GUIDANCE

Surface Preparation Guidelines

Proper surface preparation is critical to ensuring long-term coating adhesion, optimal performance, and durability of the protective system. Below are detailed recommendations to guide this process.

STANDARDS RECOMMENDED

- SSPC-SP 10 / NACE No. 2 (Near-White Metal Blast Cleaning).
- ISO 8501-1:1988 (E) / SIS 05 59 00, Grade Sa 2½ (Visual assessment of surface cleanliness, Grade Sa 2½).

ALTERNATIVE

- SSPC-SP 11, Power Tool Cleaning to Bare Metal, for smaller areas or when abrasive blasting is impractical.

PROCEDURE

1. **Cleaning and Detailing**

   All surfaces, including cut-outs, rat holes, and welds, must be thoroughly cleaned and degreased.

   Welds should be ground to a minimum radius of 2 mm, and all weld spatter must be removed.

2. **Pre-Blasting Treatment**

   Burned areas, weld seams, and rusty surfaces must be cleaned by abrasive blasting to a minimum of ISO Sa 2½, or alternatively, cleaned with power tools to SSPC-SP 3 standard.

3. **Surface Profile**

   Achieve a surface roughness with an angular profile of 75 to 100 microns, in accordance with ISO 8503 Parts 1 and 2.

4. **Abrasive Blasting**

   Surfaces should be abrasive blasted to a near-white metal finish (Sa 2½ / SP10) or, preferably, white metal (Sa 3 / SP5).

   All abrasive residues must be thoroughly removed after blasting.

5. **Visual Inspection**

   The cleanliness of the blasted surface should be verified by visual inspection.

6. **Soluble Salt Test**

   Use a Bresle Sampler (ISO 8502-6) to measure the concentration of soluble salts (chlorides).

   Maximum acceptable level: < 20 mg/m².

7. **Dew Point Control**

   Ensure a minimum of 3°C difference between the surface temperature and the dew point during the entire application process.

8. **Final Cleaning**

   Brush off any loose contamination.

   Degrease using Item 903 Bio Cleaner or an effective residue-free cleaner such as methyl ethyl ketone (MEK).

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