

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

Automatically blast-cleaned and automatically  
prefabrication primed structural steel products

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN 10238:1999 sisaldab Euroopa standardi EN 10238:1996 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 23.11.1999 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN 10238:1999 consists of the English text of the European standard EN 10238:1996.</p> <p>This document is endorsed on 23.11.1999 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> See Euroopa standard määrab kindlaks nõuded automaatmeetodil joatöölusega puhastatud ja kokkumonteerituna automaatmeetodil krunditud konstruktsiooniterasest toodete kohta.</p>	<p><b>Scope:</b></p>
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**ICS 77.140.01**

**Võtmesõnad:** ettevalmistusaste, info, joameetodil kuulikestega puhastatud värvitud toote, karakteristikud, keevitamine, kokkumonteeritud osade krundid, markeerimine, paksus, raud- ja terastooted, säilitamine, terased, tähistus, valmistamine

**Hinnagrupp F**

ICS 77.140.10

Descriptors: Steel, blast-cleaning, products.

**English version**

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

Produits en aciers de construction  
grenillés et prépeints par traitement  
automatique

Automatisch gestrahlte und automatisch  
fertigungsbeschichtete Erzeugnisse aus  
Baustählen

This European Standard was approved by CEN on 1996-03-19.

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 Central Secretariat 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 Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

**CEN**

European Committee for Standardization  
Comité Européen de Normalisation  
Europäisches Komitee für Normung

**Central Secretariat: rue de Stassart 36, B-1050 Brussels**

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## Foreword

This European Standard has been prepared by Technical Committee ECISS/TC 10 "Structural steels - Qualities", the secretariat of which is held by NNI.

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 March 1997, and conflicting national standards shall be withdrawn at the latest by March 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, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and the United Kingdom .

## 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

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

EN 10021	Iron and steel products - General technical delivery conditions
EN 10025	Hot-rolled products of non alloy structural steels - Technical delivery conditions
EN 10113-2	Hot-rolled products in weldable fine grain structural steels - Delivery conditions for normalized/normalized rolled steels
EN 10204	Metallic products - Types of inspection documents
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 2808	Paints and varnishes - Determination of film thickness
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

## 3 Definitions

For the purposes of this European Standard, the following definitions apply :

### 3.1 automatic blast cleaning

The use of mechanical plant where the product being blast cleaned is passed through a machine where turbines are used to project the abrasive onto the steel in a uniform manner.