

Rusted steel and the blast cleaning

Steel rings used for joints manufacture have to be coated by an epoxy resin suitable for drink water , therefore they must be cleaned by blasting process to grade Sa2,5 for the spigot and Sa3 for the socket.

Steel rusting grades are defined by comparison with following parameters (A, B, C e D : stated by the Swedish Corrosion Institute).

A : steel surface completely coated by mill scale

B : steel surface coated (80%) by mill scale and the rest (20%) by rust (i.e. steel exposed to all weather for 4-6 months)

C : steel surface hardly covered with mill scale and rust (rust more than mill scale : steel exposed to all weather for 1 year)

D : steel surface completely rusted and containing evident pit of corrosion (steel exposed to all weather for at least 2 years)

For each of said parameters are possible different grades of preparation (blasting) :

A : Sa2,5 ; Sa3

B : Sa1 ; Sa2 ; Sa2,5 ; Sa3

C : Sa1 ; Sa2 ; Sa2,5 ; Sa3

D : Sa1 ; Sa2 ; Sa2,5 ; Sa3

Cleaning grades are so defined :

Sa3 : white metal blast cleaning

Sa2,5 : near white metal blast cleaning

Sa2 : commercial blast cleaning

Sa1 : rough blast cleaning or brush cleaning