

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 11124-3:2018)

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN ISO 11124-3:2018 sisaldab Euroopa standardi EN ISO 11124-3:2018 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 11124-3:2018 consists of the English text of the European standard EN ISO 11124-3:2018.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation.
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Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

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English Version

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 11124-3:2018)

Préparation des subjectiles d'acier avant application de
peintures et de produits assimilés - Spécifications pour
abrasifs métalliques destinés à la préparation par
projection - Partie 3: Grenaille ronde et angulaire en
acier coulé à haut carbone (ISO 11124-3:2018)

Vorbereitung von Stahloberflächen vor dem Auftragen
von Beschichtungsstoffen - Anforderungen an
metallische Strahlmittel - Teil 3: Stahlguss mit hohem
Kohlenstoffgehalt, kugelig und kantig (Shot und Grit)
(ISO 11124-3:2018)

This European Standard was approved by CEN on 12 August 2018.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

European foreword

This document (EN ISO 11124-3:2018) has been prepared by Technical Committee ISO/TC 35 "Paints and varnishes" in collaboration with Technical Committee CEN/TC 139 "Paints and varnishes" 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of an identical text or by endorsement, at the latest by April 2019, and conflicting national standards shall be withdrawn at the latest by April 2019.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 11124-3:1997.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 11124-3:2018 has been approved by CEN as EN ISO 11124-3:2018 without any modification.

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 35, *Paints and varnishes*, Subcommittee SC 12, *Preparation of steel substrates before application of paints and related products*.

This second edition cancels and replaces the first edition (ISO 11124-3:1993), which has been technically revised.

The main changes compared to the previous edition are as follows:

— [Clause 7](#), [Tables 1, 2, 3](#) and [Annex A](#) have been technically revised.

A list of all parts in the ISO 11124 series can be found on the ISO website.

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

WARNING — Equipment, materials and abrasives used for surface preparation can be hazardous. It is important to ensure that adequate instructions are given and that all required precautions are exercised.

1 Scope

This document specifies requirements for 14 grades of high-carbon cast-steel shot and 11 grades of high-carbon cast-steel grit, as supplied for blast-cleaning processes. Values are specified for hardness, density, defect/structural requirements and chemical composition.

The requirements specified in this document apply to abrasives supplied in the "new" condition only. They do not apply to abrasives either during or after use.

Test methods for metallic blast-cleaning abrasives are given in the various parts of ISO 11125.

High-carbon cast-steel shot and grit are used in both static and site blasting equipment. They are most often selected where a facility exists for the recovery and re-use of the abrasive.

NOTE 1 Information on commonly referenced national standards for metallic abrasives and their approximate relationship with ISO 11124 is given in [Annex A](#).

NOTE 2 Although this document has been developed specifically to meet requirements for preparation of steelwork, the properties specified will generally be appropriate for use when preparing other material surfaces, or components, using blast-cleaning techniques. These techniques are described in ISO 8504-2.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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.

ISO 439, *Steel and iron — Determination of total silicon content — Gravimetric method*

ISO 629, *Steel and cast iron — Determination of manganese content — Spectrophotometric method*

ISO 4935, *Steel and iron — Determination of sulfur content — Infrared absorption method after combustion in an induction furnace*

ISO 9556, *Steel and iron — Determination of total carbon content — Infrared absorption method after combustion in an induction furnace*

ISO 10714, *Steel and iron — Determination of phosphorus content — Phosphovanadomolybdate spectrophotometric method*

ISO 11125-1, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 1: Sampling*

ISO 11125-2, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 2: Determination of particle size distribution*

ISO 11125-3, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 3: Determination of hardness*

ISO 11125-4, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 4: Determination of apparent density*

ISO 11125-5, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 5: Determination of percentage defective particles and of microstructure*

ISO 11125-6, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 6: Determination of foreign matter*

ISO 11125-7, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 7: Determination of moisture*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

3.1
high-carbon cast-steel shot
metallic blast-cleaning abrasive produced by a casting process in which molten high-carbon steel is formed into *shot* (3.3) by means of an atomization process

3.2
high-carbon cast-steel grit
metallic blast-cleaning abrasive obtained by crushing various *high-carbon cast-steel shot* (3.1) sizes into sharp-edged angular particles

3.3
shot
particles that are predominantly round, that have a length of less than twice the maximum particle width and that do not have edges, broken faces or other sharp surface defects

3.4
grit
particles that are predominantly angular, that have fractured faces and sharp edges and that are less than half round in shape

3.5
defect
fault or weakness in an abrasive which, if present at or above a given level, can be detrimental to the performance characteristics of the abrasive

Note 1 to entry: See [Table 3](#).

3.5.1
void
smooth-surfaced internal cavity considered undesirable when greater than 10 % of the cross-sectional area of a particle