

Abrasive Blasting Service and Supplies Pty Ltd Compressed Air Requirements & Abrasive Consumption							
Nozzle Orifice	Pressure At The Blast Nozzle (psi)						Air, Power and Abrasive Requirements
	60	70	80	90	100	125	
No.2 1/8"	13	15	17	18.5	20	25	Air (CFM)
	77	88	101	112	123	152	Abrasive (lb/hr)
	3	3.5	4	4.5	5	5.5	Compressor (hp)
No.3 3/16"	30	33	38	41	45	55	Air (CFM)
	171	196	226	238	264	319	Abrasive (lb/hr)
	7	8	9	10	10	12	Compressor (hp)
No.4 1/4"	54	61	68	74	81	98	Air (CFM)
	312	354	408	448	494	608	Abrasive (lb/hr)
	12	14	16	17	18	22	Compressor (hp)
No.5 5/16"	89	101	113	126	137	168	Air (CFM)
	534	604	672	740	812	982	Abrasive (lb/hr)
	30	23	26	28	31	37	Compressor (hp)
No.6 3/4"	126	143	161	173	196	237	Air (CFM)
	764	864	960	1052	1152	1393	Abrasive (lb/hr)
	28	32	36	39	44	52	Compressor (hp)
No.7 7/16"	170	194	217	240	254	314	Air (CFM)
	1032	1176	1312	1448	1584	1931	Abrasive (lb/hr)
	38	44	49	54	57	69	Compressor (hp)
No.8 1/2"	224	252	280	309	338	409	Air (CFM)
	1396	1512	1680	1856	2024	2459	Abrasive (lb/hr)
	50	56	63	69	75	90	Compressor (hp)

Disclaimer: The figures stated are for reference only and may vary under different working conditions in Abrasive Blasting. Consumption rates are based on Abrasive weighing 100 pounds per cubic foot.

# ABSS Visual Comparator Guide

## Degrees of Cleanliness

### Abrasive Blasted Steel Substrates

	Unblasted	Class SA-1	Class SA-2	Class SA-2 1/2	Class SA-3
<b>Rust Grade A</b>		No photo supplied. <small>The effort required to remove mill scale on Grade A steel typically results in less staining than the maximum 33% allowed for.</small>			
<b>Rust Grade B</b>					
<b>Rust Grade C</b>					
<b>Rust Grade D</b>					

**Rust Grade A**  
Steel surface completely covered with adherent mill scale. Little or no rust.

**Rust Grade B**  
Steel surface covered with both mill scale and rust.

**Rust Grade C**  
Steel surface completely covered with rust. Little or no pitting is visible.

**Rust Grade D**  
Steel surface completely covered with rust. Pitting is visible.

**Brush Off**  
Blast Cleaning of all except tightly adhering residues of mill scale, rust and coatings, while uniformly roughening the surface.  
Reference AS1627.4 Class 1, NACE 4, SSPC-SP7 Swedish Standard (St, Sa) 1

**Commercial**  
Blast Cleaning until at least 66% of the surface is free of all visible residues with only staining permitted on the remaining 33%. For conditions where a thoroughly cleaned surface is required.  
Reference AS1627.4 Class 2, NACE 3, SSPC-SP6 Swedish Standard (St, Sa) 2

**Near White Blast**  
Blast Cleaning nearly to White Metal cleanliness, until at least 95% of the surface is free of all visible residues with only staining permitted on the remainder. For High humidity, chemical atmospheres, marine and corrosive environments.  
Reference AS1627.4 Class 2-1/2, NACE 2, SSPC-SP10 Swedish Standard (St, Sa) 2-1/2

**White Blast**  
Removal of all visible rust, mill scale, paint and foreign matter by Blast Cleaning by wheel or nozzle (dry or wet) using Garnet, Grit or Shot. For very corrosive atmospheres where high cost of cleaning is warranted.  
Reference AS1627.4 Class 3, NACE 1, SSPC-SP5 Swedish Standard (St, Sa) 3

**Disclaimer:**  
The information on this ABSS Surface Preparation Chart is to be used as a guide only. This must not be used as a replacement to any Surface Preparation Standards. It is the responsibility of the user and/or reader to accurately determine the required Surface Preparation requirements by other means. Reference Australian Standards AS1627.4 NACE, SSPC and Swedish Standard (St, Sa)



**Abrasive Blasting Service & Supplies Pty Ltd**  
**www.abss.net.au Phone: 1300 727 240**



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