

INTERNATIONAL
STANDARD

ISO
11124-4

First edition
1993-12-15

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

Part 4:
Low-carbon cast-steel shot

*Préparation des subjectiles d'acier avant application de peintures et de
produits assimilés — Spécifications pour abrasifs métalliques destinés à
la préparation par projection —*

Partie 4: Grenaille ronde en acier moulé à bas carbone



Reference number
ISO 11124-4:1993(E)

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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 11124-4 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*.

ISO 11124 consists of the following parts, under the general title *Preparation of steel substrates before application of paints and related products — Specifications for metallic blast-cleaning abrasives*:

- Part 1: *General introduction and classification*
- Part 2: *Chilled-iron grit*
- Part 3: *High-carbon cast-steel shot and grit*
- Part 4: *Low-carbon cast-steel shot*
- Part 5: *Cut steel wire*

At the time of publication of this part of ISO 11124, part 5 was in course of preparation.

Annexes A and B of this part of ISO 11124 are for information only.

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

Part 4:

Low-carbon cast-steel shot

WARNING — Equipment, materials and abrasives used for surface preparation can be hazardous if used carelessly. Many national regulations exist for those materials and abrasives that are considered to be hazardous during or after use (waste management), such as free silica or carcinogenic or toxic substances. These regulations are therefore to be observed. It is important to ensure that adequate instructions are given and that all required precautions are exercised.

1 Scope

This part of ISO 11124 specifies requirements for 12 grades of low-carbon cast-steel shot abrasive, as supplied for blast-cleaning processes. Values are specified for hardness, density, defect/structural requirements and chemical composition.

The requirements specified in this part of ISO 11124 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.

Low-carbon cast-steel shot 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.

NOTES

1 Information on commonly referenced national standards for metallic abrasives and their approximate relationship with ISO 11124 is given in annexes A and B.

2 Although this part of ISO 11124 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 8504-2:1992, *Preparation of steel substrates before application of paints and related products — Surface preparation methods — Part 2: Abrasive blast-cleaning*.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 11124. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 11124 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 439:1982, *Steel and cast iron — Determination of total silicon — Gravimetric method*.

ISO 629:1982, *Steel and cast iron — Determination of manganese content — Spectrophotometric method*.