1993, *Preparation of steel substrates before application of paints and related products — Tests for the assessment of surface cleanliness — Part 4: Guidance on the estimation of the probability of condensation prior to paint application.*
- ISO 8503-1:1988, *Preparation of steel substrates before application of paints and related products — Surface roughness characteristics of blast-cleaned steel substrates — Part 1: Specifications and definitions for ISO surface profile comparators for the assessment of abrasive blast-cleaned surfaces.*
- ISO 8503-2:1988, *Preparation of steel substrates before application of paints and related products — Surface roughness characteristics of blast-cleaned steel substrates — Part 2: Method for the grading of surface profile of abrasive blast-cleaned steel — Comparator procedure.*
- ISO 8504-1:1992, *Preparation of steel substrates before application of paints and related products — Surface preparation methods — Part 1: General principles.*
- ISO 8504-2:1992, *Preparation of steel substrates before application of paints and related products — Surface preparation methods — Part 2: Abrasive blast-cleaning.*
- ISO 8504-3:1993, *Preparation of steel substrates before application of paints and related products — Surface preparation methods — Part 3: Hand- and power-tool cleaning.*



- ISO 11124-1:1993, *Preparation of steel substrates before application of paints and related products — Specifications for metallic blast-cleaning abrasives — Part 1: General introduction and classification.*
- ISO 11124-2:1993, *Preparation of steel substrates before application of paints and related products — Specifications for metallic blast-cleaning abrasives — Part 2: Chilled-iron grit.*
- ISO 11124-3:1993, *Preparation of steel substrates before application of paints and related products — Specifications for metallic blast-cleaning abrasives — Part 3: High-carbon cast-steel shot and grit.*
- ISO 11124-4:1993, *Preparation of steel substrates before application of paints and related products — Specifications for metallic blast-cleaning abrasives — Part 4: Low-carbon cast-steel shot.*
- ISO 11126-1:1993, *Preparation of steel substrates before application of paints and related products — Specifications for non-metallic blast-cleaning abrasives — Part 1: General introduction and classification.*
- ISO 11126-3:1993, *Preparation of steel substrates before application of paints and related products — Specifications for non-metallic blast-cleaning abrasives — Part 3: Copper refinery slag.*
- ISO 11126-4:1993, *Preparation of steel substrates before application of paints and related products — Specifications for non-metallic blast-cleaning abrasives — Part 4: Coal furnace slag.*
- ISO 11126-5:1993, *Preparation of steel substrates before application of paints and related products — Specifications for non-metallic blast-cleaning abrasives — Part 5: Nickel refinery slag.*
- ISO 11126-6:1993, *Preparation of steel substrates before application of paints and related products — Specifications for non-metallic blast-cleaning abrasives — Part 6: Iron furnace slag.*
- ISO 11126-7:1995, *Preparation of steel substrates before application of paints and related products — Specifications for non-metallic blast-cleaning abrasives — Part 7: Fused aluminium oxide.*
- ISO 11126-8:1993, *Preparation of steel substrates before application of paints and related products — Specifications for non-metallic blast-cleaning abrasives — Part 8: Olivine sand.*
- ISO 12944-1:1998, *Paints and varnishes — Corrosion protection of steel structures by protective paint systems — Part 1: General introduction.*
- EN 10238:1996, *Automatically blast-cleaned and automatically prefabrication primed structural steel products.*

### 3 Definitions

For the purposes of this part of ISO 12944, the following definitions apply in addition to those given in ISO 12944-1.

- 3.1 abrasive blast-cleaning:** The impingement of a high-kinetic-energy stream of blast-cleaning abrasive on to the surface to be prepared.
- 3.2 blast-cleaning abrasive:** A solid material intended to be used for abrasive blast-cleaning. [ISO 11124-1; ISO 11126-1]
- 3.3 dust:** Loose particulate matter present on a steel surface prepared for painting, arising from blast-cleaning or other surface preparation processes, or resulting from the action of the environment. [ISO 8502-3]
- 3.4 dew point:** The temperature at which moisture in the air will condense out on to a solid surface. See ISO 8502-4.
- 3.5 flash rusting:** Slight rust formation on a prepared steel surface soon after preparation.
- 3.6 grit:** Particles that are predominantly angular, that have fractured faces and sharp edges and that are less than half-round in shape. [ISO 11124-1; ISO 11126-1]