

**Automaatmeetodil joatöötusega puhastatud ja
kokkumonteerituna automaatmeetodil krunditud
konstruktsiooniterasest tooted**

Automatically blast-cleaned and automatically prefabrication
primed structural steel products

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN 10238:2009 sisaldab Euroopa standardi EN 10238:2009 ingliskeelset teksti.

Standard on kinnitatud Eesti Standardikeskuse 30.09.2009 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.

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English Version

**Automatically blast-cleaned and automatically prefabrication
primed structural steel products**

Éléments métalliques préfabriqués automatiquement et
décapés automatiquement par projection d'abrasif

Automatisch gestrahlte und automatisch
fertigungsbeschichtete Erzeugnisse aus Baustählen

This European Standard was approved by CEN on 12 June 2009.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

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Foreword

This document (EN 10238:2009) has been prepared by Technical Committee ECISS/TC 10 “Structural steels - Qualities”, the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by January 2010, and conflicting national standards shall be withdrawn at the latest by January 2010.

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1 Scope

This European Standard specifies requirements for automatically blast-cleaned and automatically prefabrication primed structural steel products.

This European Standard does not cover manual blast cleaning and/or manual spray painting.

NOTE Where the steel is less than 5 mm thick, care should be exercised to ensure it is not deformed by blast cleaning.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 10021, *General technical delivery conditions for steel products*

EN 10025-2, *Hot rolled products of structural steels - Part 2: Technical delivery conditions for non-alloy structural steels*

EN 10025-3, *Hot rolled products of structural steels - Part 3: Technical delivery conditions for normalized/normalized rolled weldable fine grain structural steels*

EN 10204, *Metallic products – Types of inspection documents*

EN ISO 2808:2007, *Paints and varnishes – Determination of film thickness (ISO 2808:2007)*

EN ISO 8501-1, *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 of steel substrates after overall removal of previous coatings (ISO 8501-1:2007)*

EN ISO 8503-2, *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 8503-2:1998)*

EN ISO 17652-1:2003, *Welding – Test for shop primers in relation to welding and allied processes – Part 1: General requirements (ISO 17652-1:2003)*

EN ISO 17652-2:2003, *Welding – Test for shop primers in relation to welding and allied processes – Part 2: Welding properties of shop primers (ISO 17652-2:2003)*

EN ISO 17652-3:2003, *Welding – Test for shop primers in relation to welding and allied processes – Part 3: Thermal cutting (ISO 17652-3:2003)*

EN ISO 17652-4:2003, *Welding – Test for shop primers in relation to welding and allied processes – Part 4: Emission of fumes and gases (ISO 17652-4:2003)*

3 Definitions

For the purposes of this document, the following definitions apply: