

Preparation of steel substrates before application of paints and related products - Specifications for metallic blast-cleaning abrasives - Part 2: Chilled-iron grit (ISO 11124-2:2018, Corrected version 2018-12)

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN ISO 11124-2:2018 sisaldab Euroopa standardi EN ISO 11124-2:2018 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 11124-2:2018 consists of the English text of the European standard EN ISO 11124-2:2018.
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.
Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 26.09.2018.	Date of Availability of the European standard is 26.09.2018.
Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

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EUROPEAN STANDARD

EN ISO 11124-2

NORME EUROPÉENNE

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Supersedes EN ISO 11124-2:1997

English Version

Preparation of steel substrates before application of paints
and related products - Specifications for metallic blast-
cleaning abrasives - Part 2: Chilled-iron grit (ISO 11124-
2:2018, Corrected version 2018-12)

Préparation des subjectiles d'acier avant application de
peintures et de produits assimilés - Spécifications pour
abrasifs métalliques destinés à la préparation par
projection - Partie 2: Grenaille angulaire en fonte
trempée (ISO 11124-2:2018, Version corrigée 2018-
12)

Vorbereitung von Stahloberflächen vor dem Auftragen
von Beschichtungsstoffen - Anforderungen an
metallische Strahlmittel - Teil 2: Hartguss, kantig (Grit)
(ISO 11124-2:2018)

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

This European Standard was corrected and reissued by the CEN-CENELEC Management Centre on 19 December 2018.

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-CENELEC Management Centre or to any CEN member.

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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 11124-2:2018) 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 March 2019, and conflicting national standards shall be withdrawn at the latest by March 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 11124-2:1997.

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 11124-2:2018, Corrected version 2018-12 has been approved by CEN as EN ISO 11124-2:2018 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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Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

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 11124-2:1993), which has been technically revised.

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

- Annex A and Bibliography have been removed.

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

This corrected version of ISO 11124-2:2018 incorporates the following correction:

- Missing values in cells of Table 1 have been reinserted.

Preparation of steel substrates before application of paints and related products — Specifications for metallic blast-cleaning abrasives —

Part 2: Chilled-iron 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 12 grades of chilled-iron grit abrasives, as supplied for blast-cleaning processes. It specifies ranges of particle sizes, together with corresponding grade designations. 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.

Chilled-iron grit abrasives are used in both static and site blasting equipment. They are most often selected where a facility exists for recovery and re-use of the abrasive.

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

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 chilled-iron shot

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

3.2 chilled-iron grit

metallic blast-cleaning abrasive obtained by crushing various *chilled-iron 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, may be detrimental to the performance of the abrasive

Note 1 to entry: See [Table 2](#).

3.5.1 void

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

3.5.2 shrinkage defect

internal cavity with a rough dendritic surface or a zone of microporosity, considered undesirable when greater than 40 % of the cross-sectional area of a particle

3.5.3 crack

linear discontinuity that has a length-to-width ratio of 3:1 or greater, that extends over more than 20 % of the diameter or shortest dimension of a particle and that is radial in direction